



BLIND BOLT ASSEMBLY		BB311 CORE BOLT								BB332 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 0-3/4	B GRIP RANGE 1 1/16-1 1/2	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	.2844 .2794	.210	.225	.169 .166	.0488 .0467	-5	.167	.153	4-40UNJC-3B	.173 .170	8 10 IN. LBS.	.208	.210
-6	3/16	-6	Phillips #1	.2514 .2466	.1240 .1220	.053 .051	.239	.304	5-40UNJC-3A	-6	.3536 .3486	.250	.265	.196 .193	.066 .064	-6	.194	.184	5-40UNJC-3B	.201 .197	10 14 IN. LBS.	.239	.253

BB311 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: BB311-5-12 = 4-40 core bolt for 5/32 nominal diameter sleeve, 3/4 mean assembly grip length.

BB332 SLEEVE

GENERAL NOTES:

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

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: BB332-5-12 = Sleeve, 5/32 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 diameter of Blind Bolt assembly in 32nds.

EXAMPLE: BB341G-5 = 4-40 expander for 5/32 nominal diameter Blind Bolt assembly.

BB381 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: BB381-5-12

- 5 — 3/4 Mean Assembly Grip Length
- 12 — 5/32 Nominal Diameter Blind Bolt Assembly

Blind Bolt Assembly which includes:
BB311 Core Bolt, BB332 Sleeve, and BB341G Expander

① Editorially Updated

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

TITLE						
BLIND BOLT™ ASSEMBLY						
100° COUNTERSUNK AN426 HEAD STYLE						
DRAWN	DATE	APPROVED	DATE	REVISION	DATE	DRAWING NUMBER
DGP/Hand		[Signature]	4-4-61	③	Shrode 12-13-74	BB381

BB381