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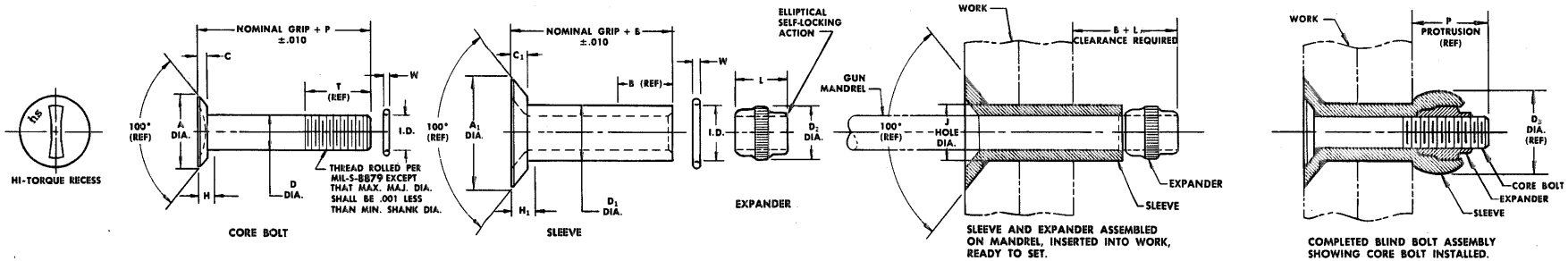
hi-shear CORPORATION
2600 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90509
AREA CODE 213 · 775-3181 · 326-8110



BLIND BOLT ASSEMBLY		BB573 CORE BOLT											BB574 SLEEVE											BB567 EXPANDER				SUGGESTED HOLE PREPARATION		PROTRUSION AFTER INSTALLATION	
										O-RING DATA											O-RING DATA										
FIRST DASH NUMBER	NOMINAL DIAMETER	FIRST DASH NUMBER	RECESS	A DIA.	D DIA.	H	C	T (REF)	THREAD	I.D.	W	PART NUMBER	FIRST DASH NUMBER	A_1 DIA.	B GRIP RANGE 0-¼	B GRIP RANGE 13/16-1 1/16	B GRIP RANGE 1 ⅛-1 ⅝	C_1	D_1 DIA.	H_1	I.D.	W	PART NUMBER	DASH NUMBER	D_2 DIA.	L (LENGTH)	THREAD	J HOLE DIA.	CORE BOLT INSTALLATION TORQUE	P	D_3
-8	1/4	-8	#2	.3304 .3256	.1650 .1630	.069 .067	.0340 .0320	.397	8-32UNJC-3A	.151 .141	.027 .023	425018-5	-8	.5066 .5018	.315	.330	.370	.0695 .0675	.257 .254	.105 .103	.244 .234	.027 .023	425018-8	-8	.255	.245	8-32UNJC-3B	.264 .258	20 30 IN. LBS.	.316	.335
-10	5/16	-10	#3	.4454 .4406	.2180 .2160	.095 .093	.0592 .0572	.498	12-28UNJF-3A	.215 .205	.027 .023	425018-6	-10	.6335 .6287	.380	.400	.420	.0800 .0780	.338 .335	.124 .122	.306 .296	.037 .033	425018-10	-10	.328	.307	12-28UNJF-3B	.345 .339	50 80 IN. LBS.	.414	.438
-12	3/8	-12	#4	.5066 .5018	.2490 .2470	.108 .106	.0723 .0703	.567	1/4- 28UNJF-3A	.244 .234	.027 .023	425018-8	-12	.7604 .7556	.450	.450	.450	.1112 .1092	.390 .387	.155 .153	.369 .359	.037 .033	425018-12	-12	.383	.368	1/4- 28UNJF-3B	.397 .391	125 150 IN. LBS.	.485	.510

BB573 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. O-ring is assembled onto core bolt.
5. See BB572 Bolt Assembly for shortest grip length available.

MATERIAL: Bolt — PH13-8Mo stainless steel per AMS5629.
O-Ring — Fluorsilicone rubber, Type I, Class 1, Grade 70, per MIL-R-25988.

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: BB573-8-12 = 8-32 Core Bolt for 1/4 nominal diameter sleeve, 3/4 mean assembly grip length.

BB567 EXPANDER

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

MATERIAL: PH13-8Mo SST per AMS5629.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: Hi-Kote 2 per Hi-Shear Specification 293.

EXAMPLE: BB567-8 = 8-32 Expander for 1/4 nominal diameter Blind Bolt Assembly.

BB574 SLEEVE

GENERAL NOTES:
1. Concentricity: Hole to "D_1" diameter within .005 FIR. "D_1" diameter to head within .005 FIR.
2. "H_1" is dimensioned from maximum "D_1" diameter.
3. O-ring is assembled onto sleeve.
4. See BB572 Bolt Assembly for shortest grip length available.

MATERIAL: Sleeve — Type 305 stainless steel per QQ-S-763.
O-Ring — Fluorsilicone rubber, Type I, Class 1, Grade 70, per MIL-R-25988.

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: BB574-8-12 = 1/4 nominal diameter sleeve, 3/4 mean assembly grip length.

Assembly Mechanical Properties		
Bolt Assembly	Double Shear Lbs. Min.	Ultimate Tensile Lbs. Min.
①		
BB572-8	8,335	3,920
BB572-10	14,415	6,675
BB572-12	20,400	8,815

BB572 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: BB572-8-12
3/4 Mean Assembly Grip Length
1/4 Nominal Diameter Blind Bolt Assembly
Blind Bolt Assembly which includes:
BB573 Core Bolt, BB574 Sleeve, and BB567 Expander

Shortest grip lengths available are: BB572-8-3
BB572-10-3
BB572-12-4

U.S. Patents 2,959,999; 2,677,985.
Foreign patents issued and pending.
"Hi-Torque" trademark.

TITLE
BLIND BOLT™ ASSEMBLY
SEALING TYPE 100° COUNTERSUNK MS24694 HEAD STYLE

DRAWN	DATE	APPROVED	DATE	REVISION	DATE	DRAWING NUMBER
D. P. S.	4-12-76	Bundelson	4-12-76	①	D. P. S. 5-5-76	BB572

BB572