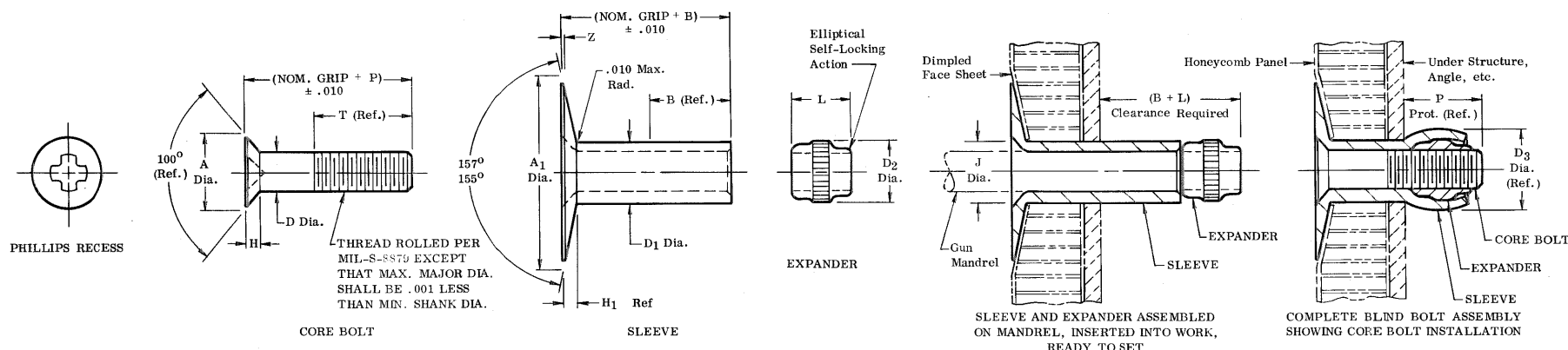




2600 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90509
AREA CODE 213 • 775-3181 • 326-6110



BLIND BOLT ASSEMBLY		① BB422 CORE BOLT								BB438 SLEEVE								① BB415G and BB415GA EXPANDER				SUGGESTED HOLE PREPARATION		PROTRUSION AFTER INSTALLATION		INSTALLATION PRESSURE (psi)		MECH. PROPERTIES OF ASSEMBLY LBS. MIN.	
FIRST DASH NUMBER	NOMINAL DIAMETER	FIRST DASH NUMBER	RECESS	A DIA.	D DIA.	H	T (REF)	THREAD	FIRST DASH NUMBER	A ₁ DIA.	B GRIP RANGE 0-3/4	B GRIP RANGE 3/4-1 1/2	B GRIP RANGE 1 1/2-1 3/4	D ₁ DIA.	H ₁	Z	DASH NUMBER	D ₂ DIA.	L (LENGTH)	THREAD	J HOLE DIA.	CORE BOLT INSTALLATION TORQUE	P	D ₂ DIA. (REF)	BG1750	BG2500	DOUBLE SHEAR		
-5	5/32	-5	Phillips	.1879 .1831	.1120 .1100	.032 .029		.274	4-40UNJC-3A	-5	.530 .510	.210	.225	—	.1645 .1640	.038 .005	.009	-5	.162	.153	4-40UNJC-3B	.168 .164	8 10 IN. LBS.	.208	.210			4,000	
-6	3/16	-6	Phillips	.2289 .2241	.1240 .1220	.045 .042		.304	5-40UNJC-3A	-6	.620 .600	.250	.265	.330	.1990 .1895	.044 .005	.009	-6	.194	.184	5-40UNJC-3B	.194 .190	10 14 IN. LBS.	.239	.253			5,500	
-8	1/4	-8	Phillips	.2922 .2874	.1650 .1630	.054 .051		.397	8-32UNJC-3A	-8	.805 .785	.315	.330	.370	.2600 .2595	.010 .005	.010	-8	.255	.245	8-32UNJC-3B	.254 .250	20 30 IN. LBS.	.316	.335		700	9,500	

BB422 CORE BOLT

GENERAL NOTES:

- Concentricity: Head to "D" diameter within .005 TIR.
- Complete threads shall begin within two thread pitches maximum. Two thread pitch maximum may consist of incomplete thread and extrusion angle.
- "H" is dimensioned from maximum "D" diameter.

MATERIAL: A-286 high temperature alloy per AMS5731 or AMS5737.

HEAT TREAT: 95,000 psi shear minimum at room temperature.

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: BB422-6-12 = 3/16 nominal sleeve diameter, 3/4 mean assembly grip length.

BB438 SLEEVE

GENERAL NOTES:

- Concentricity: Hole to "D₁" diameter within .005 TIR. "D₁" diameter to head within .005 TIR.
- "H₁" is dimensioned from maximum "D₁" diameter.

① MATERIAL: Type A-286 per AMS5731 and AMS5737.

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: BB438-6-12 = 3/16 nominal sleeve diameter, 3/4 mean assembly grip length.

① BB415G and BB415GA EXPANDER

GENERAL NOTES:

- Threads per MIL-S-8879.

MATERIAL: A-286 stainless steel per Spec. AMS5731.

HEAT TREAT: 110,000 psi shear minimum.

① FINISH: BB415G = Silver plate per AMS2410.
BB415GA = Silver plate per AMS2411.

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

① EXAMPLE: BB415G-6 = 3/16 nominal diameter Blind Bolt Assembly.

BB441 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.

① EXAMPLE: BB441-6-12

- 3/4 Mean Assembly Grip Length
- 3/16 Nominal Diameter Blind Bolt Assembly
- Blind Bolt Assembly which includes: BB422 Core Bolt, BB438 Sleeve, and BB415G EXPANDER

BB441GA-6-12 = AS EXAMPLE EXCEPT WITH EXPANDER BB415GA

U.S. Patent 2,959,999. Foreign patents issued and pending.

BLIND BOLT™ ASSEMBLY					
156° COUNTERSUNK 3.5D SHEAR HEAD					
A-286 ALLOY					
HONEYCOMB APPLICATION					
DRAWN	DATE	APPROVED	DATE	REVISION	DRAWING NUMBER
Shirley T. 7-28-71	7-28-71	Shirley T. 7-28-71	7-28-71	①	BB441