



BB306 CORE BOLT										BB333 SLEEVE										BB567 EXPANDER				SUGGESTED HOLE PREPARATION		PROTRUSION AFTER INSTALLATION					
FIRST DASH NUMBER	NOMINAL DIAMETER	FIRST DASH NUMBER	FREARSON RECESS	A DIA.	D DIA.	H	C	T (REF)	THREAD	O-RING DATA			FIRST DASH NUMBER	A1 DIA.	B GRIP RANGE 0-%	B GRIP RANGE 1 1/16-1 1/16	B GRIP RANGE 1 1/8-1 1/8	C1	D1 DIA.	H1	O-RING DATA			DASH NUMBER	D2 DIA.	L (LENGTH)	THREAD	HOLE DIA.	CORE BOLT INSTALLATION TORQUE	P	D3
										I.D.	W	PART NUMBER									I.D.	W	PART NUMBER								
-8	1/4	-8	#6	.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	#8	.4454 .4406	.2180 .2160	.095 .093	.0592 .0572	.498	12-28UNJF-3A	.215 .205	.027 .023	425007-6	-10	.6335 .6287	.380	.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

BB306 CORE BOLT

GENERAL NOTES:

- Concentricity: Head to "D" diameter within .005 TIR.
- Complete threads shall begin within two thread pitches maximum. Two thread pitch maximum may consist of incomplete thread and extrusion angle.
- "H" is dimensioned from maximum "D" diameter.
- O-ring is assembled onto core bolt.
- See BB166 Bolt Assembly for shortest grip length available.

MATERIAL: Type 431 stainless steel per Spec. AMS5628 and MIL-S-18732.
O-ring: Synthetic rubber per Spec. MIL-R-6855, Grade 60, Class I, II and III (combined).

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: BB306-8-12 = 8-32 Core Bolt for 1/4 nominal diameter sleeve, 3/4 mean assembly grip length.

BB333 SLEEVE

GENERAL NOTES:

- Concentricity: Hole to "D1" diameter within .005 FIR. Head to "D1" diameter within .005 FIR.
- "H1" is dimensioned from maximum "D1" diameter.
- O-ring is assembled onto sleeve.
- See BB362 Bolt Assembly for shortest grip length available.

MATERIAL: Type 305 stainless steel per QQ-S-763.
O-ring: Synthetic rubber per Spec. MIL-R-6855, Grade 60, Class I, II and III (combined).

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: BB333-8-12 = 1/4 nominal diameter sleeve, 3/4 mean assembly grip length.

BB567 EXPANDER

NOTE: 1. Threads per MIL-S-8879.

MATERIAL: PH13-8Mo stainless steel per AMS5629.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: Dry film lube per MIL-L-8937 and cetyl alcohol lube per Hi-Shear Spec. 305.

CODE: Dash number indicates Expander used in assembly.

EXAMPLE: BB567-10 = Expander for 12-28 bolt, dry film lube.

BB166 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: BB166-8-12

- 3/4 Mean Assembly Grip Length
- 1/4 Nominal Diameter Blind Bolt Assembly
- Blind Bolt Assembly which includes: BB306 Core Bolt, BB333 Sleeve, and BB567 Expander

Shortest grip lengths available are: BB166-8-3
-10-3

TITLE					
BLIND BOLT™ ASSEMBLY					
SEALING TYPE 100° COUNTERSUNK MS24694 HEAD STYLE					
FREARSON RECESS					
DRAWN	DATE	APPROVED	DATE	REVISION	DATE
D. P. S.	8-30-73	<i>Anderson</i>	8-31-73	2	D. P. S.
					DRAWING NUMBER
					BB166

BB166