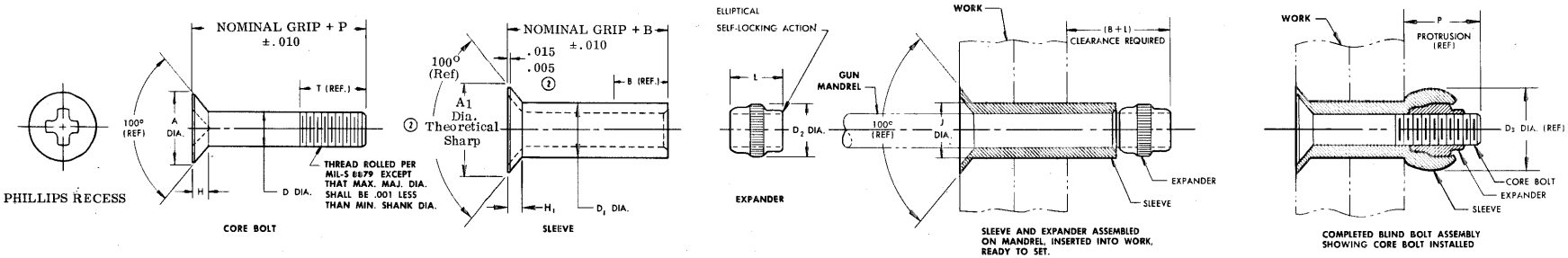
hi-shear CORPORATION
2600 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90509
AREA CODE 213 • 775-3181 • 326-8110



BLIND BOLT ASSEMBLY		BB422 CORE BOLT								BB421 SLEEVE								BB341G EXPANDER				SUGGESTED HOLE PREPARATION		PROTRUSION AFTER INSTALLATION	
FIRST DASH NUMBER	NOMINAL DIAMETER	FIRST DASH NUMBER	RECESS	A DIA.	D DIA.	H		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 1⅛-1⅝		D_1 DIA.	H_1	DASH NUMBER	D_2 DIA.	L (LENGTH)	THREAD	J HOLE DIA.	CORE BOLT INSTALLATION TORQUE	P	D_2 DIA. (REF)
-5	5/32	-5	Phillips	.1879 .1831	.1120 .1100	.032 .029		.274	4-40UNJC-3A	-5	.2612 .2564	.210	.225			.169 .166	.039 .036	-5	.167	.153	4-40UNJC-3B	.173 .170	8 10 IN. LBS.	.208	.210
-6	3/16	-6	Phillips	.2289 .2241	.1240 .1220	.045 .042		.304	5-40UNJC-3A	-6	.3016 .2966	.250	.265	.330		.196 .193	.045 .042	-6	.194	.184	5-40UNJC-3B	.201 .197	10 14 IN. LBS.	.239	.253
-8	1/4	-8	Phillips	.2922 .2874	.1650 .1630	.054 .051		.397	8-32UNJC-3A	-8	.3948 .3898	.315	.330	.370		.257 .254	.058 .055	-8	.255	.245	8-32UNJC-3B	.264 .258	20 30 IN. LBS.	.316	.335

BB422 CORE BOLT

GENERAL NOTES: 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.

MATERIAL: A-286 high temperature alloy per AMS5731 or AMS5737.
HEAT TREAT: 95,000 psi shear minimum at room temperature.
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: BB422-6-12 = 3/16 nominal sleeve diameter, 3/4 mean assembly grip length.

BB421 SLEEVE

GENERAL NOTES: 1. Concentricity: Hole to "D_1" diameter within .005 TIR. "D_1" diameter to head within .005 TIR.
2. "H_1" is dimensioned from maximum "D_1" diameter.

MATERIAL: Type A-286 meeting composition limits of the AMS specifications.
HEAT TREAT: Heat treated to meet the requirements of 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: BB421-6-12 = 3/16 nominal sleeve diameter, 3/4 mean assembly grip length.

BB341G EXPANDER

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

MATERIAL: Type 431 stainless steel per Spec. QQ-S-763.
HEAT TREAT: 125,000 psi shear minimum.
FINISH: Silver plate per QQ-S-365, Grade B, .0002—.0004 thick.
CODE: Dash number indicates diameter of Blind Bolt assembly in 32nds.
EXAMPLE: BB341G-6 = 3/16 nominal diameter Blind Bolt Assembly.

BB518 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: BB518-5-12
- 3/4 Mean Assembly Grip Length
- 3/16 Nominal Diameter Blind Bolt Assembly
- Blind Bolt Assembly which includes: BB422 Core Bolt, BB421 Sleeve, and BB341G Expander

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

BLIND BOLT™ ASSEMBLY
100° COUNTERSUNK SHEAR HEAD STYLE
A-286 ALLOY

DRAWN	DATE	APPROVAL	DATE	REVISION	DATE	DRAWING NUMBER
AHS	12-10-69		12-16-69	(2)	Shrode 8-1-72	BB518

BB518

CODE IDENTIFICATION NO. 73197
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