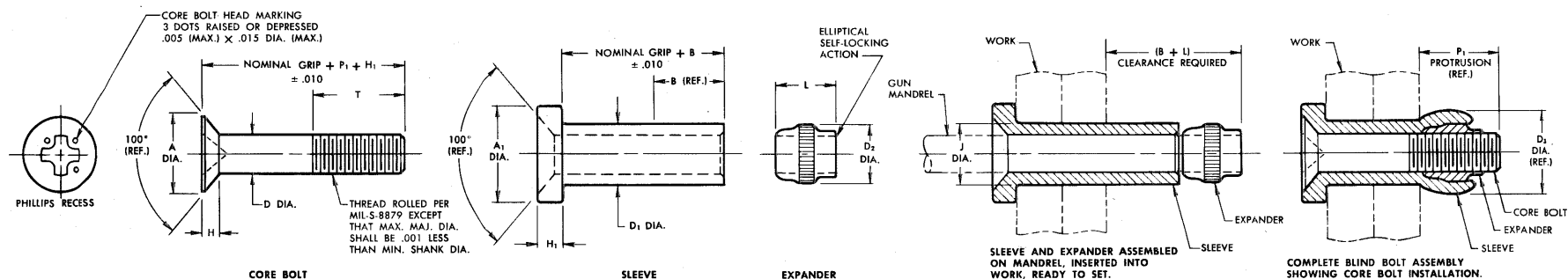


**hi-shear**  
CORPORATION

2600 SKYPARK DRIVE  
TORRANCE, CALIFORNIA 90509  
AREA CODE 213 • 775-3181 • 326-8110



BLIND BOLT ASSEMBLY		BB454 CORE BOLT								BB322 SLEEVE								BB443GA EXPANDER				SUGGESTED HOLE PREPARATION		PROTRUSION AFTER INSTALLATION		INSTALLATION PRESSURE (psi) USING HI-SHEAR TOOLING	
FIRST DASH NUMBER	NOMINAL DIAMETER	FIRST DASH NUMBER	RECESS	A DIA.	D DIA.	H	P <sub>1</sub>	T	THREAD	FIRST DASH NUMBER	A <sub>1</sub> DIA.	G GRIP RANGE 0-3/4	G GRIP RANGE 3/4-1 1/16	G GRIP RANGE 1 1/16-1 3/8	G GRIP RANGE 1 3/8-2 1/4	D <sub>1</sub> DIA.	H <sub>1</sub>	DASH NUMBER	D <sub>2</sub> DIA.	L (LENGTH)	THREAD	J HOLE DIA.	CORE BOLT INSTALLATION TORQUE	P <sub>1</sub>	D <sub>2</sub> DIA. (REF.)	BG1750	BG2500
-5	5/32	-5	Phillips	.2274 .2226	.1120 .1100	.048 .046	.208	.280 .260	4-40UNJC-3A	-5	.294 .274	.210	—	—	—	.169 .166	.055 .045	-5	.167	.153	4-40UNJC-3B	.173 .170	8 10 IN. LBS.	.208	.210	500	250

#### BB454 CORE BOLT

- GENERAL NOTES:
1. Concentricity: Head to "D" diameter within .005 FIR.
  2. Complete threads shall begin within two thread pitches maximum. Two thread pitch maximum may consist of incomplete thread and extrusion angle.
  3. "H" is dimensioned from maximum "D" diameter.

MATERIAL: 17-4PH stainless steel per AMS5643.

HEAT TREAT: Aged at 1150°F ±15° for 4 hours; air cool.

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: BB454-5-3 = 4-40 core bolt for 5/32 nominal diameter sleeve, 3/16 grip length.

#### BB322 SLEEVE

- GENERAL NOTES:
1. Concentricity: Hole to "D" diameter within .005 FIR. "D<sub>1</sub>" diameter to head within .010 FIR.

MATERIAL: Type 305 stainless steel per QQ-S-763.

FINISH: Passivate.

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

EXAMPLE: BB322-5-3 = 5/32 nominal diameter sleeve, 3/16 grip length.

#### BB443GA EXPANDER

- GENERAL NOTES:
1. Threads per MIL-S-8879.

MATERIAL: 17-4PH stainless steel per AMS5643.

HEAT TREAT: Aged at 1150°F ±15° for 4 hours; air cool.

FINISH: Silver plate per AMS2411, .0002-.0004 thick.

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

EXAMPLE: BB443GA-5 = 4-40 expander for use with 5/32 nominal diameter Blind Bolt Assembly.

#### BB444 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.

EXAMPLE: BB444-5-3

— 3/16 Grip Length  
— 5/32 Nominal Diameter Blind Bolt Assembly  
Blind Bolt Assembly which includes:  
BB454 Core Bolt, BB322 Sleeve, and  
BB443GA Expander

U.S. Patent 2,959,999. Foreign patents issued.

TITLE					
BLIND BOLT™ ASSEMBLY					
PROTRUDING HEAD STYLE					
GENERAL ELECTRIC SPECIAL					
DRAWN	DATE	APPROVED	DATE	REVISION	DATE
Phoebe 3-1-72		J. Sunderson	3-2-72	○	
					BB444

CODE IDENTIFICATION NO. 73197

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BB444