



BLIND BOLT ASSEMBLY			BB170 CORE BOLT							BB321 SLEEVE							BB567 EXPANDER				SUGGESTED HOLE PREPARATION		PROTRUSION AFTER INSTALLATION		INSTALLATION PRESSURE (psi) USING HI-SHEAR TOOLING		
FIRST DASH NUMBER	NOMINAL DIAMETER	MIN. GRIP	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 1/2-1 3/4	B GRIP RANGE 1 3/4-2 1/4	D ₁ DIA.	H ₁	DASH NUMBER	D DIA.	L (LENGTH)	THREAD	HOLE DIA.	CORE BOLT INSTALLATION TORQUE	P ₁	D ₂ DIA. (REF)	BG1750	BG2500
-5	5/32	-1	-5	Phillips #1	.2274 .2226	.1120 .1100	.048 .046	.208	.274	4-40UNJC-3A	-5	.3310 .3262	.210	—	—	.169 .166	.0680 .0660	-5	.167	.153	4-40UNJC-3B	.173 .170	8 10 IN. LBS.	.208	.210	500	250
-6	3/16	-2	-6	Phillips #1	.2514 .2466	.1240 .1220	.053 .051	.239	.304	5-40UNJC-3A	-6	.3813 .3765	.250	—	—	.196 .193	.0780 .0760	-6	.194	.184	5-40UNJC-3B	.201 .197	10 14 IN. LBS.	.239	.253	700	350
-8	1/4	-2	-8	Phillips #2	.3304 .3256	.1650 .1630	.069 .067	.316	.397	8-32UNJC-3A	-8	.5066 .5018	.315	.330	—	.257 .254	.1050 .1030	-8	.255	.245	8-32UNJC-3B	.264 .258	20 30 IN. LBS.	.316	.335	1100	650
-10	5/16	-2	-10	Hi-Torque #3	.4454 .4406	.2180 .2160	.095 .093	.414	.498	12-28UNJF-3A	-10	.6335 .6287	.380	.420	—	.338 .335	.1240 .1220	-10	.328	.307	12-28UNJF-3B	.345 .339	50 80 IN. LBS.	.414	.438	1850	950
-12	3/8	-4	-12	Hi-Torque #4	.5066 .5018	.2490 .2470	.108 .106	.485	.567	1/4-28UNJF-3A	-12	.7604 .7556	.450	.450	—	.390 .387	.1554 .1534	-12	.383	.368	1/4-28UNJF-3B	.397 .391	125 150 IN. LBS.	.485	.510	—	1450
-14	7/16	-4	-14	Hi-Torque #5	.6335 .6287	.3110 .3090	.135 .133	.543	.628	5/16-24UNJF-3A	-14	.8884 .8812	.500	.500	.500	.468 .465	.1764 .1734	-14	.458	.429	5/16-24UNJF-3B	.475 .469	200 220 IN. LBS.	.543	.600	—	1900
-16	1/2	-4	-16	Hi-Torque #6	.7604 .7556	.3740 .3720	.162 .160	.600	.685	3/8-24UNJF-3A	-16	1.0139 1.0068	.550	.550	.550	.530 .527	.2030 .2000	-16	.521	.491	3/8-24UNJF-3B	.539 .531	380 400 IN. LBS.	.600	.662	—	2250

BB170 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.
- "H" is dimensioned from maximum "D" diameter.
- Curved or flat edge, manufacturer's option.

MATERIAL: 13 - 8PH per AMS5629.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: Passivate.

CODE: First dash number of core bolt indicates sleeve nominal diameter in 32nds. Second dash number indicates grip length (thickness of work) in 16ths.

EXAMPLE: BB170-8-12 = 8-32 core bolt for 1/4 nominal diameter sleeve, 3/4 grip length.

BB588 BLIND BOLT ASSEMBLY

CODE: First dash number indicates nominal diameter of Blind Bolt Assembly in 32nds. Second dash number indicates grip length (thickness of work) in 16ths. Minimum grip in table shows the lowest second dash number available. "G" after basic assembly number indicates silver plated Expander. Letters "P" or "PB" after basic assembly number indicate type of cadmium plate.

BB321 SLEEVE

GENERAL NOTES:

- Concentricity: Hole to "D₁" diameter within .005 FIR. Head to "D₁" diameter within .005 FIR.
- "H₁" is dimensioned from maximum "D₁" diameter.

MATERIAL: Type 305 stainless steel per QQ-S-763.

FINISH: BB321 = Passivate.
BB321P = Cadmium plate per QQ-P-416, Type I, Class 2.
BB321PE = Cadmium plate per QQ-P-416, Type II, Class 2.

CODE: First dash number indicates nominal diameter of sleeve in 32nds. Second dash number indicates grip length (thickness of work) in 16ths. Letters "P" or "PB" indicate type of plating.

EXAMPLE: BB321-8-12 = 1/4 nominal diameter sleeve, 3/4 grip length.

EXAMPLE: BB588-8-12

3/4 Grip Length
1/4 Nominal Diameter Blind Bolt Assembly
Blind Bolt Assembly which includes:
① BB170 Core Bolt, BB321 Sleeve, and BB341 Expander

BB588-8-12G = As example except with Expander BB567G.
BB588-8-12P = As example except with Sleeve BB321P.
BB588-8-12PB = BB170 Core Bolt, BB321PB Sleeve and BB567 Expander.

BB567 EXPANDER

GENERAL NOTES:

- Threads per MIL-S-8879.

MATERIAL: 13 - 8PH per AMS5629.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: BB567 = Cadmium plate per QQ-P-416, Type I, Class 2, and cetyl alcohol lube.
BB567G = Silver plate per QQ-S-365, Grade B, .0002-.0004 thick, and wax lube.
BB567PB = Cadmium plate per QQ-P-416, Type II, Class 2, and cetyl alcohol lube.
BB567DU = Solid film lubricant per MIL-L-8937.

CODE: Dash number indicates diameter of Blind Bolt Assembly in 32nds. Letters "G" or "PB" indicate type of plating, "DU" indicates solid film lube.

EXAMPLE: BB567-8 = 8-32 Expander for use with 1/4 nominal diameter Blind Bolt Assembly.

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

TITLE			
BLIND BOLT™ ASSEMBLY 100° COUNTERSUNK AN509 HEAD STYLE			
DRAWN	DATE	APPROVED	DATE
RWB	3/27/78	RWB	3/27/78
REVISION	DATE	D. P. S.	
(2)		6-4-80	
DRAWING NUMBER			BB588