



BLIND BOLT ASSEMBLY			BB170 CORE BOLT							BB335 SLEEVE							BB567 EXPANDER					SUGGESTED HOLE PREPARATION		PROTECTION AFTER INSTALLATION	
FIRST DASH NUMBER	NOMINAL DIAMETER	FIRST DASH NUMBER	RECESS	A DIA.	D DIA.	H	P ₁	T (REF)	THREAD	FIRST DASH NUMBER	A ₁ DIA.	B GRIP RANGE 0-1/4	B GRIP RANGE 1/4-1/2	B GRIP RANGE 1/2-3/4	D ₁ DIA.	N ₁	DASH NUMBER	D ₂ DIA.	L (LENGTH)	THREAD	HOLE DIA.	J CORE BOLT INSTALLATION TORQUE	P ₁	D ₂ DIA. (REF)	

BB170 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. "H" is dimensioned from maximum "D" diameter.
 4. Curved or flat edge manufacturer's option.

MATERIAL: PH13-8Mo stainless steel per AMS5623.
HEAT TREAT: 125,000 psi shear minimum.

FINISH: Passivate.

CODE: First dash number of core bolt indicates sleeve nominal diameter in 32nds.
Second dash number indicates grip length (thickness of work) in 16ths.

EXAMPLE: BB170-18-12 = 7/16-20 core bolt for 9/16 nominal diameter sleeve, 3/4 grip length.

BB335 SLEEVE

- GENERAL NOTES:**
1. Concentricity: Hole to "D₁" diameter within .005 FIR.
 2. Head to "D₁" diameter within .005 FIR.

MATERIAL: A-286 alloy.
HEAT TREAT: Anneal.

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: BB335-18-12 = Sleeve, 9/16 nominal diameter, 3/4 mean assembly grip length.

BB567 EXPANDER

- NOTE:** Threads per MIL-S-8879.
MATERIAL: PH13-8Mo stainless steel per AMS5623.
HEAT TREAT: 125,000 psi shear minimum.
FINISH: Dry film lube per MIL-L-5837 (1,000-2,000 thick), and cast/ alcohol lube per HI-Shear Spec. 305.
CODE: Dash number indicates nominal diameter of bolt used in assembly.
EXAMPLE: BB567-18 = Expander for use with 9/16 nominal diameter Blind Bolt assembly.

BB567 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: BB567-18-12 = 3/4 Mean Assembly Grip Length
9/16 Nominal Diameter Blind Bolt Assembly
Blind Bolt Assembly which includes: BB170
Core Bolt, BB335 Sleeve, and BB567 Expander

TITLE BLIND BOLT™ ASSEMBLY 100° COUNTERSUNK AN509 HEAD STYLE A-286 ALLOY			
DRAWN D. P. S.	DATE APPROVED 2-15-84	DATE REVISION 2-16-84	DATE 9-7-88
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