



BLIND BOLT ASSEMBLY		BB302 CORE BOLT								BB419 SLEEVE						BB346G EXPANDER				SUGGESTED HOLE PREPARATION		PROTRUSION AFTER INSTALLATION	
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 D-X	C	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)	
-5	5/32	-5	.2274 .2226	.1120 .1100	.048 .046	.208	.274	4-40UNJC-3A	-5	.294 .274	.210	.120 .100	.169 .166	.055 .045	-5	.167	.153	4-40UNJC-3B	.173 .170	8 10 IN. LBS.	.208	.210	
-6	3/16	-6	.2514 .2466	.1240 .1220	.053 .051	.239	.304	5-40UNJC-3A	-6	.315 .295	.250	.130 .110	.196 .193	.065 .055	-6	.194	.184	5-40UNJC-3B	.201 .197	10 14 IN. LBS.	.239	.253	
-8	1/4	-8	.3304 .3256	.1650 .1630	.069 .067	.316	.397	8-32UNJC-3A	-8	.412 .387	.315	.155 .135	.257 .254	.090 .080	-8	.255	.245	8-32UNJC-3B	.264 .258	20 30 IN. LBS.	.316	.335	

BB302 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.
4. 4-40 and 5-40 bolts with -1 grip are threaded to head.

MATERIAL: Type AISI 431 stainless steel.

HEAT TREAT: 125 ksi 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: BB302-5-12 = 4-40 Core Bolt for 5/32 nominal diameter sleeve, 3/4 grip length.

BB419 SLEEVE

- NOTE: 1. Concentricity: Hole to "D" diameter within .005 FIR. "D₁" diameter to head within .010 FIR.

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

FINISH: Sandblast.

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

EXAMPLE: BB419-5-12 = 5/32 nominal diameter sleeve, 3/4 grip length.

BB420G 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. "G" after basic assembly number indicates silver plated Expander.

EXAMPLE: BB420G-5-12
 3/4 Grip Length
 5/32 Nominal Diameter
 (Blind Bolt Assembly)
 Blind Bolt Assembly which includes:
 BB302 Core Bolt, BB419 Sleeve, and
 BB346G Expander.

BB346G EXPANDER

- NOTE: 1. Threads per MIL-S-8879.

MATERIAL: Type 17-4PH stainless steel per AMS5643.

HEAT TREAT: 120,000 psi shear minimum.

FINISH: Silver plate per AMS2410C.

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

EXAMPLE: BB346G-5 = 4-40 Expander for use with 5/32 nominal diameter Blind Bolt Assembly.

U.S. Patent 2,959,999. Foreign patents issued.

TITLE							
BLIND BOLT™ ASSEMBLY PROTRUDING HEAD BOLT RETAINING STYLE							
DRAWN	DATE	APPROVED	DATE	REVISION	DATE	DRAWING NUMBER	
<i>RAH</i>	2-17-69	<i>RAH</i>	2-17-69	10	D. P. S. 3-20-79	BB420G	

BB420G