



| BLIND BOLT ASSEMBLY | | BB302 CORE BOLT | | | | | | | | BB320 SLEEVE | | | | | | BB406G 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 1/4-1 3/8 | B GRIP RANGE 1 1/2-2 1/4 | 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.) |
| -5 | 5/32 | -5 | Phillips | .2274 .2226 | .1120 .1100 | .048 .046 | .208 | .274 | 4-40UNJC-2A | -5 | .294 .274 | .210 | .225 | — | — | .156 .153 | .055 .045 | -5 | .154 | .153 | 4-40UNJC-3B | .160 .157 | 8 10 IN. LBS. | .208 | .200 |

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 corrosion-resistant steel per QQ-S-763.
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.

BB320 SLEEVE

GENERAL NOTES:

- Concentricity: Hole to "D₁" diameter within .005 FIR. Head to "D₁" diameter within .010 FIR.

© MATERIAL: Type CRES: 305 per QQ-S-763, 302 HQ, or 18-9 LW (ASTM A-493).
HEAT TREAT: Anneal.
FINISH: Abrasive clean.
CODE: First dash number indicates nominal diameter of sleeve in 32nds.
Second dash number indicates grip length (thickness of work) in 16ths.

EXAMPLE: BB320-5-12 = 5/32 nominal diameter sleeve, 3/4 grip length.

BB406G EXPANDER

GENERAL NOTES:

- Threads per MIL-S-8879.

MATERIAL: Type 17-4PH corrosion-resistant steel per AMS5643.
HEAT TREAT: 120,000 psi shear minimum.
FINISH: Silver plate per AMS2410.
CODE: Dash number indicates nominal diameter of Blind Bolt Assembly in 32nds.

EXAMPLE: BB406G-5 = 4-40 Expander for use with 5/32 nominal diameter Blind Bolt Assembly.

BB515G 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: BB515G-5-12

- 5/32 Grip Length
- 5/32 Nominal Diameter

Blind Bolt Assembly which includes:
BB302 Core Bolt, BB320 Sleeve, and BB406G Expander

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

| TITLE | | | | | | | |
|-----------------------|---------|----------|---------|----------|------|---------------------|--------|
| BLIND BOLT™ ASSEMBLY | | | | | | | |
| PROTRUDING HEAD STYLE | | | | | | | |
| DRAWN | DATE | APPROVED | DATE | REVISION | DATE | DRAWING NUMBER | |
| RKA | 4/23/65 | RWT | 4-23-65 | 10 | | D. P. S. 3-20-79 | BB515G |

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