



BLIND BOLT ASSEMBLY		BB308 CORE BOLT								BB340 SLEEVE					BB342 EXPANDER				SUGGESTED HOLE PREPARATION		PROTRUSION AFTER INSTALLATION		INSTALLATION PRESSURE (psi) USING HI-SHEAR TOOLING				
FIRST DASH NUMBER	NOMINAL DIAMETER	FIRST DASH NUMBER	RECESS	A DIA.	D DIA.	H	P	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 3/8-1 1/2	B GRIP RANGE 1 11/16-2 1/4	D ₁ DIA.	H ₁	DASH NUMBER	D ₂ DIA.	L (LENGTH)	THREAD	HOLE DIA.	CORE BOLT INSTALLATION TORQUE	P	D ₁ DIA. (REF.)	BG1750	BG2500
-5	5/32	-5	Phillips #1	.2274 .2226	.1120 .1100	.048 .046	.208	.274	4-40UNJC-3A	-5	.294 .274	.210	.225	—	.169 .166	.055 .045	-5	.167	.153	4-40UNJC-3B	.173 .170	8 10	IN. LBS.	.208	.210	500	250
-6	3/16	-6	Phillips #1	.2514 .2466	.1240 .1220	.053 .051	.239	.304	5-40UNJC-3A	-6	.315 .295	.250	.265	.330	.196 .193	.065 .055	-6	.194	.184	5-40UNJC-3B	.201 .197	10 14	IN. LBS.	.239	.253	700	350
-8	1/4	-8	Phillips #2	.3304 .3256	.1650 .1630	.069 .067	.316	.397	8-32UNJC-3A	-8	.412 .387	.315	.330	.370	.257 .254	.090 .080	-8	.255	.245	8-32UNJC-3B	.264 .258	20 30	IN. LBS.	.316	.335	1100	650
-10	5/16	-10	Hi-Torque #3	.4454 .4406	.2180 .2160	.095 .093	.414	.498	12-28UNJF-3A	-10	.530 .500	.380	.400	.420	.338 .335	.110 .100	-10	.328	.307	12-28UNJF-3B	.345 .339	50 80	IN. LBS.	.414	.438	1850	950
-12	3/8	-12	Hi-Torque #4	.5066 .5018	.2490 .2470	.108 .106	.485	.567	1/4-28UNJF-3A	-12	.615 .580	.450	.450	.450	.390 .387	.155 .145	-12	.383	.368	1/4-28UNJF-3B	.397 .391	125 150	IN. LBS.	.485	.510	—	1450

BB308 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.
- "H" is dimensioned from maximum "D" diameter.

MATERIAL: 6Al-4V titanium alloy per AMS4967.
HEAT TREAT: 95,000 psi shear minimum.
CODE: First dash number of core bolt indicates sleeve nominal diameter in 32nds. Second dash number indicates assembly grip length (thickness of work) in 16ths.
EXAMPLE: BB308-8-12 = 8-32 core bolt for 1/4 nominal diameter sleeve, 3/4 assembly grip length.

BB340 SLEEVE

GENERAL NOTES:

- Concentricity: Hole to "D" diameter within .005 FIR. "D₁" diameter to head within .010 FIR.

MATERIAL: Commercially pure titanium.
CODE: First dash number indicates nominal diameter of sleeve in 32nds. Second dash number indicates assembly grip length (thickness of work) in 16ths.
EXAMPLE: BB340-8-12 = 1/4 nominal diameter sleeve, 3/4 assembly grip length.

BB342 EXPANDER

GENERAL NOTES:

- Threads per MIL-S-8879.

MATERIAL: 6Al-4V titanium alloy per AMS4967.
HEAT TREAT: 95,000 psi shear minimum.
FINISH: Solid film lubricant.
CODE: Dash number indicates nominal diameter of Blind Bolt Assembly in 32nds.
EXAMPLE: BB342-8 = 1/4 nominal diameter Blind Bolt Assembly using 8-32 expander.

BB370 BOLT ASSEMBLY

CODE: First dash number indicates nominal diameter of Blind Bolt Assembly in 32nds. Second dash number indicates assembly grip length (thickness of work) in 16ths.
EXAMPLE: BB370-8-12

- 3/4 Assembly Grip Length
- 1/4 Nominal Diameter Blind Bolt Assembly
- Blind Bolt Assembly which includes: BB308 Core Bolt, BB340 Sleeve, and BB342 Expander

TITLE					
BLIND BOLT™ ASSEMBLY					
PROTRUDING HEAD STYLE					
TITANIUM					
DRAWN	DATE	APPROVED	DATE	REVISION	DATE
LANDES	10-28-79	Schuster	10-28-79	①	11-12-73
					BB370

U. S. Patents 2,959,999; 2,677,985.
Foreign patents issued and pending.
"Hi-Torque" trademark.

BB370