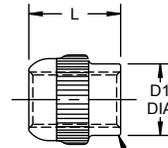
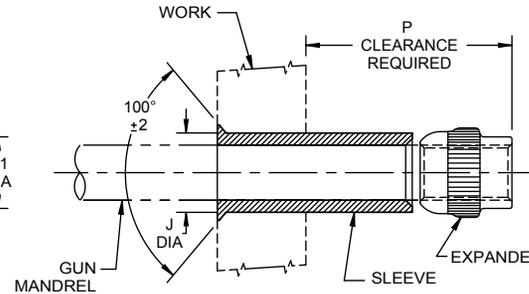


SLEEVE

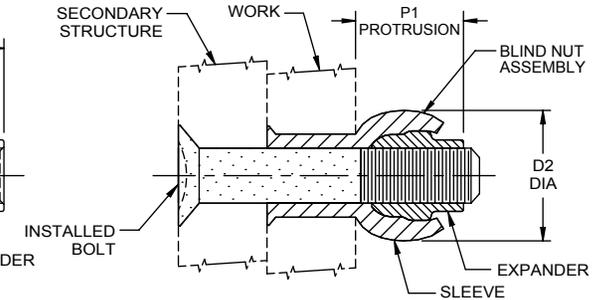


EXPANDER

ELLIPTICAL SELF-LOCKING ACTION AND MANUFACTURER'S TRADEMARK. LOCATION OPTIONAL ON THIS SURFACE.



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		BN515 SLEEVE					BB341 EXPANDER				SUGGESTED HOLE PREPARATION		PROTRUSION AFTER INSTALLATION	
FIRST DASH NO.	FIRST DASH NO.	A DIA	B GRIP RANGE 0 - 3/4	B GRIP RANGE 13/16 - 1-1/16	B GRIP RANGE 1 1/8 - 1 5/8	D DIA (REF)	PART NO.	D1 DIA	L LENGTH	THREAD	J HOLE DIA	P	D2 DIA REF	P1 REF
440	440	.229 .224	.210	-	-	.166 .162	BB341-5	.167	.153	.1120-40UNJC-3B	.173 .170	.373	.210	.175
632	632	.278 .273	.280	-	-	.215 .211	BB341-632	.217	.215	.1380-32UNJC-3B	.222 .219	.505	.285	.260
832	832	.317 .312	.315	.330	-	.254 .251	BB341-8	.255	.245	.1640-32UNJC-3B	.264 .258	.570	.335	.290
1032	1032	.372 .367	.380	.420	.460	.309 .305	BB341-1032	.309	.307	.1900-32UNJF-3B	.319 .313	.697	.410	.350
428	428	.450 .445	.450	.450	.450	.387 .383	BB341-12	.383	.368	.2500-28UNJF-3B	.397	.828	.510	.420
420	420						BB341-420			.2500-20-UNJC-3B	.391			
524	524	.528 .523	.500	.500	.500	.465 .461	BB341-14	.458	.429	.3125-24UNJF-3B	.477	.939	.600	.470
518	518						BB341-518			.3125-18UNJC-3B	.469			
624	624	.590 .585	.550	.550	.550	.527 .523	BB341-16	.521	.491	.3750-24UNJF-3B	.539	1.050	.662	.530
616	616						BB341-616			.3750-16UNJC-3B	.531			
720	720	.652 .647	.600	.600	.600	.589 .585	BB341-720	.585	.552	.4375-20UNJF-3B	.605	1.162	.720	.592
714	714						BB341-714			.4375-14UNJC-3B	.593			
820	820	.714 .709	.650	.650	.650	.651 .647	BB341-820	.643	.614	.5000-20UNJF-3B	.664	1.275	.785	.650
813	813						BB341-813			.5000-13UNJC-3B	.656			

BN516 BLIND NUT ASSEMBLY

EXAMPLE: BN516PB428 - 12

- ⑦ Grip Length in 16ths = 3/4 Grip Length
- Expander Finish Code, Cadmium plate, Type I, Class 2 (BB341-12) (See Expander "Finish" note for explanation of code letters)
- Size of Bolt To Be Used = 1/4-28 Bolt
- Sleeve Finish Code, Cadmium plate, Type II, Class 2 (BN330PB428) (See Sleeve "Finish" note for explanation of code letters)
- Blind Nut Assembly

BN515PB428PB12 = As example, except with BN515PB Sleeve and BB341PB Expander.

BN515 SLEEVE

NOTE: 1. Concentricity: Hole to "D" diameter within .005 FIM. Head to "D" diameter within .005 FIM.

MATERIAL: Type CRES: 305 per AMS-QQ-S-763, 302 HQ, or 18-9 LW (ASTM A-493).

HEAT TREAT: BN515-()-() = Anneal.

FINISH: BN515-()-() = None.
 BN515PB()-() = Cadmium plate per AMS-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. See "Finish" note for explanation of code letters.

EXAMPLE: BN515PB-428-12 = Sleeve for 1/4-28 or 1/4-20 bolt, 3/4 grip length. with cadmium plate, Type II, Class 2.

BB341 EXPANDER

NOTE: 1. Threads per AS8879.

MATERIAL: Type AISI 431 stainless steel per AMS5628.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: BB341-() = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

BB341PB() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

CODE: Dash number indicates expander used in assembly. See "Finish" note for explanation of code letters.

EXAMPLE: BB341-12 = Self-locking Expander for 1/4-28 bolt, with cadmium plate, Type I.

SPECIFICATION: Product Specification HS396.

IS A TRADEMARK OF HI-SHEAR CORPORATION

DRAWN BY RKN	DATE 1967-08-21	⑦ TITLE BLIND NUT ASSEMBLY 100° COUNTERSINK SHALLOW HEAD
APPROVED R. TRINGHAM	DATE 1967-08-24	DRAWING NUMBER BN516
REVISION ⑦	DATE F. CARINGELLA 2018-01-02	1 OF 1