



BLIND BOLT ASSEMBLY			BB302 CORE BOLT						BB320 SLEEVE						BB406G EXPANDER						SUGGESTED HOLE PREPARATION		PROTRUSION AFTER INSTALLATION				
FIRST NUMBER	NOMINAL DIAMETER		FIRST NUMBER	RECESS	A DIA.	D DIA.	H	P ₁	T (REF.)	THREAD	FIRST DASH NUMBER	A ₁ DIA.	G ₁ GRIP RANGE 0- ¹ / ₁₆	G ₂ GRIP RANGE ¹ / ₁₆ to ¹ / ₈	G ₃ GRIP RANGE 1 ¹ / ₁₆ -1 ¹ / ₂	G ₄ GRIP RANGE 1 ¹ / ₂ to2 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-5A	-5	.294 .274	.210	.225	—	—	—	.156 .153	.055 .045	-5	.154	.153	4-40UNJC-3B	.160 .157	8 IN. LBS. 10	.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 "D" 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.
BB320-5-12 = 5/32 nominal diameter sleeve, 3/4 grip length.

EXAMPLE:

BB406G EXPANDER

GENERAL NOTES:

- Threads per MIL-S-3879.

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.
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 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		DATE APPROVED		DATE REVISION		DATE DRAWING NUMBER	
PROTRUDING HEAD STYLE		RKH 1/23/65		4-23-65		BB515G	
DRAWN		DATE		D. P. S.		8-20-79	