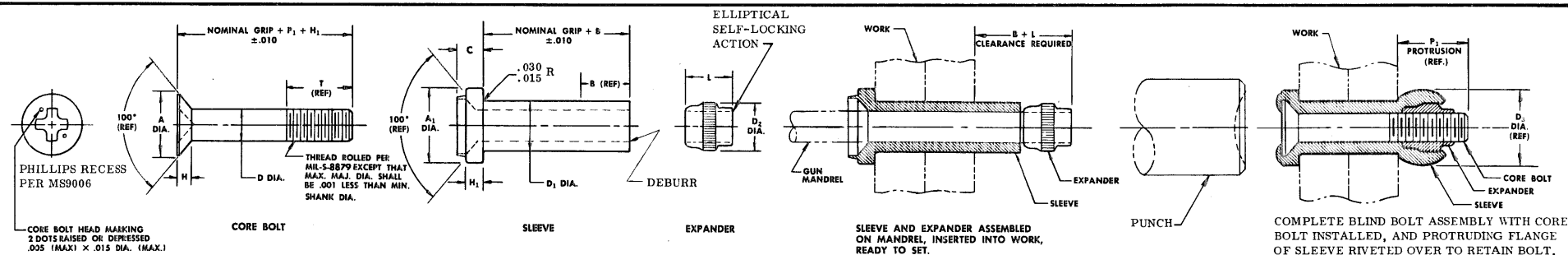




2600 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90509
AREA CODE 213 • 775-3181 • 326-8110



BLIND BOLT ASSEMBLY		BB302 CORE BOLT								BB576 SLEEVE								BB346G EXPANDER				SUGGESTED HOLE PREPARATION		PROTRUSION AFTER INSTALLATION	
FIRST DASH NUMBER	NOMINAL DIAMETER	FIRST DASH NUMBER		A DIA.	D DIA.	H	P ₁	T (REF)	THREAD	FIRST DASH NUMBER	A ₁ DIA.	B GRIP RANGE 0-¾		C		D ₁ DIA.	H ₁	DASH NUMBER	D ₂ DIA.	L (LENGTH)	THREAD	J HOLE DIA.	CORE BOLT INSTALLATION TORQUE	P ₁	D ₂ DIA. (REF)
-5	5/32	-5		.2274 .2226	.1120 .1100	.048 .046	.208	.274	4-40UNJC-3A	-5	.294 .274	.210		.120 .100		.179 .176	.055 .045	-5	.167	.153	4-40UNJC-3B	.173 .170	8 10 IN. LBS.	.208	.210

BB302 CORE BOLT

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

MATERIAL: Type AISI 431 stainless steel.

HEAT TREAT: 125,000 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: BB302-5-12 = 4-40 Core Bolt for 5/32 nominal diameter sleeve, 3/4 grip length.

BB576 SLEEVE

- NOTE: 1. Concentricity: Hole to "D" diameter within .005 FIR.
"D₁" diameter to head within .010 FIR.

② MATERIAL: Type CRES: 305 per 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: BB576-5-12 = 5/32 nominal diameter sleeve, 3/4 grip length.

BB346G EXPANDER

- NOTE: 1. Threads per MIL-S-8879.

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

HEAT TREAT: 120,000 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.

BB575 BOLT ASSEMBLY

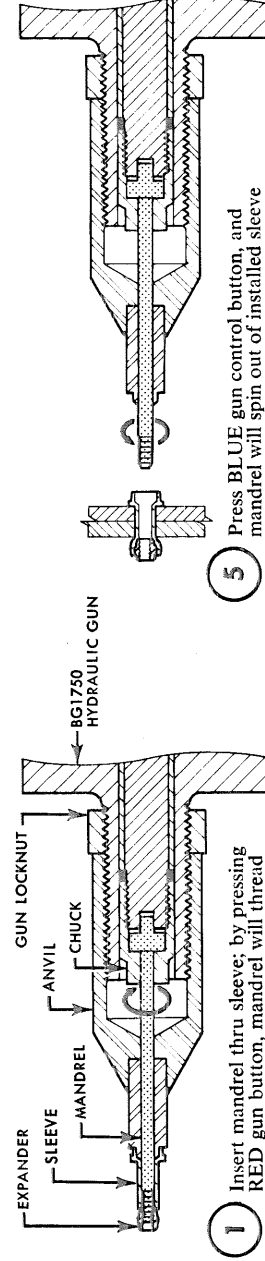
CODE: First dash number indicates nominal diameter of Blind Bolt Assembly in 32nds. Second dash number indicates grip length (thickness of work) in 16ths.

EXAMPLE: BB575-5-12
 3/4 Grip Length
 5/32 Nominal Diameter
 (Blind Bolt Assembly)
 Blind Bolt Assembly which includes:
 BB302 Core Bolt, BB576 Sleeve, and
 BB346G Expander.

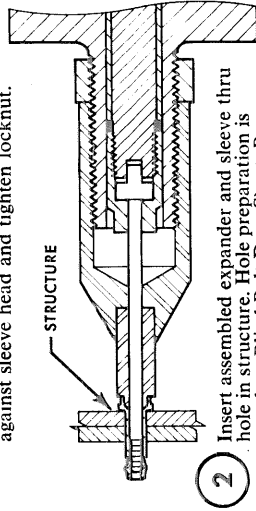
U.S. Patents 2,789,619; 2,946,208; and 2,959,999.
Foreign patents granted and pending.

TITLE					
BLIND BOLT™ ASSEMBLY PROTRUDING HEAD BOLT RETAINING STYLE .010 OVERSIZE					
Sheet 1 of 2					
DRAWN	DATE	APPROVED	DATE	REVISION	DATE
D. P. S.	4-23-76	<i>Amerson</i>	4-23-76	②	3-20-79
BB575					

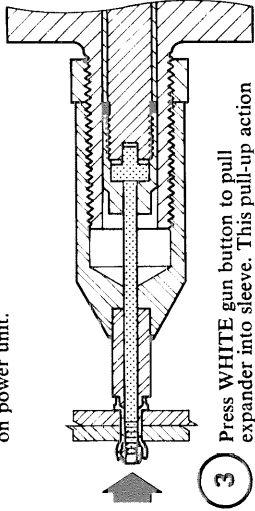
TOOLING & INSTALLATION PROCEDURE FOR INSTALLING BLIND BOLT™ ASSEMBLY



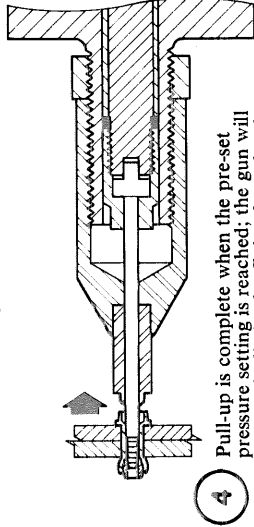
- 1 Insert mandrel thru sleeve; by pressing RED gun button, mandrel will thread into expander. To adjust the anvil to the correct sleeve length, spin anvil to seat against sleeve head and tighten locknut.



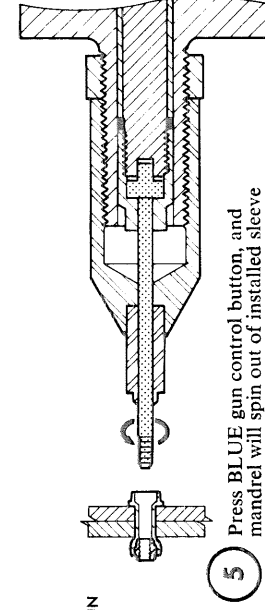
- 2 Insert assembled expander and sleeve thru hole in structure. Hole preparation is noted on Blind Bolt Data Sheet. Be sure correct hydraulic driving pressure is set on power unit.



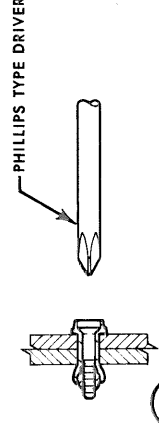
- 3 Press WHITE gun button to pull expander into sleeve. This pull-up action locks sleeve into structure, and swells the sleeve walls to tightly fill the hole.



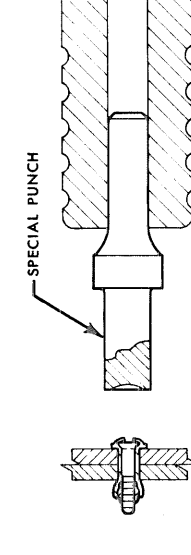
- 4 Pull-up is complete when the pre-set pressure setting is reached; the gun will automatically back off the sleeve head when the cycle is completed.



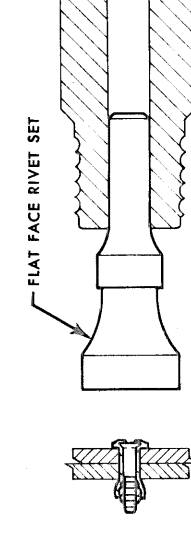
- 5 Press BLUE gun control button, and mandrel will spin out of installed sleeve and expander.



- 6 Insert core bolt into sleeve and expander, and tighten to torque limit noted on Blind Bolt Data Sheet.



- 7 Use special punch listed below and standard rivet gun to crimp over flange to retain core bolt.



- 8 Finish crimping operation by hitting with flat face rivet set or equivalent. Installation of Blind Bolt Assembly is now complete.

PART NUMBER ORDER CHART

BLIND BOLT ASSEMBLY		DRIVING TOOLS			CORE BOLT DRIVER	PUNCH		HYDRAULIC GUN	POWER UNITS			
FIRST DASH NO.	NOM. DIA.	ANVIL	CHUCK	MANDREL		.498 SHANK	.401 SHANK		AIR-HYDRAULIC	ELECTRIC-HYDRAULIC	AIR-HYDRAULIC	HAND-HYDRAULIC
-5	5/32	A43-5	C1-5	M1-5	Phillips #1	BBP1-5	BBP2-5	BG1750	BP3000	BP4000	BP7000	BG25A

NECESSARY ITEMS FOR A COMPLETE INSTALLATION ASSEMBLY:

- 1 Anvil
- 1 Chuck
- 1 Mandrel
- 1 Core Bolt Driver
- 1 Punch
- 1 Hydraulic Gun
- 1 Rivet Gun
- 1 Flat Face Rivet Set or Equivalent
- 1 Power Unit
- 110V Electrical Outlet (For Using BP4000 Power Unit Only)
- 90 psi Air Supply (For Using BP3000 and BP7000 Power Units)



2600 Skypark Drive, Torrance, California 90509
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BB575

Sheet 2 of 2