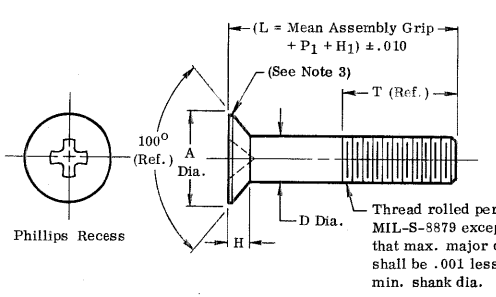
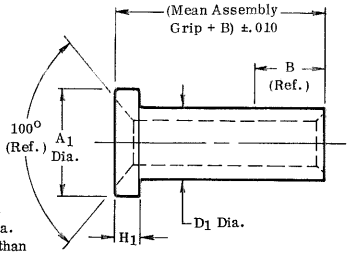
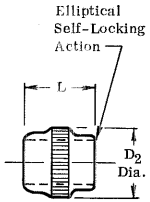
hi-shear CORPORATION
2600 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90509
AREA CODE 213 • 775-3181 • 326-8110



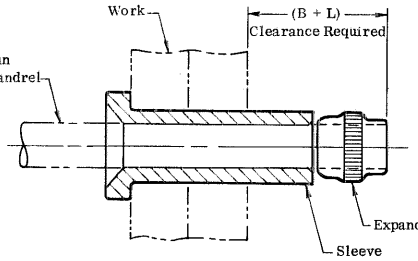
CORE BOLT



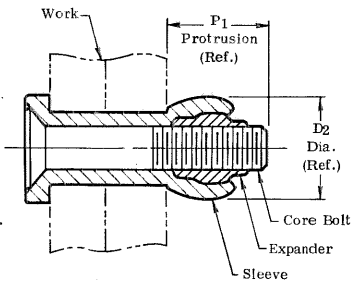
SLEEVE



EXPANDER



SLEEVE AND EXPANDER ASSEMBLED ON MANDREL, INSERTED INTO WORK, READY TO SET.



COMPLETED BLIND BOLT ASSEMBLY SHOWING CORE BOLT INSTALLED

BLIND BOLT ASSEMBLY		BB312 CORE BOLT								BB336 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.	B GRIP RANGE 0-¾	B GRIP RANGE 13/16-1 1/16	B GRIP RANGE 1 3/16-1 5/8		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	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
-6	3/16	-6	Phillips #2	.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
-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

BB312 CORE BOLT

GENERAL 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. Curved or flat edge manufacturer's option.

MATERIAL: A-286 alloy
HEAT TREAT: 95,000 psi shear minimum.
FINISH:
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: BB312-6-12 = 5-40 core bolt for 3/16 nominal diameter sleeve, 3/4 mean assembly grip length.

BB336 SLEEVE

GENERAL NOTES:
1. Concentricity: Hole to "D_1" diameter within .005 FIR.
Head to "D_1" diameter within .010 FIR.

MATERIAL: A-286 alloy
HEAT TREAT: Anneal
FINISH:
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: BB336-6-12 = Sleeve, 3/16 nominal diameter, 3/4 mean assembly grip length.

BB341G EXPANDER

GENERAL NOTES:
1. Threads per MIL-S-8879.

MATERIAL: Type 431 corrosion-resistant steel per Spec. AMS5628.
HEAT TREAT: 125,000 psi shear minimum.
FINISH: Silver plate per AMS2410 (.0002-.0004 thick) and wax lubricant.
CODE: Dash number indicates nominal diameter of Blind Bolt assembly in 32nds.
EXAMPLE: BB341G-6 = 5-40 expander for 3/16 nominal diameter Blind Bolt assembly.

BB380 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: BB380-6-12
- 3/4 Mean Assembly Grip Length
- 3/16 Nominal Diameter Blind Bolt Assembly
- Blind Bolt Assembly which includes: BB312 Core Bolt, BB336 Sleeve, and BB341G Expander

③ Editorially Updated

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

TITLE
BLIND BOLT™ ASSEMBLY
PROTRUDING HEAD STYLE
A-286 ALLOY

DRAWN	DATE	APPROVED	DATE	REVISION	DATE	DRAWING NUMBER
D.G.P.	4-4-61		4-4-61	③	Shrode 12-13-74	BB380

BB380

2-1012

CODE IDENTIFICATION NO. 73197

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