



BLIND BOLT ASSEMBLY		BB302 CORE BOLT									BB322.32 SLEEVE						BB341 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 0-3/4	B GRIP RANGE 1 1/16-1 1/8	B GRIP RANGE 1 3/4-1 5/8	B GRIP RANGE 1 1/2-2 3/4	D ₁ DIA.	H ₁	DASH NUMBER	D ₂ DIA.	L (LENGTH)	THREAD	HOLE DIA.	CORE BOLT INSTALLATION TORQUE	P ₁	D ₂ DIA. (REF.)
-6	3/16	-6	Phillips #1	.2514 .2466	.1240 .1220	.053 .051	.239	.304	5-40UNJC-3A	-6	.315 .295	.250	—	—	.2180 .2155	.065 .055	-6	.194	.184	5-40UNJC-3B	.223 .219	10 14 IN. LBS.	.239	.271	
-8	1/4	-8	Phillips #2	.3304 .3256	.1650 .1630	.069 .067	.316	.397	8-32UNJC-3A	-8	.412 .387	.315	.330	—	.2810 .2785	.090 .080	-8	.255	.245	8-32UNJC-3B	.288 .281	20 30 IN. LBS.	.316	.354	
-10	5/16	-10	Hi-Torque #3	.4454 .4406	.2180 .2160	.095 .093	.414	.498	12-38UNJF-3A	-10	.505 .475	.380	.400	.420 .440	.3435 .3410	.110 .100	-10	.328	.307	12-28UNJF-3B	.352 .344	50 80 IN. LBS.	.414	.438	

BB302 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: Type 431 stainless steel per Spec. QQ-S-763.
HEAT TREAT: 125,000 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: BB302-8-12 = 8-32 core bolt for 1/4 nominal diameter sleeve, 3/4 mean assembly grip length.

BB322.32 SLEEVE

- GENERAL NOTES:
- Concentricity: Hole to "D₁" diameter within .005 FIR. Head to "D₁" diameter within .010 FIR.
 - "H₁" is dimensioned from maximum "D₁" diameter.

MATERIAL: Type CRES: 305 per QQ-S-763, 302 HQ, or 18-9 LW (ASTM A-493).
FINISH: BB322.32 = Passivate.

CODE: BB322.32P = Cadmium plate per QQ-P-416, Type I, Class 2.
BB322.32PB = Cadmium plate per QQ-P-416, Type II, Class 2.
First dash number indicates nominal diameter of sleeve in 32nds for which this is a 1/32 oversize replacement.
Second dash number indicates mean assembly grip length (thickness of work) in 16ths.
"P" or "PB" indicates plating specification.

EXAMPLE: BB322.32-8-12 = 1/4 nominal diameter sleeve, 3/4 mean assembly grip length.

BB341 EXPANDER

- GENERAL NOTES:
- Threads per MIL-S-8879.
- MATERIAL: Type 431 stainless steel per Spec. QQ-S-763.
HEAT TREAT: 125,000 psi shear minimum.

FINISH: BB341 = Cadmium plate per QQ-P-416, Type I, Class 2.
BB341G = Silver plate per QQ-S-365, Grade B, .0002-.0004 thick.
BB341PB = Cadmium plate per QQ-P-416, Type II, Class 2.
CODE: Dash number indicates nominal diameter of Blind Bolt Assembly in 32nds.
Letters "G" and "PB" indicate type of plating.

EXAMPLE: BB341-8 = 8-32 Expander for use with 1/4 nominal diameter Blind Bolt Assembly.

BB352.32 BLIND 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. "G" after basic assembly number indicates silver plated Expander. Letters "P" or "PB" after basic assembly number indicate type of cadmium plate.

EXAMPLE: BB352.32-8-12
 3/4 Mean Assembly Grip Length
 1/4 Nominal Diameter Blind Bolt Assembly
 Blind Bolt Assembly which includes:
 BB302 Core Bolt, BB322.32 Sleeve, and
 BB341 Expander

BB352.32G-8-12 = As example except with Expander BB341G.
BB352.32P-8-12 = As example except with Sleeve BB322.32P.

TITLE					
BLIND BOLT™ ASSEMBLY PROTRUDING HEAD STYLE 1/32" OVERSIZE					
DRAWN	DATE	APPROVED	DATE	REVISION	DRAWING NUMBER
J COE	2-15-56	Edwards	2-15-56	12	D. P. S. 9-5-86 BB352.32

BB352.32