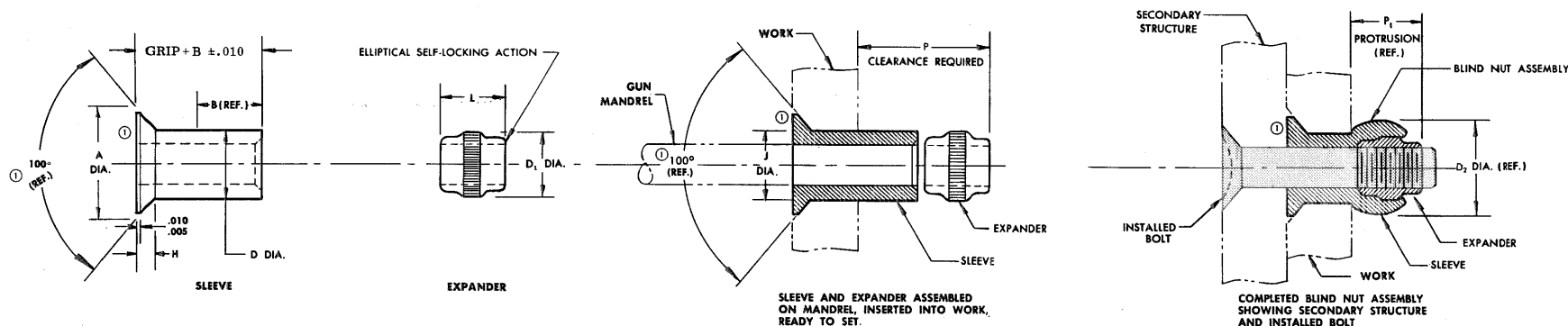




BN538 BLIND NUT ASSEMBLY		BN539 SLEEVE							BB415 EXPANDER				HOLE PREPARATION			PROTRUSION AFTER INSTALLATION	
FIRST DASH NUMBER		FIRST DASH NUMBER	A DIA.	B GRIP RANGE 0-3/4	B GRIP RANGE 1 1/4-1 1/2	B GRIP RANGE 1 1/2-1 3/4	D DIA.	H	PART NUMBER	D1 DIA.	L	THREAD	J HOLE DIA.	P		D2 DIA.	P1
-832		-832	.3948 .3898	.315	.350		.257 .255	.0578 .0558	BB415-8	.255	.245	8-32UNC-3B	.264 .258	.570		.335	.290
-1024		-1032	.4739 .4689	.380	.420	.460	.312 .309	.0679 .0659	BB415-1024 BB415-1032	.309	.307	10-24UNC-3B 10-32UNF-3B	.319 .313	.697		.410	.350
-420		-428	.5604 .5554	.450	.450	.450	.390 .387	.0715 .0695	BB415-420 BB415-12	.383	.368	1/4-20UNC-3B 1/4-28UNF-3B	.397 .391	.828		.510	.420
-518		-524	.6680 .6620	.500	.500	.500	.468 .465	.0839 .0814	BB415-518 BB415-14	.458	.429	5/16-18UNC-3B 5/16-24UNF-3B	.477 .469	.939		.600	.470
-616		-624	.7540 .7480	.550	.550	.550	.530 .527	.0940 .0915	BB415-616 BB415-16	.521	.491	3/8-16UNC-3B 3/8-24UNF-3B	.539 .531	1.050		.662	.530

BN539 SLEEVE

BB415 EXPANDER

BN538 BLIND NUT ASSEMBLY

- NOTES: 1. Concentricity: Hole to "D" diameter within .005 TIR;
"D" diameter to head within .005 TIR.
2. "H" is dimensioned from maximum "D" diameter.

MATERIAL: Type 316 stainless steel per QQ-S-763.

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: BN539-428-12 = Sleeve for 1/4-28 bolt, 3/4 grip length.

NOTE: Threads per MIL-S-7742.

MATERIAL: A-286 alloy per AMS5731.

① FINISH: Solid film lube per MIL-L-8937.

HEAT TREAT: 110,000 psi shear minimum.

CODE: Dash number indicates expander used in assembly.

EXAMPLE: BB415-12 = Expander for 1/4-28 bolt.
BB415-420 = Expander for 1/4-20 bolt.

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

EXAMPLE: BN538-428-12
3/4 Grip Length
For 1/4-28 Bolt
Blind Nut Assembly which includes:
BN539 Sleeve and BB415 Expander

U.S. Patent 2,959,999. Foreign patents issued.

TITLE BLIND NUT ASSEMBLY 100° COUNTERSUNK HEAD STYLE					
DRAWN RHL	DATE 12-29-67	APPROVED KJL	DATE 12-29-67	REVISION ①	DRAWING NUMBER BN538

CODE IDENTIFICATION NO. 73197

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