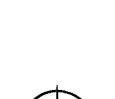
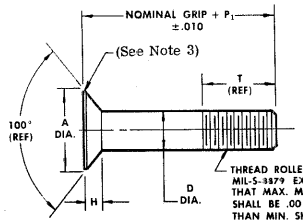
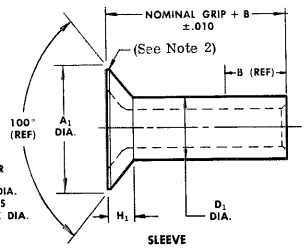
hi-shear CORPORATION
2600 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90509
AREA CODE 213 · 775-3181 · 326-8110

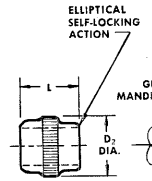




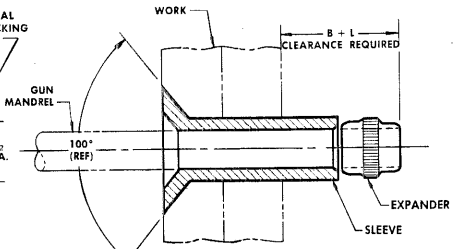
CORE BOLT



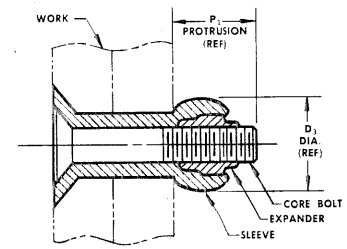
SLEEVE



EXPANDER



SLEEVE AND EXPANDER ASSEMBLED ON MANDREL, INSERTED INTO WORK, READY TO SET.



COMPLETED BLIND BOLT ASSEMBLY SHOWING CORE BOLT INSTALLED.

BLIND BOLT ASSEMBLY		BB311 CORE BOLT								BB335 SLEEVE								BB341G EXPANDER				SUGGESTED HOLE PREPARATION		PROTRUSION 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 0-¾	B GRIP RANGE 13/16-11/16	B GRIP RANGE 1⅛-1⅝		D_1 DIA.	H_1	DASH NUMBER	D_2 DIA.	L (LENGTH)	THREAD	HOLE DIA.	CORE BOLT INSTALLATION TORQUE	P_1	D_3 DIA. (REF)
-5	5/32	-5	Phillips #1	.2274 .2226	.1120 .1100	.048 .046	.208	.274	4-40UNJC-3A	-5	.3310 .3262	.210	.225	—		.169 .166	.068 .066	-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	.3813 .3765	.250	.265	.330		.196 .193	.078 .076	-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	.5066 .5018	.315	.330	.370		.257 .254	.105 .103	-8	.255	.245	8-32UNJC-3B	.264 .258	20 30 IN. LBS.	.316	.335

BB311 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: A-286 alloy
HEAT TREAT: 95,000 psi shear minimum.
FINISH:
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: BB311-6-12 = 5-40 core bolt for 3/16 nominal diameter sleeve, 3/4 mean assembly grip length.

BB335 SLEEVE

GENERAL NOTES:
1. Concentricity: Hole to "D_1" diameter within .005 FIR. Head to "D_1" diameter within .005 FIR.
2. Curved or flat edge manufacturer's option.

MATERIAL: A-286 alloy
HEAT TREAT: Anneal
FINISH:
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: BB335-6-12 = Sleeve, 3/16 nominal diameter, 3/4 mean assembly grip length.

BB341G EXPANDER

GENERAL NOTES: 1. Threads per MIL-S-8879.
MATERIAL: Type 431 corrosion-resistant steel per Spec. AMS5628.
HEAT TREAT: 125,000 psi shear minimum.
FINISH: Silver plate per AMS2410 (.0002-.0004 thick) and wax lubricant.
CODE: Dash number indicates diameter of Blind Bolt assembly in 32nds.
EXAMPLE: BB341G-6 = 5-40 expander for 3/16 nominal diameter Blind Bolt assembly.

BB379 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: BB379-6-12
- 3/4 Mean Assembly Grip Length
- 3/16 Nominal Diameter Blind Bolt Assembly
- Blind Bolt Assembly which includes: BB311 Core Bolt, BB335 Sleeve, and BB341G Expander

② Editorially Updated

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

TITLE				
BLIND BOLT™ ASSEMBLY 100° COUNTERSUNK AN509 HEAD STYLE A-286 ALLOY				
DRAWN / DATE	APPROVED / DATE	REVISION / DATE	DRAWING NUMBER	
D.G.P. 4-4-61	MMd 4-4-61	② Shrode 12-13-74	BB379	

CODE IDENTIFICATION NO. 73197

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BB379

2-1012

LISI AEROSPACE – Please refer to Central Documentation Website to check validity