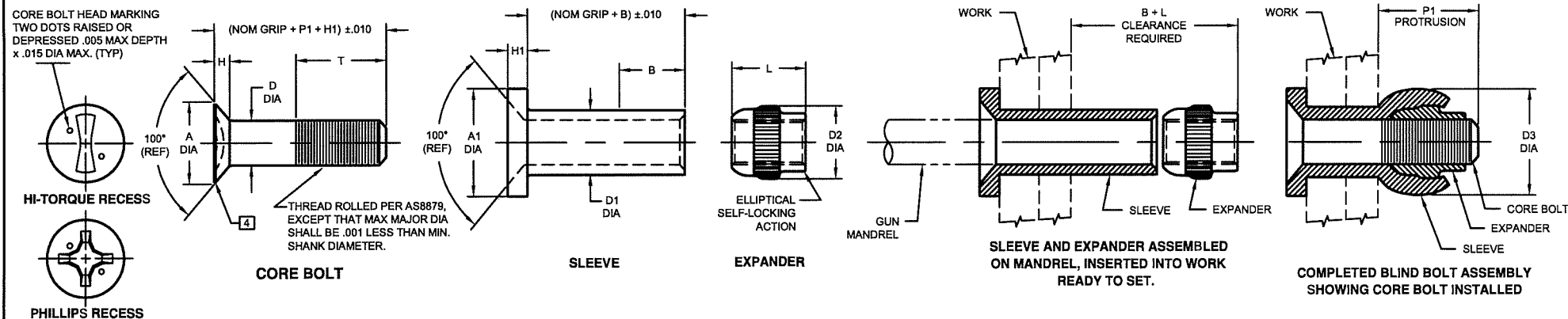




BLIND BOLT ASSEMBLY			BB302 CORE BOLT								BB322 SLEEVE								BB341 EXPANDER				SUGGESTED HOLE PREPARATION		PROTRUSION AFTER INSTALLATION		INSTALLATION PRESSURE (psi) USING HI-SHEAR TOOLING	
FIRST DASH NO.	NOM DIA	MIN GRIP	FIRST DASH NO.	RECESS NO.	A DIA	D DIA	H	P1	T (REF)	THREAD	FIRST DASH NO.	A1 DIA	B GRIP RANGE 0 - 3/4	B GRIP RANGE 13/16 - 1 1/16	B GRIP RANGE 1 1/8 - 1 5/8	B GRIP RANGE 1 11/16 - 2 1/4	(37) D1 DIA	H1 DIA	FIRST DASH NO.	D2 DIA	L LENGTH	THREAD	HOLE DIA	CORE BOLT INSTALLATION TORQUE IN-LBS.	P1 (REF)	D3 DIA (REF)	BG1750	BG2500
5	5/32	-1	5	Phillips # 1	.2274 .2226	.1120 .1100	.048 .046	.208	.274	4-40UNJC-3A	5	.294 .274	.210	.225	.265	.305	.169 .166	.055 .045	5	.167	.153	4-40UNJC-3B	.173 .170	10 8	.208	.210	500	250
6	3/16	-1	6	Phillips # 1	.2514 .2466	.1240 .1220	.053 .051	.239	.304	5-40UNJC-3A	6	.315 .295	.250	.265	.330	.395	.196 .193	.065 .055	6	.194	.184	5-40UNJC-3B	.201 .197	14 10	.239	.253	700	350
8	1/4	-2	8	Phillips # 2	.3304 .3256	.1650 .1630	.069 .067	.316	.397	8-32UNJC-3A	8	.412 .387	.315	.330	.370	.425	.257 .254	.090 .080	8	.255	.245	8-32UNJC-3B	.264 .258	30 20	.316	.335	1100	650
10	5/16	-2	10	HT # 3	.4454 .4406	.2180 .2160	.095 .093	.414	.498	12-28UNJF-3A	10	.530 .500	.380	.400	.420	.440	.338 .335	.110 .100	10	.328	.307	12-28UNJF-3B	.345 .339	80 50	.414	.438	1850	950
12	3/8	-2	12	HT # 4	.5066 .5018	.2490 .2470	.108 .106	.485	.567	1/4-28UNJF-3A	12	.615 .580	.450	.450	.450	.450	.390 .387	.155 .145	12	.383	.368	1/4-28UNJF-3B	.397 .391	150 125	.485	.510	-	1450
14	7/16	-4	14	HT # 5	.6335 .6287	.3110 .3090	.135 .133	.543	.628	5/16-24UNJF-3A	14	.803 .768	.500	.500	.500	.500	.468 .465	.160 .150	14	.458	.429	5/16-24UNJF-3B	.475 .469	220 200	.543	.600	-	1900
16	1/2	-4	16	HT # 6	.7604 .7556	.3740 .3720	.162 .160	.600	.685	3/8-24UNJF-3A	16	.896 .861	.550	.550	.550	.550	.530 .527	.185 .175	16	.521	.491	3/8-24UNJF-3B	.539 .531	400 380	.600	.662	-	2250

BB302 CORE BOLT

- NOTE:**
1. Concentricity: Head to "D" diameter within .005 FIM.
 2. Complete thread shall begin within two thread pitches maximum which may consist of incomplete thread and extrusion angle.
 3. "H" is dimensioned from maximum "D" diameter.
 4. Curved or flat edge, manufacturer's option.

MATERIAL: Type AISI 431 stainless steel.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: BB302(-)(-) = Passivate.

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

EXAMPLE: BB302-8-12 = 8-32 core bolt for 1/4 nominal diameter sleeve, 3/4 (.750) grip length.

BB322 SLEEVE

- NOTE:**
1. Concentricity: Hole to "D1" diameter within .005 FIM. Head to "D1" diameter within .005 FIM.
 2. "H1" is dimensioned from maximum "D1" diameter.

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

FINISH: BB322(-)(-) = Passivate.
BB322P(-)(-) = Cadmium plate per AMS-QQ-P-416, Type I, Class 2.
BB322PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.

CODE: First dash number indicates nominal diameter of sleeve in 32nds.
Second dash number indicates nominal grip length (thickness of work) in 16ths.
See "Finish" note for explanation of code letters.

EXAMPLE: BB322-8-12 = 1/4 nominal diameter sleeve, 3/4 (.750) grip length.

BB341 EXPANDER

NOTE: 1. Threads per AS8879.

MATERIAL: Type AISI 431 stainless steel.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: BB341(-) = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
BB341DU(-) = Solid film lube per AS5272, Type I.
BB341G(-) = Silver plate per AMS2410 (.0002-.0004 thick) and cetyl alcohol lube per Hi-Shear Spec. 305.
BB341GU(-) = Silver plate per AMS2410 (.0002-.0004 thick), no lube.
BB341PB(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

CODE: Dash number indicates diameter of Blind Bolt Assembly in 32nds.
See "Finish" notes for explanation of code letters.

EXAMPLE: BB341-8 = 8-32 Expander for use with 1/4 nominal diameter Blind Bolt Assembly.

BB352 BLIND BOLT ASSEMBLY

CODE: First dash number indicates nominal diameter of Blind Bolt Assembly in 32nds.
Second dash number indicates nominal grip length.
See "Finish" notes for explanation of code letters.

EXAMPLE: BB352-8-12
└─ 3/4 Grip Length
└─ 1/4 Nominal Diameter Blind Bolt Assembly
Blind Bolt Assembly which includes:
BB302 Core Bolt, BB322 Sleeve, and BB341 Expander.

BB352G8-12 = As example, except with BB341G Expander.
BB352P8-12 = As example, except with BB321 Sleeve.
BB352PB8-12 = As example, except with BB322PB Sleeve and BB341PB Expander.

SPECIFICATION: Product Specification HS396.

DRAWN	DATE	TITLE
Cessna	1-24-55	BLIND BOLT™ ASSEMBLY PROTRUDING HEAD STYLE
APPROVED	DATE	
G.S.Wing	1-24-55	
REVISION	DATE	DRAWING NUMBER
(37)	J.F.Obispo 4-23-13	BB352