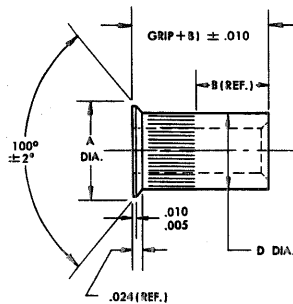
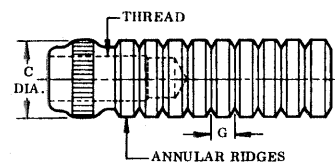


hi-shear
CORPORATION

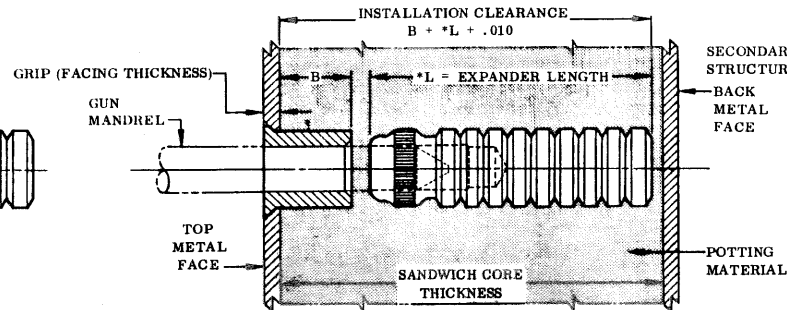
2600 Skypark Drive
Torrance, California 90509 U.S.A.
Telephone (310) 326-8110
FAX (310) 784-4144



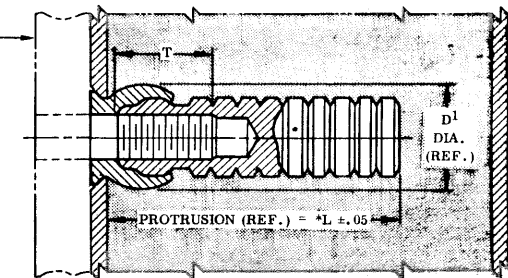
SLEEVE



EXPANDER



**SLEEVE AND EXPANDER ASSEMBLED ON MANDREL,
AND INSERTED INTO PANEL READY FOR PULL-UP.**



**INSTALLED BLIND-SERT ASSEMBLY
SHOWING SECONDARY STRUCTURE.**

BN532 BLIND-SERT ASSEMBLY		BN517 SLEEVE			BB412 EXPANDER					INSTALLATION DATA				
FIRST DASH NO.	FIRST DASH NO.	A DIA.	B	D DIA.	PART NUMBER	MINIMUM NO. OF GROOVES	MINIMUM MFR'D. LENGTH	G GROOVE SPACING	THREAD	C DIA.	MINIMUM CORE THICKNESS	D DIA.	INSTALLATION HOLE DIA.	T MIN. THREAD DEPTH
-632	-632	.278 .273	.280	.215 .211	BB412-632	3	1/2"	.075	6-32UNJC-3B	.217	13/16"	.285	.222 .219	.210
-832	-832	.317 .312	.315	.254 .251	BB412-832	3	9/16"	.075	8-32UNLC-3B	.255	7/8"	.385	.264 .258	.250
-1024	-1032	.372 .367	.380	.309 .305	BB412-1024 BB412-1032	2	5/8"	.125	10-24UNJC-3B 10-32UNJF-3B	.309	1-1/8"	.410	.319 .313	.310
-420	-428	.450 .445	.450	.387 .383	BB412-420 BB412-428	2	11/16"	.125	1/4-20UNJC-3B 1/4-20UNJF-3B	.383	1-1/4"	.510	.397 .391	.370
-518	-524	.528 .523	.500	.465 .461	BB412-518 BB412-524	2	3/4"	.125	5/16-18UNJC-3B 5/16-24UNJF-3B	.458	1-3/8"	.600	.477 .469	.430
-616	-624	.590 .585	.550	.527 .523	BB412-616 BB412-624	2	15/16"	.125	3/8-16UNJC-3B 3/8-24UNJF-3B	.523	1-1/2"	.662	.539 .531	.470
-820	-820	.714 .709	.650	.651 .647	BB412-820	1	1"	.125	1/2-20UNJF-3B	.643	1-1/2"	.785	.664 .656	.570

NOTE: For installation data and tooling, refer to Hi-Shear Corporation Brochure 2-1094.

BN517 SLEEVE

GENERAL NOTES: 1. Concentricity: Hole to "D" diameter within .005 FIM.
"D" diameter to head within .005 FIM.

MATERIAL: Aluminum 2017 per QQ-A-430.

HEAT TREAT: Anneal.

FINISH: Anodize (clear).

CODE: First dash number indicates the diameter of the bolt to be used with the Blind-Sert Assembly.
Second dash number indicates the grip (facing thickness) in 1/16" increments.

EXAMPLE: BN517-428-1 = Sleeve for 1/4-28 or 1/4-20 bolt, 1/16" grip length (facing thickness).

BB412 EXPANDER

GENERAL NOTES: 1. Threads per MIL-S-8879.

MATERIAL: Type 303 stainless steel.

FINISH: Passivate.

CODE: First dash number indicates Expander to be used with the required attaching bolt.
Second dash number indicates the Expander length (L) in 1/16" increments. (Obtained by adding the minimum manufactured length in 16ths, to the difference (in 16ths) between the minimum core thickness and the required core thickness.)

NOTE: For any dimension less than 1/16", use the next higher 1/16" increment.

EXAMPLE: BB412-428-15
Expander Length in 16ths (Min. manufactured length, 11/16", plus 4/16", the difference between 1-1/4" min. core thickness and 1-1/2" required core thickness.)
Expander to be used with a 1/4-28 attaching bolt.
Expander Part Number

BN532 BLIND-SERT ASSEMBLY

CODE: First dash number indicates diameter of bolt to be used with the Blind-Sert Assembly.
Second dash number indicates the grip (facing thickness) in 1/16" increments.
Third dash number indicates the length of the Expander in 1/16" increments (the minimum manufactured length plus the difference in 16ths between the minimum core thickness and the required core thickness).
NOTE: In calculating either the second or third dash number, if the actual dimension is not an even 1/16" increment, use the next higher 1/16" unit.

EXAMPLE: BN532-428-1-15
Expander length is 16ths. (Minimum manufactured length, 11/16" plus 4/16", the difference between 1-1/4" min. core thickness and 1-1/2" required core thickness.)
Grip (facing thickness) in 16ths.
1/4-28 bolt to be used.
Blind-Sert Assembly. Includes BN517 Sleeve and BB412 Expander.

*"BLIND NUT" is a trademark of Hi-Shear Corporation.

DRAWN DATE		TITLE	
R.K.H.	9-7-66	BLIND-SERT® ASSEMBLY	
APPROVED DATE		A BLIND THREADED INSERT FOR POTTED HONEYCOMB PANELS	
W. Tringham	9-7-66		
REVISION DATE		DRAWING NUMBER	
⑧	J.R.H. 3-31-97	BN532	