



BLIND BOLT ASSEMBLY		BB301 CORE BOLT								BB501 SLEEVE								BB341 EXPANDER				SUGGESTED HOLE PREPARATION		PROTRUSION AFTER INSTALLATION	
FIRST DASH NUMBER	NOMINAL DIAMETER	FIRST DASH NUMBER	RECESS	A DIA.	D DIA.	H	P <sub>1</sub>	T (REF)	THREAD	FIRST DASH NUMBER	A <sub>1</sub> DIA.	B GRIP RANGE 0-¾	B GRIP RANGE 1 1/16-1 1/8			D <sub>1</sub> DIA.	H <sub>1</sub>	DASH NUMBER	D <sub>2</sub> DIA.	L (LENGTH)	THREAD	HOLE DIA.	CORE BOLT INSTALLATION TORQUE	P <sub>1</sub>	D <sub>1</sub> DIA. (REF)
-5	5/32	-5	Phillips #1	.2274 .2226	.1120 .1100	.048 .046	.208	.274	4-40UNJC-3A	-5	.2844 .2794	.210	.225			.169 .166	.0488 .0467	-5	.167	.153	4-40UNJC-3B	.173 .170	8 10 IN. LBS.	.208	.210
-6	3/16	-6	Phillips #1	.2514 .2466	.1240 .1220	.053 .051	.239	.304	5-40UNJC-3A	-6	.3536 .3486	.250	.265			.196 .193	.066 .064	-6	.194	.184	5-40UNJC-3B	.201 .197	10 14 IN. LBS.	.239	.253
-8	1/4	-8	Phillips #2	.3304 .3256	.1650 .1630	.069 .067	.316	.397	8-32UNJC-3A	-8	.4732 .4682	.315	.330			.257 .254	.094 .089	-8	.255	.245	8-32UNJC-3B	.264 .258	20 30 IN. LBS.	.316	.335
-10	5/16	-10	Hi-Torque #3	.4454 .4406	.2180 .2160	.095 .093	.414	.498	12-28UNJF-3A	-10	.5619 .5569	.380	.400			.338 .335	.098 .093	-10	.328	.307	12-28UNJF-3B	.345 .339	50 80 IN. LBS.	.414	.438

#### BB301 CORE BOLT

**GENERAL NOTES:**

1. Concentricity: Head to "D" diameter within .005 FIR.
2. Complete threads shall begin within two thread pitches maximum. Two thread pitch maximum may consist of incomplete thread and extrusion angle.
3. Curved or flat edge manufacturer's option.

**MATERIAL:** Type 431 corrosion-resisting steel per Spec. AMS5628.

**HEAT TREAT:** 125,000 psi shear minimum.

**CODE:** First dash number of core bolt indicates sleeve nominal diameter in 32nds.

Second dash number indicates mean assembly grip length (thickness of work) in 16ths.

**EXAMPLE:** BB301-5-12 = 4-40 core bolt for 5/32 nominal diameter sleeve, 3/4 mean assembly grip length.

#### BB501 SLEEVE

**GENERAL NOTES:**

1. Concentricity: Hole to "D1" diameter within .005 FIR.
2. Curved or flat edge manufacturer's option.

**MATERIAL:** Type 305 corrosion-resisting steel per QQ-S-763.

**HEAT TREAT:** Annealed.

**CODE:** First dash number indicates nominal diameter of sleeve in 32nds.

Second dash number indicates mean assembly grip length (thickness of work) in 16ths.

**EXAMPLE:** BB501-5-12 = Sleeve, 5/32 nominal diameter, 3/4 mean assembly grip length.

#### BB341 EXPANDER

**GENERAL NOTES:**

1. Threads per MIL-S-8879.

**MATERIAL:** Type 431 corrosion-resisting steel per Spec. AMS5628.

**HEAT TREAT:** 125,000 psi shear minimum.

**FINISH:** Cadmium plate per QQ-P-416, Type I, Class 2, and cetyl alcohol lube.

**CODE:** Dash number indicates diameter of Blind Bolt Assembly in 32nds.

**EXAMPLE:** BB341-5 = 4-40 expander for 5/32 nominal diameter Blind Bolt assembly.

#### BB382 BOLT ASSEMBLY

**CODE:** First dash number indicates nominal diameter of Blind Bolt assembly in 32nds.

Second dash number indicates mean assembly grip length (thickness of work) in 16ths.

**EXAMPLE:** BB382-5-12

3/4 Mean Assembly Grip Length  
5/32 Nominal Diameter Blind Bolt Assembly  
Blind Bolt Assembly which includes:  
BB301 Core Bolt, BB501 Sleeve, and BB341 Expander

① Editorially Updated

U.S. Patent 2,959,999. Foreign patents issued. Hi-Torque® trademark.

TITLE					
BLIND BOLT™ ASSEMBLY					
100° COUNTERSUNK AN426 HEAD STYLE					
DRAWN	DATE	APPROVED	DATE	REVISION	DATE
R. K. L.	4-4-61	MMS	4-4-61	③	12-13-74
Shrode					BB382

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