

The diagram illustrates the Core Bolt Assembly process through four main stages:

- CORE BOLT:** Shows two views of the bolt head: "PHILLIPS" RECESS and "HI-TORQUE" RECESS. The shank is threaded with a diameter of D DIA. and a length of $L = \text{GRIP} + P_1 + H_1 \pm .010$. The thread is rolled per MIL-S-7742, except for the maximum major diameter, which shall be .001 less than the minimum shank diameter. The head has a diameter of A DIA. and a height of H . The thread length is T (REF.).
- SLEEVE:** A cylindrical sleeve with an inner diameter of A_1 DIA. and an outer diameter of D_1 DIA. The length is B (REF.).
- EXPANDER:** A small cylindrical component with a length of L and a diameter of D_2 DIA. It features an "ELLIPTICAL SELF-LOCKING ACTION".
- SLEEVE AND EXPANDER ASSEMBLED ON MANDREL, INSERTED INTO WORK:** Shows the sleeve and expander being inserted into a workpiece. The sleeve has a length of $B + L$ and a clearance required. The workpiece has a diameter of D_2 DIA. (REF.).
- COMPLETED BUND BOLT ASSEMBLY SHOWING CORE BOLT INSIDE:** The final assembly showing the core bolt inside the sleeve, which is now expanded and locked into the workpiece. The sleeve has a length of P_1 and a protrusion (REF.). The core bolt has a diameter of D_2 DIA. (REF.).

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