



BLIND BOLT ASSEMBLY		BB309 CORE BOLT								BB335 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.	E GRIP RANGE 0-3/4	B GRIP RANGE 1/16-1 1/16	D GRIP RANGE 1 1/4-1 1/2	D ₁ DIA.	H ₁	DASH NUMBER	D ₂ DIA.	L (LENGTH)	THREAD	SOLE 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	.3310 .3262	.210			.169 .166	.0680 .0660	-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	.3813 .3765	.250			.196 .193	.0780 .0760	-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	.5066 .5018	.315	.330		.257 .254	.1050 .1030	-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	.414	.498	12-28UNJF-3A	-10	.6335 .6287	.380	.400	.420	.338 .335	.1240 .1220	-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	.485	.567	1/4-28UNJF-3A	-12	.7604 .7556	.450	.450	.450	.390 .387	.1554 .1534	-12	.383	.368	1/4-28UNJF-3B	.397 .391	125 150 IN. LBS.	.485	.510

BB309 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: BB309-6-12 = 3/16 nominal sleeve diameter, 3/4 mean assembly grip length.

BB335 SLEEVE

GENERAL NOTES: 1. Concentricity: Hole to "D₁" diameter within .005 TIR. "D₁" diameter to head within .005 TIR.
2. "H₁" is dimensioned from maximum "D₁" diameter.

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: BB335-6-12 = 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.

BB365 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: BB365-6-12
 ↳ 3/4 Mean Assembly Grip Length
 ↳ 3/16 Nominal Diameter Blind Bolt Assembly
 ↳ Blind Bolt Assembly which includes: BB309 Core Bolt, BB335 Sleeve, and BB341G Expander

U.S. Patent 2,959,999. Foreign patents issued. Hi-Torque® trademark.

TITLE					
BLIND BOLT ASSEMBLY					
100° COUNTERSUNK AN509 HEAD STYLE					
A-286 ALLOY					
DRAWN	DATE	APPROVED	DATE	REVISION	DRAWING NUMBER
J.W.O.	4-5-57	MM	11-3-57	14	BB365

BB365