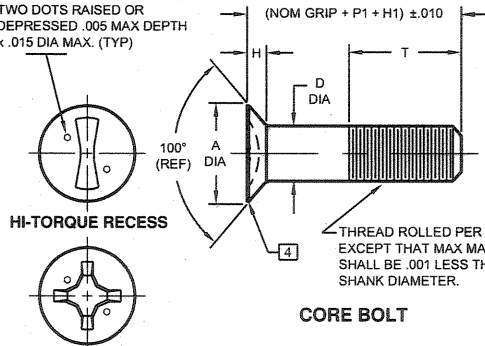
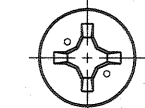


CORE BOLT HEAD MARKING  
TWO DOTS RAISED OR  
DEPRESSED .005 MAX DEPTH  
x .015 DIA MAX. (TYP)

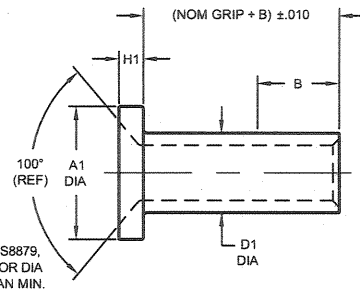


CORE BOLT

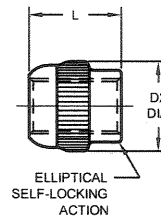
HI-TORQUE RECESS



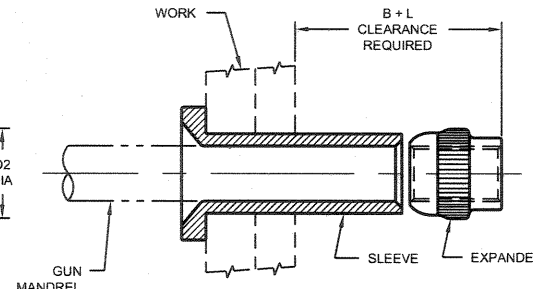
PHILLIPS RECESS



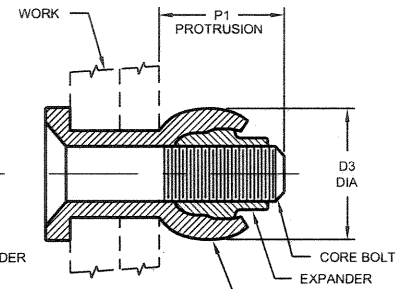
SLEEVE



EXPANDER



SLEEVE AND EXPANDER ASSEMBLED  
ON MANDREL, INSERTED INTO WORK  
READY TO SET.



COMPLETED BLIND BOLT ASSEMBLY  
SHOWING CORE BOLT INSTALLED

BLIND BOLT ASSEMBLY		BB302 CORE BOLT										BB322 SLEEVE					BB341 EXPANDER				SUGGESTED HOLE PREPARATION		PROTRUSION AFTER INSTALLATION		INSTALLATION PRESSURE (psi) USING HI-SHEAR TOOLING			
FIRST DASH NO.	NOM DIA	MIN GRIP	FIRST DASH NO.	RECESS NO.	A DIA	D DIA	H	P1	T (REF)	THREAD	FIRST DASH NO.	A1 DIA	B GRIP RANGE 0-.3/4	B GRIP RANGE 13/16-1 1/16	B GRIP RANGE 1 1/8-1 5/8	B GRIP RANGE 1 11/16-2 1/4	D2 DIA	H1 DIA	FIRST DASH NO.	D2 DIA	L LENGTH	THREAD	HOLE DIA	CORE BOLT INSTALLATION TORQUE IN-LBS.	P1 (REF)	D3 DIA (REF)	BG1750	BG2500
5	5/32	-1	5	Phillips # 1	.2274	.1120	.048	.208	.274	4-40UNJC-3A	5	.294	.210	.225	.265	.305	.169	.055	5	.167	.153	4-40UNJC-3B	.173	10	.208	.210	500	250
					.2226	.1100	.046					.274					.166	.045					.170	8				
6	3/16	-1	6	Phillips # 1	.2514	.1240	.053	.239	.304	5-40UNJC-3A	6	.315	.250	.265	.330	.395	.196	.065	6	.194	.184	5-40UNJC-3B	.201	14	.239	.253	700	350
					.2466	.1220	.051					.295					.193	.055					.197	10				
8	1/4	-2	8	Phillips # 2	.3304	.1650	.069	.316	.397	8-32UNJC-3A	8	.412	.315	.330	.370	.425	.257	.090	8	.255	.245	8-32UNJC-3B	.264	30	.316	.335	1100	650
					.3256	.1630	.067					.387					.254	.080					.258	20				
10	5/16	-2	10	HT # 3	.4454	.2180	.095	.414	.498	12-28UNJF-3A	10	.530	.380	.400	.420	.440	.338	.110	10	.328	.307	12-28UNJF-3B	.345	80	.414	.438	1850	950
					.4406	.2160	.093					.500					.335	.100					.339	50				
12	3/8	-2	12	HT # 4	.5066	.2490	.108	.485	.567	1/4-28UNJF-3A	12	.615	.450	.450	.450	.450	.390	.155	12	.383	.368	1/4-28UNJF-3B	.397	150	.485	.510	-	1450
					.5018	.2470	.106					.580					.387	.145					.391	125				
14	7/16	-4	14	HT # 5	.6335	.3110	.135	.543	.628	5/16-24UNJF-3A	14	.803	.500	.500	.500	.500	.468	.160	14	.458	.429	5/16-24UNJF-3B	.475	220	.543	.600	-	1900
					.6287	.3090	.133					.861					.465	.150					.469	200				
16	1/2	-4	16	HT # 6	.7604	.3740	.162	.600	.685	3/8-24UNJF-3A	16	.896	.550	.550	.550	.550	.530	.185	16	.521	.491	3/8-24UNJF-3B	.539	400	.600	.662	-	2250
					.7556	.3720	.160					.861					.527	.175					.531	380				

**BB302 CORE BOLT**

- NOTE:**
1. Concentricity: Head to "D" diameter within .005 FIM.
  2. Complete thread shall begin within two thread pitches maximum which may consist of incomplete thread and extrusion angle.
  3. "H" is dimensioned from maximum "D" diameter.

**MATERIAL:** Type AISI 431 stainless steel.

**HEAT TREAT:** 125,000 psi shear minimum.

**36 FINISH:** BB302-( ) = Passivate.

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

**EXAMPLE:** BB302-8-12 = 8-32 core bolt for 1/4 nominal diameter sleeve, 3/4 (.750) grip length.

**BB322 SLEEVE**

- NOTE:**
1. Concentricity: Hole to "D1" diameter within .005 FIM. Head to "D1" diameter within .005 FIM.
  2. "H1" is dimensioned from maximum "D1" diameter.

**MATERIAL:** Type CRES: 305 per AMS-QQ-S-763, 302 HQ, or 18-9 LW (ASTM A-493).

**36 FINISH:** BB322-( ) = Passivate.  
BB322P-( ) = Cadmium plate per AMS-QQ-P-416, Type I, Class 2.  
BB322PB-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.

**CODE:** First dash number indicates nominal diameter of sleeve in 32nds.  
Second dash number indicates nominal grip length (thickness of work) in 16ths.  
See "Finish" note for explanation of code letters.

**EXAMPLE:** BB322-8-12 = 1/4 nominal diameter sleeve, 3/4 (.750) grip length.

**BB341 EXPANDER**

**NOTE:** 1. Threads per AS8879.

**MATERIAL:** Type AISI 431 stainless steel.

**HEAT TREAT:** 125,000 psi shear minimum.

**36 FINISH:** BB341-( ) = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.  
BB341DU( ) = Solid film lube per AS5272, Type I.  
BB341G( ) = Silver plate per AMS2410 (.0002-.0004 thick) and cetyl alcohol lube per Hi-Shear Spec. 305.  
BB341GU( ) = Silver plate per AMS2410 (.0002-.0004 thick), no lube.  
BB341PB( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

**CODE:** Dash number indicates diameter of Blind Bolt Assembly in 32nds.  
See "Finish" notes for explanation of code letters.

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

**BB352 BLIND BOLT ASSEMBLY**

**CODE:** First dash number indicates nominal diameter of Blind Bolt Assembly in 32nds.  
Second dash number indicates nominal grip length.  
See "Finish" notes for explanation of code letters.

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

BB352G8-12 = As example, except with BB341G Expander.  
BB352P8-12 = As example, except with BB321 Sleeve.  
BB352PB8-12 = As example, except with BB322PB Sleeve and BB341PB Expander.

**SPECIFICATION:** Product Specification HS396. 36

DRAWN		DATE		TITLE	
Cessna		1-24-55		BLIND BOLT™ ASSEMBLY PROTRUDING HEAD STYLE	
APPROVED		DATE			
G.S.Wing		1-24-55			
REVISION		DATE		DRAWING NUMBER	
36		J.F. Obispo	9-17-07	BB352	

BB352