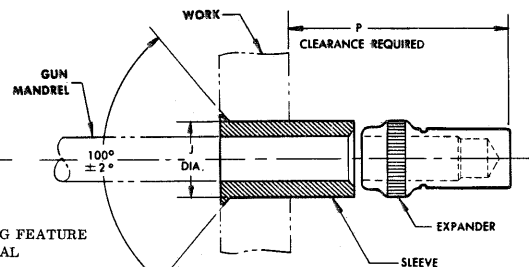
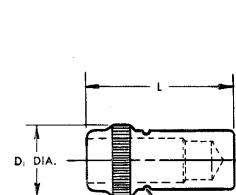
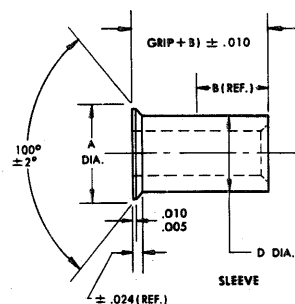
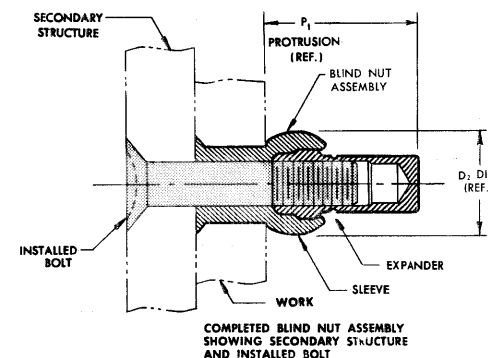




2600 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90509
AREA CODE 213 • 775-3181 • 326-8110



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



BN537 BLIND NUT ASSEMBLY		BN502 SLEEVE						BB414 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.		PART NUMBER	D1 DIA.	L	THREAD	J HOLE DIA.	P		D2 DIA.	P1	
-632	-632	.278 .273	.280			.218 .216		BB414-632	.217	.610	6-32UNC-3B	.222 .219	B+.620		.285	.655	
-832	-832	.317 .312	.315	.330		.257 .255		BB414-832	.255	.650	8-32UNC-3B	.264 .258	B+.660		.335	.695	
-1024	-1032	.372 .367	.380	.420	.460	.312 .309		BB414-1024 BB414-1032	.309	.830 .710	10-24UNC-3B 10-32UNF-3B	.319 .313	B+.840 B+.720		.410	.870 .750	
-420	-428	.450 .445	.450	.450	.450	.390 .387		BB414-420 BB414-12	.383	.980 .950	1/4-20UNC-3B 1/4-28UNF-3B	.397 .391	B+.990 B+.960		.510	1.030 1.000	
-518	-524	.528 .523	.500	.500	.500	.468 .465		BB414-518 BB414-14	.458	1.100 1.010	5/16-18UNC-3B 5/16-24UNF-3B	.477 .469	B+1.110 B+1.020		.600	1.140 1.050	
-616	-624	.590 .585	.550	.550	.550	.530 .527		BB414-616 BB414-16	.521	1.170 1.070	3/8-16UNC-3B 3/8-24UNF-3B	.539 .531	B+1.180 B+1.080		.662	1.210 1.110	

BN502 SLEEVE

BB414 EXPANDER

BN537 BLIND NUT ASSEMBLY

NOTE: 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: BN502-624-12 = Sleeve for 3/8-24 or 3/8-16 bolt,
3/4 grip length.

NOTE: Threads per MIL-S-7742.

MATERIAL: A-286 alloy per AMS5731.

HEAT TREAT: 110,000 psi shear minimum.

FINISH: BB414 = Solid film lube (Electrofilm #77-S).
BB414G = Silver plate per AMS2410.

CODE: Dash number indicates size of expander used in assembly.
Letters "LK" after part number indicate expander with locking feature. Letter "G" indicates silver plate.

EXAMPLE: BB414-16 = Expander for 3/8-24 bolt.
BB414GLK-16 = Expander with silver plate and locking feature for 3/8-24 bolt.
BB414-616 = Expander for 3/8-16 bolt.

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

EXAMPLE: BN537-624-12
3/4 Grip Length
For 3/8-24 Bolt
Blind Nut Assembly which includes:
BN502 Sleeve and BB414 Expander
BN537LK-624-12: As above except with locking type expander.

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

TITLE							
BLIND NUT ASSEMBLY							
100° COUNTERSUNK SHALLOW HEAD							
DOME TYPE							
DRAWN	DATE	APPROVED	DATE	REVISION	DATE	D. P. S.	DRAWING NUMBER
10-12-87	10-12-87	10-12-87	10-12-87	10-12-87	10-12-87	10-12-87	BN537

CODE IDENTIFICATION NO. 73197

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BN537