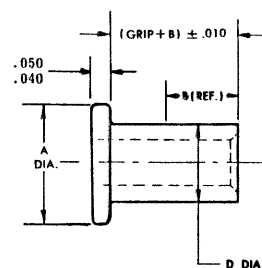
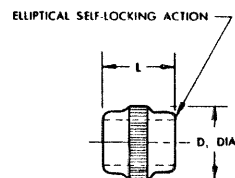


hi-shear
CORPORATION

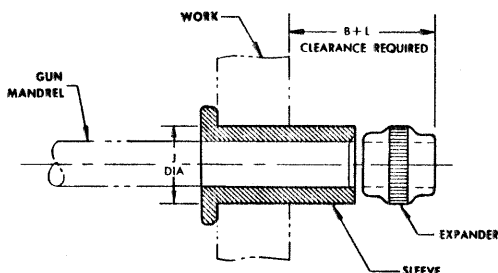
2600 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90509
AREA CODE 213 • 775-3181 • 326-8110



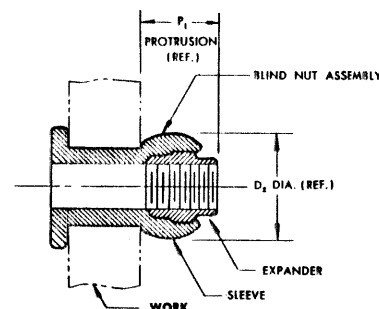
SLEEVE



EXPANDER



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



COMPLETED BLIND NUT ASSEMBLY

BLIND NUT ASSEMBLY		BN531 SLEEVE						BB341 EXPANDER				HOLE PREPARATION		PROTRUSION AFTER INSTALLATION	
FIRST DASH NO.	FIRST DASH NO.	A DIA.	B GRIP RANGE 0-3/4	B GRIP RANGE 1-3/16-1-1/16	B GRIP RANGE 1-1/8-1-5/8	D DIA.	PART NUMBER	D ₁ DIA.	L	THREAD	J HOLE DIA.	D ₂ DIA.	P ₁		
-440	-440	.294 .274	.210	—	—	.169 .167	BB341-5	.167	.153	4-40UNJC-3B	.173 .170	.210	.175		
-632	-632	.315 .295	.280	—	—	.218 .216	BB341-632	.217	.215	6-32UNJC-3B	.222 .219	.285	.260		
-832	-832	.412 .387	.315	.330	—	.257 .255	BB341-8	.255	.245	8-32UNJC-3B	.264 .258	.335	.290		
-1024 -1032	-1032	.505 .475	.380	.420	.460	.312 .309	BB341-1024 BB341-1032	.309	.307	10-24UNJC-3B 10-32UNJF-3B	.319 .313	.410	.350		
-420 -428	-428	.615 .580	.450	.450	.450	.390 .387	BB341-420 BB341-12	.383	.368	1/4-20UNJC-3B 1/4-28UNJF-3B	.397 .391	.510	.420		
-518 -524	-524	.803 .768	.500	.500	.500	.468 .465	BB341-518 BB341-14	.458	.429	5/16-18UNJC-3B 5/16-24UNJF-3B	.477 .469	.600	.470		
-616 -624	-624	.896 .861	.550	.550	.550	.530 .527	BB341-616 BB341-16	.521	.491	3/8-16UNJC-3B 3/8-24UNJF-3B	.539 .531	.662	.530		

BN531 SLEEVE

NOTE: Concentricity: Hole to "D" diameter within .005 TIR.
Head to "D" diameter within .010 TIR.

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

① FINISH: BN531 – Sandblast.
BN531PB – Cadmium plate per QQ-P-416, Type II, Class 2.

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 code for explanation of code letters.

EXAMPLE: BN531-428-12 = Sleeve for 1/4-18 bolt, 3/4 grip length.

BB341 EXPANDER

NOTE: Threads per MIL-S-8879.

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

HEAT TREAT: 125,000 psi shear minimum.

① FINISH: BB341 = Cadmium plate per QQ-P-416, Type I, Class 3.
BB341G = Silver plate per AMS2410.
BB341PB = Cadmium plate per QQ-P-416, Type II, Class 2.

CODE: Dash number indicates Expander used in assembly.

EXAMPLE: BB341-12 = Expander for 1/4-28 bolt.

BN530 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: BN530-428-12
3/4 Grip Length
For 1/4-28 Bolt
Blind Nut Assembly which includes:
BN531 Sleeve and BB341 Expander

BN530G-428-12 = As example except with BB341G Expander.
① BN530PB-428-12 = As example except with BN531PB Sleeve and BB341PB Expander.

"Blind Nut" is a trademark of Hi-Shear Corporation.

TITLE									
BLIND NUT™ ASSEMBLY									
THIN PROTRUDING HEAD STYLE									
DRAWN	DATE	APPROVED	DATE	REVISION	DATE	D.P.S.	DRAWING NUMBER		
RAN	6-29-86	R.W. Kingham	6/29/86	2	6-21-90	D.P.S.	BN530		