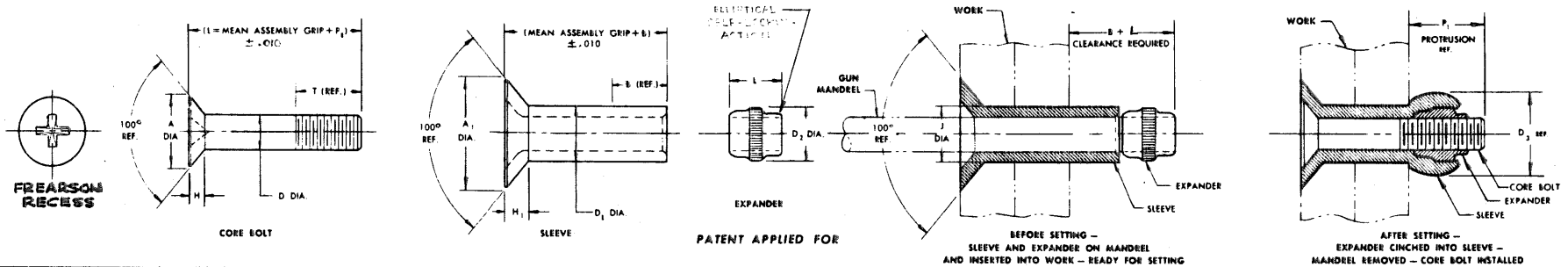

BB351F BOLT ASSEMBLY		BB301F CORE BOLT								BB321 SLEEVE								BB341 EXPANDER				SUGGESTED HOLE PREPARATION					PROTRUSION AFTER INSTALLATION	
FIRST DASH NUMBER	NOMINAL DIAMETER	FIRST DASH NUMBER	HEAD STYLE	A HEAD DIA.	T REF.	D SHANK DIA.	H HEAD HEIGHT	P_1	THREAD	FIRST DASH NUMBER	A_1 HEAD DIA	B GRIP RANGE 0 3/4	B GRIP RANGE 3/4 1 1/4	B GRIP RANGE 1 1/4 1 3/4		D_1 SHANK DIA.	H_1 HEAD HEIGHT	FIRST DASH NUMBER	D_2 OUTSIDE DIA.	L LENGTH	THREAD	J HOLE DIA				CORE BOLT INSTALLATION TORQUE	P_E PROTRUSION APPROX.	D_3 APPROX
-5	5/32	-5	FREARSON	.2274 .2226	.274	.1120 .1100	.048 .046	.208	4-40NC-3A	-5	.3310 .3262	.210	.225			.169 .166	.068 .066	-5	.167	.153	4-40NC-3B	.173 .170				8 10 IN. LBS.	.208	.210
-6	3/16	-6	FREARSON	.2514 .2466	.304	.1240 .1220	.053 .051	.239	5-40NC-3A	-6	.3813 .3765	.250	.265	.330		.196 .193	.078 .076	-6	.194	.184	5-40NC-3B	.201 .197				10 14 IN. LBS.	.239	.253
-8	1/4	-8	FREARSON	.3304 .3256	.397	.1650 .1630	.069 .067	.316	8-32NC-3A	-8	.5066 .5018	.315	.330	.370		.257 .254	.105 .103	-8	.255	.245	8-32NC-3B	.264 .258				20 30 IN. LBS.	.316	.335

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GENERAL NOTES

BB301F CORE BOLT

1. Head and shank to be concentric within .005 T.I.R.
2. Complete threads shall begin within two thread pitches maximum. Two thread pitch maximum may consist of incomplete thread or extrusion angle. Maximum major diameter shall be at least .001 less than minimum shank diameter but not less than minimum major diameter.

CODE: First dash number indicates nominal diameter of Sleeve in 1/32 increments into which Core Bolt will fit.
Second dash number indicates thickness of work (grip length) in 1/16 increments.

EXAMPLE: BB301F-8-12 — 12/16 or 3/4 mean assembly grip length; 8/32 or 1/4 Sleeve nominal diameter; Core Bolt basic part number

BB321 SLEEVE

1. hole and shank to be concentric within .005 T.I.R.
2. Head and shank to be concentric within .005 T.I.R.
3. "H_1" is dimensioned from maximum "D_1" diameter.

CODE: First dash number indicates nominal diameter of Sleeve in 1/32 increments.
Second dash number indicates thickness of work (grip length) in 1/16 increments.

EXAMPLE: BB321-8-12 — 12/16 or mean assembly grip length; 8/32 or 1/4 Sleeve nominal diameter; Sleeve basic part number

BB341 EXPANDER

CODE: Dash number indicates nominal diameter of Blind Bolt Assembly in 1/32 increments.

EXAMPLE: BB341-8 — 8/32 or 1/4 Blind Bolt Assembly nominal diameter; Expander basic part number

BB351F BOLT ASSEMBLY

1. Blind Bolt Assembly consists of Core Bolt, Sleeve and Expander.

CODE: First dash number indicates nominal diameter of Blind Bolt Assembly in 1/32 increments. Second dash number indicates thickness of work (grip length) in 1/16 increments.

EXAMPLE: BB351F-8-12 — 12/16 or 3/4 mean assembly grip length; 8/32 or 1/4 Blind Bolt Assembly nominal diameter; Blind Bolt Assembly which includes: BB301F-8-12 Core Bolt, BB321-8-12 Sleeve, BB341-8 Expander

U.S. PATENT 2677985 OTHER U.S. AND FOREIGN PATENTS PENDING "HI-TORQUE" TRADEMARK

MATERIAL	431 Corrosion resistant steel per specification MIL-S-853a, class 10.	Type 302 modified stainless steel.	431 Corrosion resistant steel per specification MIL-S-853a, class 10.
HEAT TREAT	Minimum 125,000 PSI shear		Minimum 125,000 PSI shear
FINISH			Cadmium plate per specification QQ-P-416, Type I, Class C. Plating thickness .0002-.0005.

TITLE: BLIND BOLT ASSEMBLY
AN509 HEAD STYLE
FREARSON RECESS

DRAWN	DATE	APPROVED	DATE	REVISION	DATE	DRAWING NUMBER
12-12-56		12-13-56		1	5-7-59	BB351F