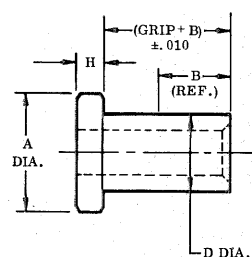


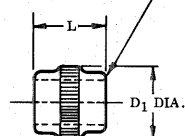
hi-shear
CORPORATION

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

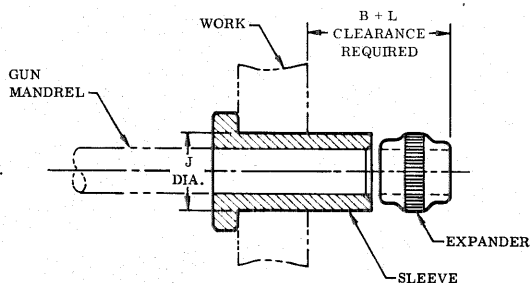


SLEEVE

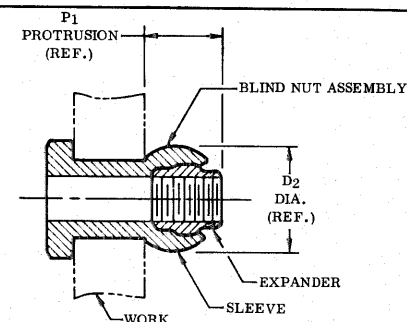
ELLIPTICAL SELF-LOCKING ACTION



EXPANDER



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



COMPLETED BLIND NUT ASSEMBLY

BLIND NUT ASSEMBLY		BN326 AND BN326PB SLEEVE							BB500, BB500G AND BB500PB EXPANDER				HOLE PREPARATION			PROTRUSION AFTER INSTALLATION		
FIRST DASH NUMBER		FIRST DASH NUMBER	A DIA.	S GRIP RANGE 0-1/4	S GRIP RANGE 1/4-1 1/4	S GRIP RANGE 1 1/4-1 3/4	D DIA.	H	PART NUMBER	D1 DIA.	L	THREAD	J HOLE DIA.			D2 DIA.	P1	
-440		-440	.294 .274	.210			.169 .167	.055 .045	BB500-5	.167	.141	4-40UNC-3B	.173 .170			.210	.175	
-632		-632	.315 .295	.280			.218 .216	.065 .055	BB500-632	.217	.180	6-32UNC-3B	.222 .219			.285	.210	
-832		-832	.412 .387	.315	.330		.257 .255	.090 .080	BB500-8	.255	.205	8-32UNC-3B	.264 .258			.335	.247	
-1024		-1032	.505 .475	.380	.420	.460	.312 .309	.110 .100	BB500-1024	.309	.240	10-24UNC-3B	.319			.410	.283	
		-1032							BB500-1032			10-32UNF-3B	.313					
-420		-428	.615 .580	.450	.450	.450	.390 .387	.155 .145	BB500-420	.383	.300	1/4-20UNC-3B	.397			.510	.343	
		-428							BB500-12			1/4-28UNF-3B	.391					
-518		-524	.803 .768	.500	.500	.500	.468 .465	.160 .150	BB500-518	.453	.351	5/16-18UNC-3B	.477			.600	.395	
		-524							BB500-14			3/16-24UNF-3B	.469					
-616		-624	.896 .861	.550	.550	.550	.530 .527	.185 .175	BB500-616	.521	.406	3/8-16UNC-3B	.539			.662	.450	
		-624							BB500-16			3/8-24UNF-3B	.531					

BN326 AND BN326PB SLEEVE

① NOTE: Concentricity: Hole to "D" diameter within .005 FIR;
Head to "D" diameter within .010 FIR.

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

FINISH: BN326 — Sandblast.

① BN326PB — Cadmium plate per QQ-P-416, Type II, Class 2.

CODE: First dash number indicates size of bolt to be used.
Second dash number indicates grip length (thickness of work) in 16ths.

① Letters "PB" indicate cadmium plate per QQ-P-416, Type II, Class 2.

EXAMPLE: BN326-428-12 = Sleeve for 1/4-28 bolt, 3/4 grip length.

BB500, BB500G, BB500PB EXPANDER

NOTE: Threads per MIL-S-8879.

① MATERIAL: Type 431 stainless steel per Spec. AMS 5628.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: BB500 — Cadmium plate per QQ-P-416, Type I, Class 2.

① BB500G — Silver plate per AMS 2410, .0002 - .0004 thick.

BB500PB — Cadmium plate per QQ-P-416, Type II, Class 2.

CODE: Dash number indicates Expander used in assembly.

Letters "G" and "PB" indicate type of finish.

No letter indicates cadmium plate, Type I.

EXAMPLE: BB500-12 = Expander for 1/4-28 bolt, cadmium plate, Type I.

BN1356, BN1356G AND BN1356PB BLIND NUT ASSEMBLY

CODE: First dash number indicates size of bolt to be used.
Second dash number indicates grip length (thickness of work) in 16ths. Letters "G" and "PB" after basic assembly number indicate type of finish. No letter indicates Expander cadmium plated, Type I.

EXAMPLE: BN1356-428-12
3/4 Grip Length
For 1/4-28 Bolt
Blind Nut Assembly which includes:
BN326 Sleeve and BB500 Expander

① BN1356G-428-12 = As example except with Expander BB500G.

BN1356PB-428-12 = Sleeve and Expander cadmium plated, Type II.

TITLE					
BLIND NUT ASSEMBLY					
PROTRUDING HEAD STYLE					
DRAWN	DATE	APPROVED	DATE	REVISION	DATE
D. P. S.	8-4-75	8-4-75	8-4-75	①	3-28-77
DRAWING NUMBER					BN1356

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

CODE IDENTIFICATION NO. 73197

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BN1356