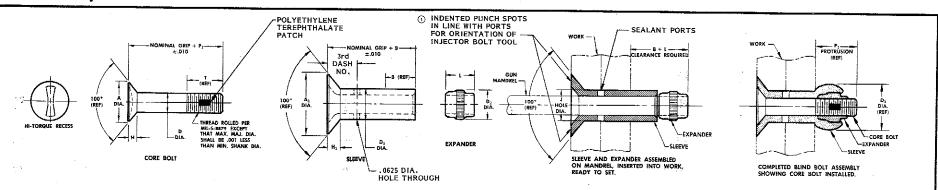


2600 SKYPARK DRIVE TORRANCE. CALIFORNIA 90509 AREA CODE 213 . 775-3181 - 325-8110



BLINE ASSI	BOLT		BB706 CORE BOLT								BB705 SLEEVE								BB459TB EXPANDER				SUGGESTED HOLE PREPARATION		PROTRUSION AFTER	
FIRST DASH NUMBER	NOMINAL DIAMETER	FIRST DASH NUMBER	RECESS	A DIA.	DIA.	н	P ₁	T (REF)	THREAD	PIRST DASH NUMBER	A ₁ DIA.	B GRIP RANGE 0-3/2	B GRIP RANGE 13/10-11/16			D ₁ DIA.	Hz	DASH NUMBER	D ₂ DIA.	L (LENGTH)	THREAD	J HOLE DIA.	CORE BOLT INSTALLATION TORQUE	Pi	D ₃ DIA. (REF)	
-10	5/16	-10	Hi- Torque #3	.4454 .4406	.218 .217	.095 .093	.414	- 498	12-28UNJF-3A	-10	.6335 .6287	.380	. 400			.338	.1240	-10	. 328	.307	12-28UNJF-3B	-340 -338	50 IN. LBS.	.414	. 438	
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BB706 CORE BOLT

GENERAL NOTES: 1.

Concentricity: Head to "D" diameter within .005 TIR.

2. Complete threads shall begin within two thread pitches maximum. Two thread pitch maximum may consist of

incomplete thread and extrusion engle.
"H" is dimensioned from maximum "D" diameter.

Close tolerance diameter core bolt for .002 maximum slip fit with sleeve.

MATERIAL: Type 431 stainless steel per Spec. QQ-S-763.

HEAT TREAT: 125,000 psi shear minimum.

① FINISH: Hi-Kote 2 solid film lube with cetyl alcohol.

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: BB706-10-12 = 12-28 core bolt for 5/16 nominal diameter sleeve, 3/4 mean assembly grip length.

BB 705 SLEEVE

GENERAL NOTES: 1. Concentricity: Hole to "D1" diameter within .005 TIR. "D1" diameter to head within .005 TIR. 2. "H1" is dimensioned from maximum "D1" diameter.

MATERIAL: A-286 CRES per AMS5731.

HEAT TREAT: Aged and zone annealed as required to meet Hi-Shear

Spec. 140, Type I.

① FINISH: Abrasive clean and passivate.

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

number indicates distance measured from top of head to center of port in hundredths of an inch.

EXAMPLE: BB705-10-12-23 = 5/16 nominal diameter sleeve, 3/4 mean assembly grip length, port location .23.

BB459TB EXPANDER

GENERAL NOTES: 1. Threads per MIL-S-8879.

MATERIAL: Type 431 stainless steel per Spec. QQ-S-763.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: Hi-Kote 2 solid film lube with cetyl alcohol. CODE: Dash number indicates diameter of Blind Bolt Assembly

in 32nds.

EXAMPLE: BB459TB-10 = 12-28 Expander for use with 5/16 nominal

diameter Blind Bolt.

BB 704 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. Third dash number indicates port location in hundredths of an inch.

EXAMPLE: <u>BB704-10-12-23</u>

.23 Inch Port Location -3/4 Mean Assembly Grip Length 5/16 Nominal Diameter Blind Bolt Assembly Blind Bolt Assembly which includes: BB706 Core Bolt, BB705 Sleeve and BB459TB Expander

"Blind Bolt" is a trademark of Hi-Shear Corporation.

TITLE

BLIND FOLT T.M. ASSEMBLY 100° COUNTERSUNK AN 509 HEAD STYLE

WITH PATCH THREAD LOCK SEALANT INJECTION APPLICATION

> DRAWING NUMBER **BB704** 11-16-88

D.P.S.

BB704