



BLIND BOLT ASSEMBLY		BB301 CORE BOLT									BB321.64 SLEEVE						BB341 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 0-3/4	B GRIP RANGE 1 1/16-1 1/8	B GRIP RANGE 1 1/4-1 1/2	B GRIP RANGE 1 7/8-2 1/4	D ₁ DIA.	H ₁	DASH NUMBER	D ₂ DIA.	L (LENGTH)	THREAD	SOLE DIA.	INSTALLATION TORQUE	P ₁	D ₂ DIA. (REF)
-5	5/32	-5	Phillips	.2274 .2226	.1120 .1100	.048 .046	.208	.274	4-40UNC-3A	-5	.3310 .3262	.210	—	—	—	.185 .182	.0630 .0590	-5	.167	.153	4-40UNC-3B	.191 .187	8 10 in. lbs.	.208	.220
-6	3/16	-6	Phillips #1	.2514 .2466	.1240 .1220	.053 .051	.239	.304	5-40UNC-3A	-6	.3813 .3765	.250	—	—	—	.203 .200	.0748 .0728	-6	.194	.184	5-40UNC-3B	.208 .204	10 14 in. lbs.	.239	.255
-8	1/4	-8	Phillips #2	.3304 .3256	.1650 .1630	.069 .067	.316	.397	8-32UNC-3A	-8	.5066 .5018	.315	.330	—	—	.265 .262	.1014 .0994	-8	.255	.245	8-32UNC-3B	.271 .266	20 30 in. lbs.	.316	.338
-10	5/16	-10	Hi-Torque #3	.4454 .4406	.2180 .2160	.095 .093	.414	.498	12-28UNF-3A	-10	.6335 .6287	.380	.400	.420	—	.358 .356	.1150 .1120	-10	.328	.307	12-28UNF-3B	.365 .359	50 80 in. lbs.	.414	.438

BB301 CORE BOLT

- 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. Curved or flat edge manufacturer's option.

MATERIAL: Type 431 stainless steel per Spec. QQ-8-763.

HEAT TREAT 125,000 psi shear minimum.

CODE First dash number of core bolt indicates sleeve nominal diameter in 32nds. Second dash number indicates nominal grip length (thickness of work) in 16ths.

EXAMPLE BB301-8-12 = 8-32 core bolt for 1/4 nominal diameter sleeve, 3/4 nominal grip length

BB321.64 SLEEVE

- NOTES: 1. Concentricity: Hole to "D₁" diameter within .005 FIR; Head to "D₁" diameter within .005 FIR.
2. "H₁" is dimensioned from maximum "D₁" diameter.

MATERIAL: Type CRES: 305 per QQ-8-763, 302 HQ, or 18-9 LW (ASTM A-493).

FINISH: BB321.64 = Passivate.
BB321.64P = Cadmium plate per QQ-P-416, Type I, Class 2.
BB321.64PB = Cadmium plate per QQ-P-416, Type II, Class 2

CODE: First dash number indicates nominal diameter of sleeve in 32nds for which the BB321.64 Sleeve is the 1/64 oversize replacement. Second dash number indicates nominal grip length (thickness of work) in 16ths. Letters "P" or "PB" indicate plating spec.

EXAMPLE: BB321.64-8-12 = 1/4 nominal diameter sleeve, 3/4 nominal grip length.

BB341 EXPANDER

NOTE: Threads per MIL-S-8879.

MATERIAL: Type 431 stainless steel per Spec. QQ-8-763.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: BB341 = Cadmium plate per QQ-P-416, Type I, Class 2.
BB341G = Silver plate per QQ-8-365, Grade B, .0002-.0004 thick.
BB341PB = Cadmium plate per QQ-P-416, Type II, Class 2.

CODE: Dash number indicates diameter of Blind Bolt Assembly in 32nds. Letters "G" or "PB" indicate type of plating.

EXAMPLE: BB341-8 = 8-32 Expander for use with 1/4 nominal diameter Blind Bolt Assembly.

BB351.64 BLIND BOLT ASSEMBLY

CODE: First dash number indicates nominal diameter of Blind Bolt Assembly in 32nds. Second dash number indicates nominal grip length (thickness of work) in 16ths. "G" after basic assembly number indicates silver plated Expander. Letters "P" or "PB" after basic assembly number indicate type of cadmium plate.

EXAMPLE: BB351.64-8-12

3/4 Nominal Grip Length
1/4 Nominal Diameter Blind Bolt Assembly
Blind Bolt Assembly which includes:
BB301 Core Bolt, BB321.64 Sleeve, and BB341 Expander

BB351.64G-8-12 = As example except with Expander BB341G.
BB351.64P-8-12 = As example except with Sleeve BB321.64P.
BB351.64PB-8-12 = As example except with Sleeve BB321.64PB, and Expander BB341PB.

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

TITLE						
BLIND BOLT™ ASSEMBLY						
ANS09 HEAD STYLE 1/64 OVERSIZE						
DRAWN	DATE	APPROVED	DATE	REVISION	DATE	DRAWING NUMBER
RKL	1-22-62	MMS	1-24-62	(11)	D. P. S. 3-20-79	BB351.64