



BLIND BOLT ASSEMBLY		BB312 CORE BOLT								BB336 SLEEVE						BB415GA 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 9-3/4	B GRIP RANGE 1 1/16-1 1/16	B GRIP RANGE 1 3/8-1 3/8	B GRIP RANGE 1 11/16-2 3/4	D ₁ DIA.	H ₁	DASH NUMBER	D ₂ DIA.	L (LENGTH)	THREAD	J HOLE DIA.	CORE BOLT INSTALLATION TORQUE	P ₁	D ₃ DIA. (REF.)
-5	5/32	-5	Phillips #1	.2274 .2226	.1120 .1100	.048 .046	.208	.274	4-40NC-3A	-5	.294 .274	.210	.225		.169 .166 .193	.055 .045	-5	.167	.153	4-40NC-3B	.173 .170	8 10 IN. LBS.	.208	.210	
-6	3/16	-6	Phillips #1	.2514 .2466	.1240 .1220	.053 .051	.239	.304	5-40NC-3A	-6	.315 .295	.250	.265	.330	.196 .193	.065 .055	-6	.194	.184	5-40NC-3B	.201 .197	10 14 IN. LBS.	.239	.253	
-8	1/4	-8	Phillips #2	.3304 .3256	.1650 .1630	.069 .067	.316	.397	8-32NC-3A	-8	.412 .387	.315	.330	.370	.257 .254	.090 .080	-8	.255	.245	8-32NC-3B	.264 .258	20 30 IN. LBS.	.316	.335	

BB312 CORE BOLT

- ① 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. "H" is dimensioned from maximum "D" diameter.
- ② MATERIAL: A-286 alloy per AMS5731 or AMS5735.
HEAT TREAT: 95,000 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: BB312-6-12 = 3/16 nominal sleeve diameter, 3/4 mean assembly grip length.

BB336 SLEEVE

- ① GENERAL NOTES: 1. Concentricity: Hole to "D" diameter within .005 FIR.
② MATERIAL: A-286 alloy per AMS 5731.
③ HEAT TREAT: Anneal per AMS5736.
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 = 3/16 nominal sleeve diameter, 3/4 mean assembly grip length.

BB415GA EXPANDER

- GENERAL NOTES: 1. Threads per MIL-S-8879.
② MATERIAL: A-286 alloy per AMS5731 or AMS5735.
HEAT TREAT: 110,000 psi shear minimum.
FINISH: Silver plate per AMS2411, .0002—, .0004 thick.
CODE: Dash number indicates nominal diameter of Blind Bolt Assembly in 32nds.
EXAMPLE: BB415GA-6 = 3/16 nominal diameter Blind Bolt Assembly.

BB391 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: BB391-6-12
— 3/4 Mean Assembly Grip Length
— 3/16 Nominal Diameter Blind Bolt Assembly
— Blind Bolt Assembly which includes:
BB312 Core Bolt, BB336 Sleeve, and BB415GA Expander

U. S. Patents 2,789, 619; 2,946, 208; 2,959, 999.
Foreign patents granted and pending.

TITLE					
BLIND BOLT™ ASSEMBLY PROTRUDING HEAD STYLE A-286 ALLOY					
DRAWN	DATE	APPROVED	DATE	REVISION	DRAWING NUMBER
<i>Belj</i>	12-31-64	<i>M</i>	12-31-62	2	BB391

CODE IDENTIFICATION NO. 73197

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