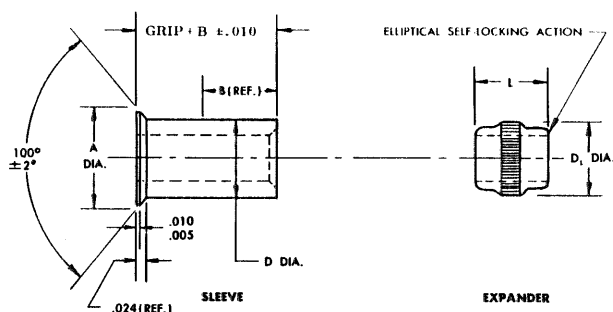
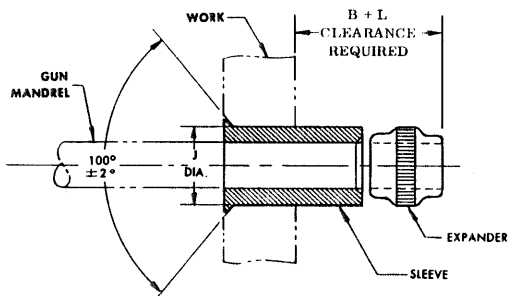
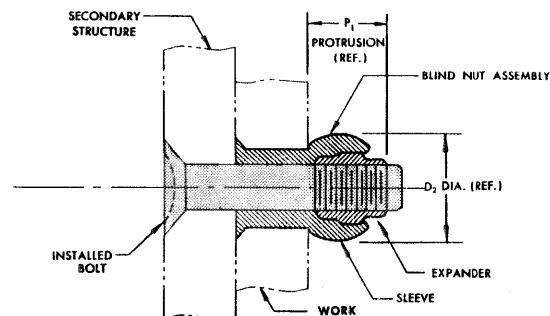




EXPANDER



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



COMPLETED BLIND NUT ASSEMBLY SHOWING SECONDARY STRUCTURE AND INSTALLED BOLT

BLIND NUT ASSEMBLY		BN502 SLEEVE							BB341G EXPANDER				HOLE PREPARATION		PROTRUSION AFTER INSTALLATION	
FIRST DASH NUMBER		FIRST DASH NUMBER	A DIA.	B GRIP RANGE 0-1/4	B GRIP RANGE 1/4-1/2	B GRIP RANGE 1/2-3/4	D DIA.	H	PART NUMBER	D1 DIA.	L	THREAD	J HOLE DIA.		D2 DIA.	P1
-440		-440	.229 .224	.210			.169 .167		BB341G-5	.167	.153	4-40UNC-3B	.173 .170		.210	.175
-632		-632	.278 .273	.280			.218 .216		BB341G-632	.217	.215	6-32UNC-3B	.222 .219		.285	.260
-832		-832	.317 .312	.315	.330		.257 .255		BB341G-8	.255	.245	8-32UNC-3B	.264 .258		.335	.290
-1032		-1032	.372 .367	.380	.420	.460	.312 .309		BB341G-1032	.309	.307	10-32UNF-3B	.319 .313		.410	.350
-428		-428	.450 .445	.450	.450	.450	.390 .387		BB341G-12	.383	.368	1/4-28UNF-3B	.397 .391		.510	.420
-524		-524	.528 .523	.500	.500	.500	.468 .465		BB341G-14	.458	.429	5/16-24UNF-3B	.477 .469		.600	.470
-624		-624	.590 .585	.550	.550	.550	.530 .527		BB341G-16	.521	.491	3/8-24UNF-3B	.539 .531		.662	.530

BN502 SLEEVE

NOTE: 1. Concentricity: Hole to "D" diameter within .005 TIR.
"D" diameter to head within .005 TIR.

MATERIAL: A-286 high temperature alloy per AMS5735.

HEAT TREAT: Anneal.

FINISH: Sandblast.

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

EXAMPLE: BN502-428-12 = Sleeve for 1/4-28 bolt, 3/4 grip length.

BB341G EXPANDER

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

MATERIAL: Type 431 stainless steel per Spec. QQ-S-763.

HEAT TREAT: 125 ksi shear minimum

FINISH: Silver plate per AMS2410, .0002-.0004 thick, and wax lube.

CODE: Dash number indicates Expander used in assembly.
Letter "G" after part number indicates silver plate.

EXAMPLE: BB341G-12 = Expander for 1/4-28 Bolt.

BN372 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.

EXAMPLE: BN372-428-12
3/4 Grip Length
For 1/4-28 Bolt
Blind Nut Assembly which includes:
BN502 Sleeve and BB341G Expander

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

TITLE					
BLIND NUT ASSEMBLY					
100° COUNTERSUNK SHALLOW HEAD HIGH TEMPERATURE APPLICATION					
DRAWN	DATE	APPROVED	DATE	REVISION	DRAWING NUMBER
GARDNER	9-16-60	SCHUSTER	6-16-60	8	BN372

CODE IDENTIFICATION NO. 77197

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