



BLIND BOLT ASSEMBLY		BB170 CORE BOLT								BB335 SLEEVE					BB567 EXPANDER				SUGGESTED HOLE PREPARATION		PROTEUSION AFTER INSTALLATION			
FIRST DASH NUMBER	NOMINAL DIAMETER	FIRST DASH NUMBER	RECESS	A DIA.	D DIA.	H	P ₁	Y (REF)	THREAD	FIRST DASH NUMBER	A ₁ DIA.	B GRIP RANGE 0-3%	E GRIP RANGE 1 1/16-1 1/8	G GRIP RANGE 1 1/2-1 3/4	D ₁ DIA.	H ₁	DASH NUMBER	D ₂ DIA.	L (LENGTH)	THREAD	J HOLE DIA.	CORE BOLT INSTALLATION TORQUE	F ₁	D ₂ DIA. (REF)
-18	9/16	-18	7/16	.8884 .8404	.4370 .4360	.190 .188	.675	.759	7/16-20UNJF-3A	-18	1.1408 1.1387	.600	.600	.600	.592 .597	.230 .228	-720	.585	.552	7/16-20UNJF-3B	.602 .594	.530 .450	.675	.736

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: PH13-8Mo stainless steel 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: BB170-18-12 = 7/16-20 core bolt for 9/16 nominal diameter sleeve, 3/4 grip length.

BB335 SLEEVE

- GENERAL NOTES:**
- Concentricity: Hole to "D₁" diameter within .005 FIR. Head to "D₁" diameter within .005 FIR.

② Curved or flat edge manufacturer's option.

MATERIAL: A-286 alloy.

HEAT TREAT: Anneal.

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: BB335-18-12 = Sleeve, 9/16 nominal diameter, 3/4 mean assembly grip length.

BB567 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: BB597-18-12

— 3/4 Mean Assembly Grip Length
— 9/16 Nominal Diameter Blind Bolt Assembly
— Blind Bolt Assembly which includes: BB170 Core Bolt, BB335 Sleeve, and BB567 Expander

BB567 EXPANDER

- NOTE:** Threads per MIL-S-8879.
- MATERIAL:** PH13-8Mo stainless steel per AMS5629.
- HEAT TREAT:** 125,000 psi shear minimum.
- FINISH:** Dry film lube per MIL-L-6937 (.0002-.0005 thick), and cetyl alcohol lube per Hi-Shear Spec. 305.
- CODE:** Dash number indicates nominal diameter of bolt used in assembly.
- EXAMPLE:** BB567-18 = Expander for use with 9/16 nominal diameter Blind Bolt assembly.

TITLE
BLIND BOLT™ ASSEMBLY
100° COUNTERSUNK AN509 HEAD STYLE
A-286 ALLOY

DRAWN	DATE	APPROVED	DATE	REVISION	DATE	DRAWING NUMBER
D. P. S.	2-15-84	E. E. G.	2-16-84	②	D. P. S.	9-7-88
						BB597

BB597