



BLIND BOLT ASSEMBLY		BB301 CORE BOLT								BB501 SLEEVE						BB341 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 1/16	D ₁ DIA.	H ₁	DASH NUMBER	D ₂ DIA.	L (LENGTH)	THREAD	HOLE DIA.	CORE BOLT INSTALLATION TORQUE	P ₁	D ₁ 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
-8	1/4	-8	Phillips #2	.3304 .3256	.1650 .1630	.069 .067	.316	.397	8-32UNJC-3A	-8	.4732 .4682	.315	.330	.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	.338 .335	.098 .093	-10	.328	.307	12-28UNJF-3B	.345 .339	50 80 IN. LBS.	.414	.438

BB301 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: Type 431 corrosion-resisting steel per Spec. AMS5628.

HEAT TREAT: 125,000 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: BB301-5-12 = 4-40 core bolt for 5/32 nominal diameter sleeve, 3/4 mean assembly grip length.

BB501 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: Type 305 corrosion-resisting steel per QQ-S-763.

HEAT TREAT: Annealed.

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: BB501-5-12 = Sleeve, 5/32 nominal diameter, 3/4 mean assembly grip length.

BB341 EXPANDER

GENERAL NOTES:

- Threads per MIL-S-8879.

MATERIAL: Type 431 corrosion-resisting steel per Spec. AMS5628.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: Cadmium plate per QQ-P-416, Type I, Class 2, and cetyl alcohol lube.

CODE: Dash number indicates diameter of Blind Bolt Assembly in 32nds.

EXAMPLE: BB341-5 = 4-40 expander for 5/32 nominal diameter Blind Bolt assembly.

BB382 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: BB382-5-12

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

Blind Bolt Assembly which includes:
BB301 Core Bolt, BB501 Sleeve, and BB341 Expander

Ⓢ Editorially Updated

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

TITLE					
BLIND BOLT™ ASSEMBLY					
100° COUNTERSUNK AN426 HEAD STYLE					
DRAWN	DATE	APPROVED	DATE	REVISION	DATE
R. K. L.	4-4-61	MMS	4-4-61	3	12-13-74
					BB382