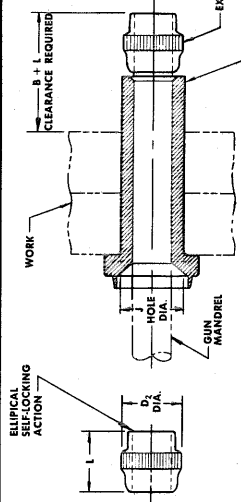


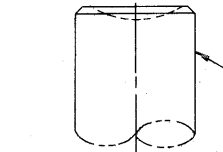
**SCORE BOARD**

CORE BOLT HEAD MARKING  
3 DOTS RAISED OR DEPRESSED  
005 (MAX) X .015 DIA (MAX)

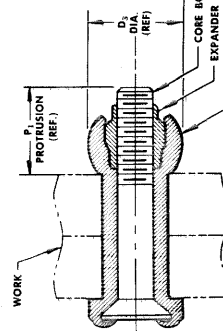


**EXPANDED**

**SLEEVE AND EXPANDER ASSEMBLED  
ON MANDREL, INSERTED INTO WORK,  
READY TO SET**



COMPLETE BLIND BOLT ASSEMBLY WITH CORE BOLT INSTALLED, AND PROTRUDING FLANGE OF SLEEVE RIVETED OVER TO RETAIN BOLT



COMPLETE

COMPLETE  
BOLT INSTAN  
OF SLEEVE

[illegible]

## BB457 CORE BOLT

- NOTES:
1. Concentricity: Head to "D" diameter within .005 TIR.
  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 "I" diameter.

**MATERIAL:** Type INCO 718 stainless steel per AMS5662.

HEAT TREAT: 120,000 psi 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: BB457-5-12 = 4-40 Core Bolt for 5/32 nominal diameter sleeve. 3/4 grip length.

## 3B458 ST.EEVE

- NOTE: 1. Concentricity: Hole to "D" diameter within .005 TIR.  
"D<sub>1</sub>" diameter to head within .010 TIR.

**MATERIAL:** Type INCO 625 stainless steel per AMS5666.

**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:** BB458-5-12 = 5/32 nominal diameter sleeve, 3/4 grip length.

## BB455 EXPANDER

- NOTE: 1. Threads per MIL-S-7742.

**MATERIAL:** Type INCO 718 stainless steel per AMS5662.

HEAT TREAT: 120,000 psi shear minimum.

**FINISH:** Silver plate per AMS2410C.

**FINISH:** Silver plate per AMS2410C.

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

**EXAMPLE:** BB455-5 = 4-40 Expander for use with 5/32 nominal diameter Blind Bolt Assembly.

## BB456 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:**

|                                                   |                |                                              |
|---------------------------------------------------|----------------|----------------------------------------------|
| BP456-5-12                                        | └───┐<br>└───┘ | 3/4 Grip Length<br><br>5/32 Nominal Diameter |
| <b>Blind Bolt Assembly which includes:</b>        |                |                                              |
| BP457 Core Bolt, BP458 Sleeve, and BP459 Expander |                |                                              |

U.S. Patents 2,789,619; 2,946,208; and 2,959,999.  
Foreign patents granted and pending.

| TITLE                                                                  | DATE |
|------------------------------------------------------------------------|------|
| BLIND BOLT ASSEMBLY<br>T.M.<br>PROTRUDING HEAD BOLT<br>RETAINING STYLE |      |

| DRAWN | DATE    | APPROVED           | DATE    | REVISION | DATE | DRAWING NUMBER |
|-------|---------|--------------------|---------|----------|------|----------------|
| APB   | 8-14-78 | <i>[Signature]</i> | 8-14-78 |          |      | BB 456         |