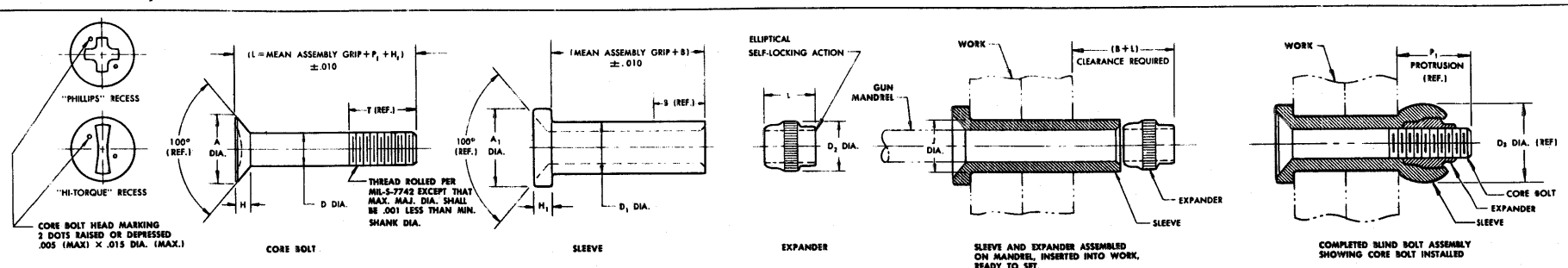
hi-shear CORPORATION
2600 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90509
AREA CODE 213 · 775-3181 · 326-8110



BB386 BOLT ASSEMBLY		BB302 CORE BOLT								BB322N SLEEVE								BB341N EXPANDER				SUGGESTED HOLE PREPARATION					PROTRUSION AFTER INSTALLATION	
FIRST DASH NUMBER	NOMINAL DIAMETER	FIRST DASH NUMBER	RECESS	A	T	D	H	P_1	THREAD	FIRST DASH NUMBER	A_1	S GRIP RANGE 0-⅝	S GRIP RANGE ⅝-1⅛	S GRIP RANGE 1⅛-1⅝	S GRIP RANGE 1⅝-2⅛	D_1	H_1	DASH NUMBER	D_2	L	THREAD	J HOLE DIA.				CORE BOLT INSTALLATION TORQUE	P_1	D_2
-5	5/32	-5	PHILLIPS #1	.2274 .2236	.274	.1120 .1100	.048 .046	.208	4-40 NC-3A	5	.294 .274	.210	.225			.169 .166	.055 .045	-5	.167	.153	4-40 NC-3B	.173 .170				8 10 IN. LBS.	.208	.210
-6	3/16	-6	PHILLIPS #1	.2514 .2466	.304	.1240 .1220	.053 .051	.239	5-40 NC-3A	6	.315 .295	.250	.265	.330		.196 .193	.065 .055	-6	.194	.184	5-40 NC-3B	.201 .197				10 14 IN. LBS.	.239	.253
-8	1/4	-8	PHILLIPS #2	.3304 .3256	.397	.1650 .1630	.069 .067	.316	8-32 NC-3A	-8	.412 .387	.315	.330	.370		.257 .254	.090 .080	-8	.255	.245	8-32 NC-3B	.264 .258				20 30 IN. LBS.	.316	.335
-10	5/16	-10	HI-TORQUE #3	.4454 .4406	.498	.2180 .2160	.095 .093	.414	12-28 NF-3A	-10	.530 .500	.380	.400	.420		.338 .335	.110 .100	-10	.328	.307	12-28 NF-3B	.345 .339				50 80 IN. LBS.	.414	.438
-12	3/8	-12	HI-TORQUE #4	.5066 .5018	.567	.2490 .2470	.108 .106	.485	1/4-28 UNF-3A	-12	.615 .580	.450	.450	.450		.390 .387	.155 .145	-12	.383	.368	1/4-28 UNF-3B	.397 .391				125 150 IN. LBS.	.485	.510
-14	7/16	-14	HI-TORQUE #5	.6335 .6287	.628	.3110 .3090	.135 .133	.543	5/16-24 UNF-3A	-14	.863 .768	.500	.500	.500		.468 .465	.160 .150	-14	.458	.429	5/16-24 UNF-3B	.475 .469				200 220 IN. LBS.	.543	.600
-16	1/2	-16	HI-TORQUE #6	.7604 .7556	.685	.3740 .3720	.162 .160	.600	3/8-24 UNF-3A	-16	.896 .861	.550	.550	.550		.530 .527	.185 .175	-16	.521	.491	3/8-24 UNF-3B	.539 .531				380 400 IN. LBS.	.600	.662

GENERAL NOTES

BB302 CORE BOLT

1. CONCENTRICITY: Head to "D" diameter within .005 TIR.
2. Complete threads shall begin within two thread pitches maximum. Two thread pitch maximum may consist of incomplete thread and extrusion angle.
3. "H" is dimensioned from maximum "D" diameter.

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: BB302-8-12 = 8-32 core bolt for 1/4 nominal diameter sleeve, 3/4 mean assembly grip length.

BB322N SLEEVE

1. CONCENTRICITY: Hole to "D" diameter within .005 TIR. "D_1" diameter to head within .010 TIR.

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: BB322N-8-12 = 1/4 nominal diameter sleeve, 3/4 mean assembly grip length.

BB341N EXPANDER

1. Threads per MIL-S-7742

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

EXAMPLE: BB341N-8 = 1/4 nominal diameter Blind Bolt Assembly using 8-32 Expander.

BB386 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: BB386-8-12
- 3/4 mean assembly grip length
- 1/4 nominal diameter (Blind Bolt Assembly)
- Blind Bolt Assembly which includes: BB302 Core Bolt, BB322N Sleeve, BB341N Expander

MATERIAL	Type 431 Stainless steel per Spec. QQ-S-763	Type 305 stainless steel per QQ-S-763	Type 431 stainless steel per Spec. QQ-S-763
HEAT TREAT	125,000 psi shear minimum.		125,000 psi shear minimum
FINISH		Nickel - Cadmium plate per AMS2416	Nickel - Cadmium plate per AMS2416

TITLE
BLIND BOLT* ASSEMBLY
PROTRUDING HEAD STYLE

DRAWN	DATE	APPROVED	DATE	REVISION	DATE	DRAWING NUMBER
8-763	Brlej	[illegible]	8-763	○		BB386

BB386