



BLIND BOLT ASSEMBLY			BB141 CORE BOLT										BB142 SLEEVE							BB415 EXPANDER				SUGGESTED HOLE PREPARATION		PROTRUSION AFTER INSTALLATION					
FIRST DASH NUMBER	NOMINAL DIAMETER	FIRST DASH NUMBER	RECESS	A DIA.	D DIA.	H	C	T (REF)	THREAD	O-RING DATA			FIRST DASH NUMBER	A ₁ DIA.	B GRIP RANGE 0-3/4	B GRIP RANGE 3/16-1 1/16	B GRIP RANGE 1 1/4-1 1/2	C ₁	D ₂ DIA.	H ₁	O-RING DATA			DASH NUMBER	D ₂ DIA.	L (LENGTH)	THREAD	J HOLE DIA.	CORE BOLT INSTALLATION TORQUE	P	D ₃
										I.D.	W	PART NUMBER									I.D.	W	PART NUMBER								
-8	1/4	-8	HI-Torque #2	.3304 .3256	.1650 .1630	.069 .067	.0340 .0320	.397	8-32UNJC-3A	.151 .141	.027 .023	425005-5	-8	.5066 .5018	.315	.330	.370	.0695 .0675	.257 .254	.105 .103	.244 .234	.027 .023	425005-8	-8	.255	.245	8-32UNJC-3B	.264 .258	20 30 IN. LBS.	.316	.335
-10	5/16	-10	HI-Torque #3	.4454 .4406	.2180 .2160	.095 .093	.0592 .0572	.493	12-28UNJF-3A	.215 .205	.027 .023	425007-6	-10	.6335 .6287	.360	.400	.420	.0800 .0780	.338 .335	.124 .122	.306 .296	.037 .033	425005-10	-10	.328	.307	12-28UNJF-3B	.345 .339	50 80 IN. LBS.	.414	.438
-12	3/8	-12	HI-Torque #4	.5066 .5018	.2490 .2470	.108 .106	.0723 .0703	.567	1/4-28UNJF-3A	.244 .234	.027 .023	425005-8	-12	.7604 .7556	.450	.450	.450	.1112 .1092	.390 .387	.155 .153	.369 .359	.037 .033	425005-12	-12	.383	.368	1/4-28UNJF-3B	.397 .391	125 150 IN. LBS.	.485	.510

BB141 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 BB140 Bolt Assembly for shortest grip length available.

MATERIAL: A-286 per AMS5731.
O-ring: Synthetic rubber per Spec. MIL-R-6855, Grade 60, Class I, II and III (combined).

HEAT TREAT: 95,000 psi shear minimum.
FINISH: Hi-Kote 1 and 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: BB141-8-12 = 8-32 Core Bolt for 1/4 nominal diameter sleeve, 3/4 mean assembly grip length.

BB142 SLEEVE

GENERAL NOTES: 1. Concentricity: Hole to "D₁" diameter within .005 FIR. "D₁" diameter to head within .005 FIR.
2. "H₁" is dimensioned from maximum "D₁" diameter.
3. O-ring is assembled onto sleeve.
4. See BB140 Bolt Assembly for shortest grip length available.

MATERIAL: A-286 per AMS5731.
O-ring: Synthetic rubber per Spec. MIL-R-6855, Grade 60, Class I, II and III (combined).

FINISH: Hi-Kote 1
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: BB142-8-12 = 1/4 nominal diameter sleeve, 3/4 mean assembly grip length.

BB415 EXPANDER

GENERAL NOTES: 1. Threads per MIL-S-8879.
MATERIAL: Type A-286 per AMS5731.
HEAT TREAT: 110,000 psi shear minimum.
FINISH: BB415- () = Solid film tube per MIL-L-8937.
BB415AP- () = Hi-Kote 1 and cetyl alcohol.
CODE: Dash number indicates expander used in assembly.
EXAMPLE: BB415-8 = Expander for 1/4 nominal diameter blind bolt assembly.

BB140 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: BB140-8-12
 3/4 Mean Assembly Grip Length
 1/4 Nominal Diameter Blind Bolt Assembly
 Blind Bolt Assembly which includes:
 BB141 Core Bolt, BB142 Sleeve, and
 BB415 Expander
 BB140AP- () - () = Same as example except with Expander BB415AP.
 Shortest grip lengths available are: BB140-8-3
 -10-3
 -12-4

TITLE			
BLIND BOLT™ ASSEMBLY			
SEALING TYPE 100° COUNTERSUNK AN509 HEAD STYLE A-286 - HI-TORQUE RECESS			
DRAWN	DATE	APPROVED	DATE
D. P. S.	9-11-73	<i>J. Anderson</i>	7-11-73
		REVISION	DATE
		①	10-27-82
D. P. S.			DRAWING NUMBER
			BB140

BB140