



| BLIND BOLT ASSEMBLY | | BB316 CORE BOLT | | | | | | | | BB119 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 0-3% | B GRIP RANGE 1 1/16-1 1/8 | B GRIP RANGE 1 1/4-1 1/2 | C | D ₁ DIA. | M ₁ | DASH NUMBER | D ₂ DIA. | L (LENGTH) | THREAD | HOLE DIA. | CORE BOLT INSTALLATION TORQUE | P ₁ | D ₂ DIA. (REF) |
| -5 | 5/32 | -5 | Frearson | .2274 .2226 | .1120 .1100 | .048 .046 | .208 | .274 | 4-40UNJC-3A | -5 | .294 .274 | .210 | — | — | .120 .100 | .169 .166 | .055 .045 | -5 | .167 | .153 | 4-40UNJC-3B | .173 .170 | 8 10 IN. LBS. | .208 | .210 |
| -6 | 3/16 | -6 | Frearson | .2514 .2466 | .1240 .1220 | .053 .051 | .239 | .304 | 5-40UNJC-3A | -6 | .315 .295 | .250 | — | — | .130 .110 | .196 .193 | .065 .055 | -6 | .194 | .184 | 5-40UNJC-3B | .201 .197 | 10 14 IN. LBS. | .239 | .253 |
| -8 | 1/4 | -8 | Frearson | .3304 .3256 | .1650 .1630 | .069 .067 | .316 | .397 | 8-32UNJC-3A | -8 | .412 .387 | .315 | .330 | — | .155 .135 | .257 .254 | .090 .080 | -8 | .255 | .245 | 8-32UNJC-3B | .264 .258 | 20 30 IN. LBS. | .316 | .335 |

BB316 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 angle.
 3. "H" is dimensioned from maximum "D" diameter.

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

HEAT TREAT: 95,000 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: BB316-6-12 = 3/16 nominal sleeve diameter 3/4 mean assembly grip length.

BB119 SLEEVE

- GENERAL NOTES:**
1. Concentricity: Hole to "D" diameter within .005 TIR. "D₁" diameter to head within .010 TIR.

MATERIAL: Type A-286 per AMS5731.

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: BB119-6-12 = 3/16 nominal sleeve diameter, 3/4 mean assembly grip length.

BB341G EXPANDER

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

MATERIAL: Type AISI 431 stainless steel.

HEAT TREAT: 125 ksi shear minimum.

FINISH: Silver plate per QQ-S-365, Grade B, .0002-.0004 thick.

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

EXAMPLE: BB341G-6 = 3/16 nominal diameter Blind Bolt Assembly.

BB120 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: BB120-6-12

- 3/4 Mean Assembly Grip Length
- 3/16 Nominal Diameter Blind Bolt Assembly
- Blind Bolt Assembly which includes: BB316 Core Bolt, BB119 Sleeve, and BB341G Expander

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

| TITLE | | | |
|---|---------|-------------|--------------|
| BLIND BOLT™ ASSEMBLY PROTRUDING HEAD RETAINING STYLE A-286 ALLOY | | | |
| DRAWN | DATE | APPROVED | DATE |
| D.P.S. | 6-23-87 | E.P. Beeles | |
| DRAWING NUMBER | | | |
| | | | BB120 |