



BLIND BOLT ASSEMBLY		BB457 CORE BOLT							BB336 SLEEVE					BB341GT EXPANDER				SUGGESTED HOLE PREPARATION		PROTRUSION AFTER INSTALLATION		DOUBLE SHEAR STRENGTH MINIMUM	UTS LBS. MIN.
FIRST DASH NUMBER	NOMINAL DIAMETER	FIRST DASH NUMBER	A DIA.	D DIA.	H	P ₁	T (REF.)	THREAD	FIRST DASH NUMBER	A ₁ DIA.	B GRIP RANGE 0-¾	D ₁ DIA.	H ₁	DASH NUMBER	D ₂ DIA.	L (LENGTH)	THREAD	J HOLE DIA.	CORE BOLT INSTALLATION TORQUE	P ₁	D ₂ DIA. (REF.)		
-16	1/2	-16	.7604 .7556	.3740 .3720	.162 .160	.600	.685	3/8-24UNJF-3A	-16	.896 .861	.550	.530 .527	.185 .175	-16	.561	.491	3/8-24UNJF-3B	.539 .531	400 370	.600	.662	40,000	14,800
-20	5/8	-20	1.0139 1.0091	.4990 .4970	.217 .215	.700	.790	1/2-20UNJF-3A	-20	1.174 1.139	.650	.654 .651	.235 .225	-20	.643	.614	1/2-20UNJF-3B	.664 .656	750 700	.700	.790	64,000	16,100
-24	3/4	-24	1.2723 1.2675	.6240 .6220	.272 .270	.875	.915	5/8-18UNJF-3A	-24	1.462 1.422	.750	.778 .774	.335 .320	-24	.765	.670	5/8-18UNJF-3B	.789 .781	1500 1450	.875	.914	95,000	19,200

BB457 CORE BOLT

- 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.

MATERIAL: Type Inco 718 stainless steel per AMS5662.

HEAT TREAT: 125,000 psi shear minimum.

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: BB457-16-12 = 3/8-24 Core Bolt for 1/2 nominal diameter sleeve, 3/4 grip length.

BB336 SLEEVE

- NOTES: 1. Concentricity: Hole to "D" diameter within .005 FIR.
 "D₁" diameter to head within .010 FIR.
 2. Curved or flat edge manufacturer's option.

MATERIAL: A-286 alloy.

HEAT TREAT: Anneal.

FINISH: Passivate.

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: BB336-16-12 = Sleeve, 1/2 nominal diameter, 3/4 mean assembly grip length.

BB596 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.

EXAMPLE: BB596-16-12
 ——— 3/4 Grip Length
 ——— 1/2 Nominal Diameter
 ——— Blind Bolt Assembly which includes:
 BB457 Core Bolt, BB336 Sleeve, and
 BB341GT Expander

BB341GT EXPANDER

NOTE: 1. Thread per MIL-S-7742.

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

HEAT TREAT: 125,000 psi shear minimum.

FINISH: Silver plate per AMS2410C, and Hi-Kote 2.

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

EXAMPLE: BB341GT-16 = 3/8-24 Expander for use with 1/2 nominal diameter Blind Bolt Assembly.

TITLE					
BLIND BOLT™ ASSEMBLY PROTRUDING HEAD STYLE					
Sheet 1 of 2					
DRAWN	DATE	APPROVED	DATE	REVISION	DRAWING NUMBER
D. P. S.	10-10-83	<i>[Signature]</i>	10-17-83	3	BB596

GRIP TABLE

SECOND DASH NO.	GRIP	GRIP RANGE
1	—	—
2	—	—
3	—	—
4	1/4	.250 .187
5	5/16	.312 .250
6	3/8	.375 .312
7	7/16	.437 .375
8	1/2	.500 .437
9	9/16	.562 .500
10	5/8	.625 .562
11	11/16	.687 .625
12	3/4	.750 .687
13	13/16	.812 .750
14	7/8	.875 .812
15	15/16	.937 .875
16	1"	1.000 .937
17	1-1/16	1.062 1.000
18	1-1/8	1.125 1.062
19	1-3/16	1.187 1.125
20	1-1/4	1.250 1.187

SECOND DASH NO.	GRIP	GRIP RANGE
21	1-5/16	1.312 1.250
22	1-3/8	1.375 1.312
23	1-7/16	1.437 1.375
24	1-1/2	1.500 1.437
25	1-9/16	1.562 1.500
26	1-5/8	1.625 1.562
27	1-11/16	1.687 1.625
28	1-3/4	1.750 1.687
29	1-13/16	1.812 1.750
30	1-3/4	1.875 1.812
31	1-15/16	1.937 1.875
32	2"	2.000 1.937
33	2-1/16	2.062 2.000
34	2-1/8	2.125 2.062
35	2-3/16	2.187 2.125
36	2-1/4	2.250 2.187
37	2-5/16	2.312 2.250
38	2-3/8	2.375 2.312
39	2-7/16	2.437 2.375
40	2-1/2	2.500 2.437

SECOND DASH NO.	GRIP	GRIP RANGE
41	2-9/16	2.562 2.500
42	2-5/8	2.625 2.562
43	2-11/16	2.687 2.625
44	2-3/4	2.750 2.687
45	2-13/16	2.812 2.750
46	2-7/8	2.875 2.812
47	2-15/16	2.937 2.875
48	3"	3.000 2.937
49	3-1/16	3.062 3.000
50	3-1/8	3.125 3.062
51	3-3/16	3.187 3.125
52	3-1/4	3.250 3.187
53	3-5/16	3.312 3.250
54	3-3/8	3.375 3.312
55	3-7/16	3.437 3.375
56	3-1/2	3.500 3.437
57	3-9/16	3.562 3.500
58	3-5/8	3.625 3.562
59	3-11/16	3.687 3.625
60	3-3/4	3.750 3.687

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BLIND BOLT™ ASSEMBLY			
PROTRUDING HEAD STYLE			
Sheet 2 of 2			
			DRAWING NUMBER
			BB596

BB596