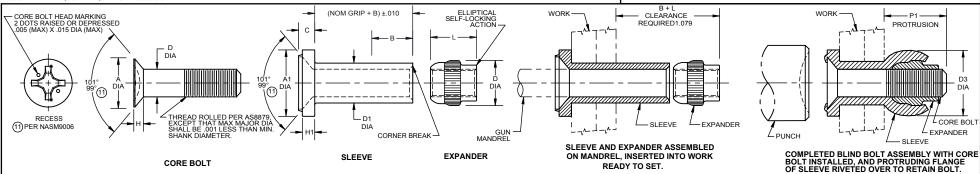
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EXPANDER

	ND BOLT SEMBLY	BB302 CORE BOLT							BB419 SLEEVE						BB346G EXPANDER				SUGGESTED HOLE PREPARATION		PROTRUSION AFTER INSTALLATION	
FIRST DASH NUMBER	NOMINAL DIAMETER	FIRST DASH NUMBER	A DIA	D DIA	Н	P1	T (REF)	THREAD	FIRST DASH NO.	A1 DIA	B GRIP RANGE 0 - 3/4	С	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)
-5	5/32	-5	.2274 .2226		.048 .046		.274	.1120-40 UNJC-3A	-5	.294 .274	.210	.120 .100	.169 .166	.055 .045	-5	.167	.153	.1120-40 UNJC-3B	.173 .170	8 10	.208	.210
-6	3/16	-6	.2514 .2466			.239	.304	.1250-40 UNJC-3A	-6	.315 .295	.250	.130 .110	.196 .193	.065 .055	-6	.194	.184	.1250-40 UNJC-3B	.201 .197	10 14	.239	.253
-8	1/4	-8	.3304 .3256			.316	.397	.1640-32 UNJC-3A	-8	.412 .387	.315	.155 .135	.257 .254	.090 .080	-8	.255	.245	.1640-32 UNJC-3B	.264 .258	20 30	.316	.335
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BB302 CORE BOLT

NOTE: 1. Concentricity: Head to "D" diameter within .005 FIM.

2. Complete thread shall begin within two thread pitches maximum. Two thread pitch maximum may consist of incomplete thread and extrusion angle.

CORE BOLT

3. "H" is dimensioned from maximum "D" diameter.

4. 4-40 and 5-40 bolts with -1 grip are threaded to head...

MATERIAL: Type AISI 431 stainless steel

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.

BB419 SLEEVE

SLEEVE

NOTE: 1. Concentricity: Hole to "D" diameter within .005 FIM. Hole to "D1" diameter within .010 FIM.

MATERIAL: Type CRES: 305 per AMS-QQ-S-763, 302 HQ, or 18-9 LW

(ASTM A-493).

FINISH: Sandblast.

CODE: First dash number indicates nominal diameter of sleeve in 32nds. Second dash number indicates grip length (thickness

EXAMPLE: BB419-5-12 = 5/32 nominal diameter sleeve, 3/4 grip length.

BB346G EXPANDER

ON MANDREL, INSERTED INTO WORK

READY TO SET.

NOTE: Threads per AS8879.

MATERIAL: Type 17-4PH stainless stell per AMS5643.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: Silver plate per AMS2410C.

Dash number indicates nominal diameter of Blind Bolt Assembly in 32nds.

EXAMPLE: BB346G-5 = 4-40 Expander for use with 5/32 nominal diameter Blind Bolt

Assembly

BB420G BLIND BOLT ASSEMBLY

CODE: First dash number indicates nominal diameter of Blind Bolt

Assembly in 32nds. Second dash number indicates nominal grip (thickness of work) in 16ths. "G" after basic assembly number

indicates silver plated Expander.

EXAMPLE: BB420G-5-12

└─ 3/4 Grip Length - 5/32 Nominal Diameter (Blind Bolt Assembly)

Blind Bolt Assembly which includes:

BB302 Core Bolt, BB419 Sleeve, and BB346G Expander.

BB IS A TRADEMARK OF HI-SHEAR CORPORATION

DRAWN BY DATE TITLE RKL 1969-02-17 BLIND BOLT™ ASSEMBLY PROTRUDING HEAD APPROVED DATE RWL RETAINING STYLE 1969-02-17 F.CARINGELL

BB420G

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