



BLIND BOLT ASSEMBLY		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	H	P1	T (REF)	THREAD	FIRST DASH NO.	A1 DIA	B GRIP RANGE 0 - 3/4	C	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	.1120	.048	.208	.274	.1120-40	-5	.294	.210	.120	.169	.055	-5	.167	.153	.1120-40	.173	8	.208	.210
			.2226	.1100	.046	UNJC-3A	.274	.100		.166		.045	UNJC-3B	.170		10						
-6	3/16	-6	.2514	.1240	.053	.239	.304	.1250-40	-6	.315	.250	.130	.196	.065	-6	.194	.184	.1250-40	.201	10	.239	.253
			.2466	.1220	.051	UNJC-3A	.295	.110		.193		.055	UNJC-3B	.197		14						
-8	1/4	-8	.3304	.1650	.069	.316	.397	.1640-32	-8	.412	.315	.155	.257	.090	-8	.255	.245	.1640-32	.264	20	.316	.335
			.3256	.1630	.067	UNJC-3A	.387	.135		.254		.080	UNJC-3B	.258		30						

BB302 CORE BOLT

- NOTE:**
- Concentricity: Head to "D" diameter within .005 FIM.
 - Complete thread 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.
 - 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

- NOTE:**
- 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 of work) in 16ths.

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

BB346G EXPANDER

- NOTE:**
- Threads per AS8879.

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

HEAT TREAT: 125,000 psi shear minimum.

FINISH: Silver plate per AMS2410C.

CODE: 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		TITLE BLIND BOLT™ ASSEMBLY PROTRUDING HEAD RETAINING STYLE	
DRAWN BY RKL	DATE 1969-02-17	APPROVED RWL	DATE 1969-02-17
REVISION 11	DATE F.CARINGELLA 2019-07-15	DRAWING NUMBER BB420G	