



BLIND BOLT ASSEMBLY		BB454 CORE BOLT									BB322.64 SLEEVE						BB443GA EXPANDER				SUGGESTED HOLE PREPARATION		PROTRUSION AFTER INSTALLATION			
FIRST DASH NUMBER	NOMINAL DIAMETER	FIRST DASH NUMBER	RECESS	A DIA.	D DIA.	H	P ₁	T	THREAD	FIRST DASH NUMBER	A ₁ DIA.	B GRIP RANGE 0-%	E GRIP RANGE 1 ¹ / ₁₆ -1 ¹ / ₁₆	B GRIP RANGE 1 ¹ / ₁₆ -1%	E GRIP RANGE 1 ¹ / ₁₆ -2 ¹ / ₁₆	D ₂ DIA.	H ₁	DASH NUMBER	D ₂ DIA.	L (LENGTH)	THREAD	J HOLE DIA.	CORE BOLT INSTALLATION TORQUE	P ₁	D ₂ DIA. (REF.)	
-6	3/16	-6	Phillips	.2514 .2466	.1240 .1220	.053 .051	.239	.310 .290	5-40UNJC-3A	-6	.315 .295	.250	—	—	—	.203 .200	.065 .055	-6	.194	.184	5-40UNJC-3B	.208 .204	10 14	IN. LBS.	.239	.253

BB454 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.

MATERIAL: 17-4PH stainless steel per Spec. AMS5643.
HEAT TREAT: Aged at 1150°F ± 15°F for 4 hours. Air cool.
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: BB454-6-5 = 5-40 core bolt for 3/16 nominal diameter sleeve, 5/16 assembly grip length.

BB322.64 SLEEVE

GENERAL NOTES:

- Concentricity: Hole to "D₁" diameter within .005 FIR. "D₁" 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: BB322.64-6-5 = 3/16 nominal diameter sleeve, 5/16 assembly grip length.

BB443GA EXPANDER

GENERAL NOTES:

- 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.
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-6 = 5-40 expander for use with 3/16 nominal diameter Blind Bolt Assembly.

BB444.64 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: BB444.64-6-5
 — 5/16 Assembly Grip Length
 — 3/16 nominal diameter Blind Bolt Assembly
 — Blind Bolt Assembly which includes: BB454 Core Bolt, BB322.64 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
<i>D. P. S.</i>	3-1-72	<i>D. P. S.</i>	3-3-72	①	BB444.64
				D. P. S.	9-21-89