



BLIND BOLT ASSEMBLY		BB309 CORE BOLT									BB332 SLEEVE						BB341G EXPANDER				SUGGESTED HOLE PREPARATION		FRUSION 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 1/2-1 1/4	B GRIP RANGE 1 1/4-1 3/4	B GRIP RANGE 1 3/4-2 1/4	D ₁ DIA.	H ₁	DASH NUMBER	D ₂ DIA.	L (LENGTH)	THREAD	J HOLE 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	.2844 .2794	.210	.225	.265	.305	.169 .166	.0488 .0467	-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	.3536 .3486	.250	.265	.330	.395	.196 .193	.066 .064	-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	.4732 .4682	.315	.330	.370	—	.257 .254	.094 .089	-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	.5619 .5569	.380	.400	.420	—	.338 .335	.098 .093	-10	.328	.307	12-28UNJF-3B	.345 .339	50 80 IN. LBS.	.414	.438

BB309 CORE BOLT

GENERAL NOTES:

- Concentricity: Head to "D" diameter within .005 FIR.
- Complete threads shall begin within two thread pitches maximum. Two thread pitch maximum may consist of incomplete thread and extrusion angle.
- Curved or flat edge manufacturer's option.

MATERIAL: A-286 high temperature alloy per AMS 5735.
HEAT TREAT: 95,000 psi shear minimum.
FINISH: Passivate.
CODE: First dash number of core bolt indicates sleeve nominal diameter in 32nds.
Second dash number indicates grip length (thickness of work) in 16ths.
EXAMPLE: BB309-5-12 = 4-40 Core Bolt for 5/32 nominal diameter sleeve, 3/4 grip length.

BB332 SLEEVE

GENERAL NOTES:

- Concentricity: Hole to "D₁" diameter within .005 FIR. Head to "D₁" diameter within .005 FIR.
- Curved or flat edge manufacturer's option.

MATERIAL: A-286 alloy meeting composition limits of the AMS spec.
HEAT TREAT: Heat treated to meet the requirements of AMS 5736.
FINISH: Passivate.
CODE: First dash number indicates nominal diameter of sleeve in 32nds.
Second dash number indicates grip length (thickness of work) in 16ths.
EXAMPLE: BB332-5-12 = Sleeve, 5/32 nominal diameter, 3/4 grip length.

BB341G EXPANDER

GENERAL NOTES:

- Threads per MIL-S-8879.

MATERIAL: Type AISI 431 corrosion-resisting steel per AMS5628.
HEAT TREAT: 125 ksi shear minimum
FINISH: Silver plate per AMS2410 (.0002-.0004 thick) and wax lubricant.
CODE: Dash number indicates diameter of Blind Bolt assembly in 32nds.
EXAMPLE: BB341G-5 = 4-40 Expander for 5/32 nominal diameter Blind Bolt Assembly.

BB368 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: BB368-5-12
 — 3/4 Grip Length
 — 5/32 Nominal Diameter Blind Bolt Assembly
 Blind Bolt Assembly which includes:
 BB309 Core Bolt, BB332 Sleeve, and BB341G Expander

"Blind Bolt" is a trademark of Hi-Shear Corporation.

TITLE						
BLIND BOLT™ ASSEMBLY						
100° COUNTERSUNK AN426 HEAD STYLE						
DRAWN	DATE	APPROVED	DATE	REVISION	DATE	DRAWING NUMBER
Johad 4-22-99		Schuster 4-22-99		14	D. P. S. 2-14-90	BB368