



BLIND BOLT ASSEMBLY		BB454 CORE BOLT								BB322.32 SLEEVE						BB443GA EXPANDER				SUGGESTED HOLE PREPARATION		PROTRUSION AFTER INSTALLATION		
FIRST DASH NUMBER	NOMINAL DIAMETER	FIRST DASH NUMBER	RECESS	A DIA.	D DIA.	H	P <sub>1</sub>	T (REF.)	THREAD	FIRST DASH NUMBER	A <sub>1</sub> DIA.	G GRIP RANGE 0-3/4	E GRIP RANGE 1 1/16-1 1/8	B GRIP RANGE 1 3/4-1 3/8	D <sub>1</sub> DIA.	H <sub>1</sub>	DASH NUMBER	D <sub>2</sub> DIA.	L (LENGTH)	THREAD	J HOLE DIA.	CORE BOLT INSTALLATION TORQUE	P <sub>1</sub>	D <sub>2</sub> DIA. (REF.)
-8	1/4	-8	Phillips #2	.3304 .3256	.1650 .1630	.069 .067	.316	.420 .390	8-32UNJC-3A	-8	.412 .387	.315	.330	—	.2810 .2785	.090 .080	-8	.255	.245	8-32UNJC-3B	.288 .281	20 30 IN. LB.	.316	.354

**BB454 CORE BOLT**

- GENERAL 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: 17-4PH stainless steel per Spec. AMS5643.

HEAT TREAT: Aged at 1150°F ± 15°F for 4 hours. Air cool.

① FINISH: Cetyl alcohol lubricant.

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

EXAMPLE: BB454-8-8 = 8-32 core bolt for 1/4 nominal diameter sleeve, 1/2 assembly grip length.

**BB322.32 SLEEVE**

- GENERAL NOTES: 1. Concentricity: Hole to "D<sub>1</sub>" diameter within .005 FIR.  
"D<sub>1</sub>" diameter to head within .010 FIR.

MATERIAL: Type 305 stainless steel per QQ-S-763.

FINISH: Passivate.

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

EXAMPLE: BB322.32-8-8 = 1/4 nominal diameter sleeve, 1/2 assembly grip length.

**BB443GA EXPANDER**

- GENERAL NOTES: 1. Threads per MIL-S-8879.

MATERIAL: 17-4PH stainless steel per AMS5643.

HEAT TREAT: Aged at 1150°F ± 15°F for 4 hours. Air Cool.

① FINISH: Silver plate per AMS2411, .0003 - .0005 thick, and cetyl alcohol lube per Hi-Shear Spec. 305.

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

EXAMPLE: BB443GA-8 = 8-32 expander for use with 1/4 nominal diameter Blind Bolt Assembly.

**BB444.32 BOLT ASSEMBLY**

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

EXAMPLE: BB444.32-8-8  
 — 1/2 Assembly Grip Length  
 — 1/4 Nominal Diameter Blind Bolt Assembly  
 Blind Bolt Assembly which includes:  
 BB454 Core Bolt, BB322.32 Sleeve,  
 and BB443GA Expander

"Blind Bolt" is a trademark of Hi-Shear Corporation.

TITLE					
BLIND BOLT™ ASSEMBLY PROTRUDING HEAD STYLE GENERAL ELECTRIC SPECIAL					
DRAWN	DATE	APPROVED	DATE	REVISION	DRAWING NUMBER
D. P. S.	10-14-76	<i>[Signature]</i>	10-14-76	2	D. P. S. 9-21-89 BB444.32