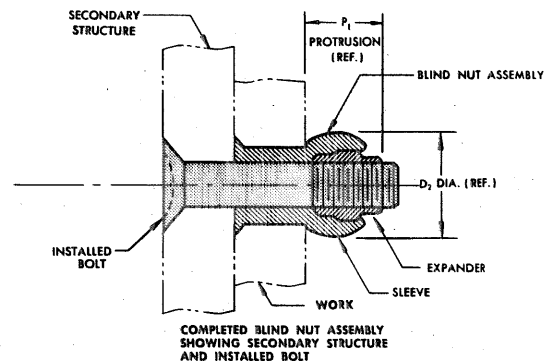
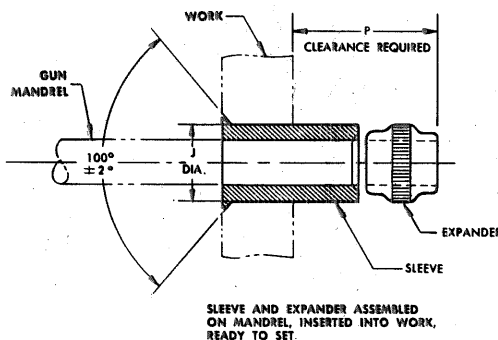
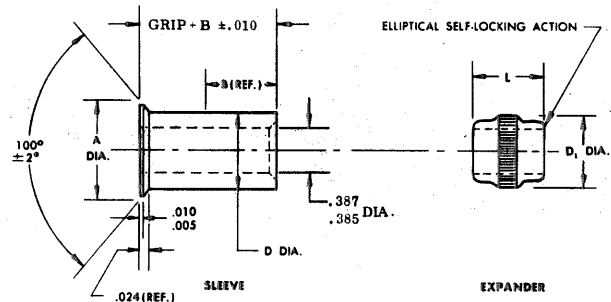


hi-shear
CORPORATION

2600 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90509
AREA CODE 213 • 775-3181 • 328-8110



BN536 BLIND NUT ASSEMBLY		BN502 SLEEVE								BB516GA 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	D, DIA.	L	THREAD	J HOLE DIA.	P	D, DIA.	P, DIA.
-440		-440	.229 .224	.210	.225		.169 .167			BB516GA-5	.167	.153	4-40UNJC-3B	.173 .170	.373	.210	.175
-632		-632	.278 .273	.280	.295	.350	.218 .216			BB516GA-632	.217	.215	6-32UNJC-3B	.222 .219	.505	.285	.260
-832		-832	.317 .312	.315	.330	.370	.257 .255			BB516GA-8	.255	.245	8-32UNJC-3B	.264 .258	.570	.335	.290
-1032		-1032	.372 .367	.380	.420	.460	.312 .309			BB516GA-1032	.309	.307	10-32UNJF-3B	.319 .313	.697	.410	.350
-428		-428	.450 .445	.450	.450	.450	.390 .387			BB516GA-12 BB516GA-420	.383	.368	1/4-28UNJF-3B 1/4-20UNJC-3B	.397 .391	.828	.510	.420
-524		-524	.528 .523	.500	.500	.500	.468 .465			BB516GA-14 BB516GA-518	.458	.429	5/16-24UNJF-3B 5/16-18UNJC-3B	.477 .469	.939	.600	.470
-624		-624	.590 .585	.550	.550	.550	.530 .527			BB516GA-16 BB516GA-616	.521	.491	3/8-24UNJF-3B 3/8-16UNJC-3B	.539 .531	1.050	.662	.530
-720		-720	.652 .647	.600	.600	.600	.592 .589			BB516GA-720 BB516GA-714	.585	.552	7/16-20UNJF-3B 7/16-14UNJC-3B	.605 .593	1.162	.720	.592
-820		-820	.714 .709	.650	.650	.650	.654 .651			BB516GA-820 BB516GA-813	.643	.614	1/2-20UNJF-3B 1/2-13UNJC-3B	.664 .656	1.275	.785	.650

BN502 SLEEVE

GENERAL NOTES: Concentricity: Hole to "D" diameter within .005 TIR;
"D" diameter to head within .005 TIR.

MATERIAL: Type A-286 meeting composition limits of the AMS specifications.

HEAT TREAT: Heat treated to meet the requirements of AMS5736.

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.

BB516GA EXPANDER

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

MATERIAL: 17-4PH stainless steel per AMS5643.

HEAT TREAT: 120,000 psi shear.

FINISH: Silver plate per AMS2411.

CODE: Dash number indicates expander used in assembly.

EXAMPLE: BB516GA-12 = Expander for 1/4-28 bolt, silver plated per AMS2411.

BN536 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: BN536-428-12
3/4 Grip Length
For 1/4-28 Bolt
Blind Nut Assembly which includes:
BN502 Sleeve and BB516GA Expander

U.S. PATENT 2,959,999. FOREIGN PATENTS
ISSUED AND PENDING.

TITLE					
BLIND NUT™ ASSEMBLY					
100° COUNTERSUNK SHALLOW HEAD					
DRAWN	DATE	APPROVED	DATE	REVISION	DATE
Shrode	6-11-71	Shrode	6-15-71	1	Shrode
DRAWING NUMBER					BN536

CODE IDENTIFICATION NO. 73197

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BN536