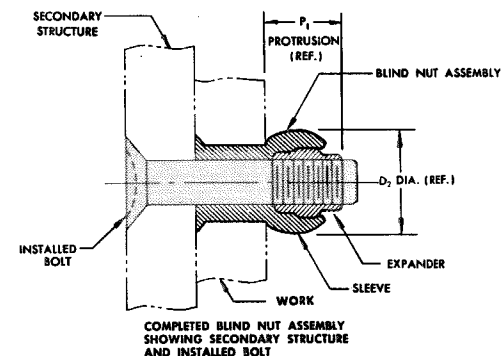
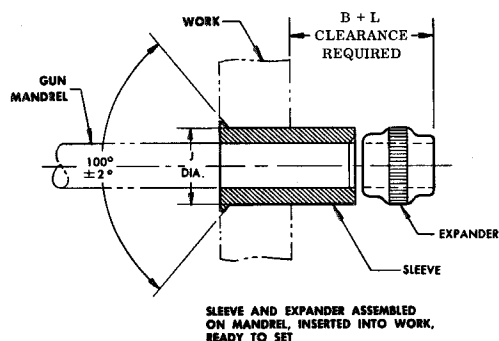
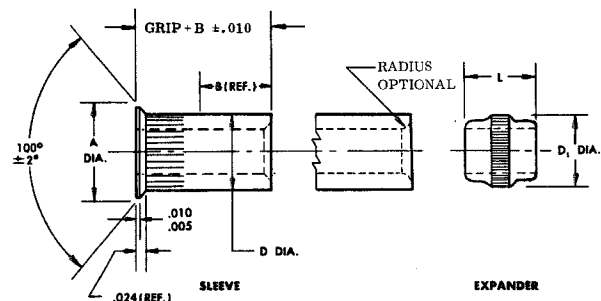


hi-shear
CORPORATION

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



BLIND NUT ASSEMBLY		BN515 SLEEVE						BB434 EXPANDER				HOLE PREPARATION			PROTRUSION AFTER INSTALLATION	
FIRST DASH NUMBER		FIRST DASH NUMBER	A DIA.	S GRIP RANGE 0-1/4	S GRIP RANGE 1/4-1/2	S GRIP RANGE 1/2-1 1/4	D DIA.	PART NUMBER	D1 DIA.	L	THREAD	J HOLE DIA.			D2 DIA.	P1
-440		-440	.229 .224	.210	—	—	.169 .167	BB434-5	.167	.153	4-40UNJC-3B	.173 .170			.210	.175
-632		-632	.278 .273	.280	—	—	.218 .216	BB434-632	.217	.215	6-32UNJC-3B	.222 .219			.285	.260
-832		-832	.317 .312	.315	.330	—	.257 .255	BB434-8	.255	.245	8-32UNJC-3B	.264 .258			.335	.290
-1032		-1032	.372 .367	.380	.420	.460	.312 .309	BB434-1032	.309	.307	10-32UNJF-3B	.319			.410	.350
-1024		-1024						BB434-1024			10-24UNJC-3B	.313				
-428		-428	.450 .445	.450	.450	.450	.390 .387	BB434-12	.383	.368	1/4-28UNJF-3B	.397			.510	.420
-420		-420						BB434-420			1/4-20UNJC-3B	.391				
-524		-524	.528 .523	.500	.500	.500	.468 .465	BB434-14	.458	.429	5/16-24UNJF-3B	.477			.600	.470
-518		-518						BB434-518			5/16-18UNJC-3B	.469				
-624		-624	.590 .585	.550	.550	.550	.530 .527	BB434-16	.521	.491	3/8-24UNJF-3B	.539			.662	.530
-616		-616						BB434-616			3/8-16UNJC-3B	.531				
-720		-720	.652 .647	.600	.600	.600	.592 .589	BB434-720	.585	.552	7/16-20UNJF-3B	.605			.720	.592
-714		-714						BB434-714			7/16-14UNJC-3B	.593				
-820		-820	.714 .709	.650	.650	.650	.654 .651	BB434-820	.643	.614	1/2-20UNJF-3B	.664			.785	.650
-813		-813						BB434-813			1/2-13UNJC-3B	.656				

BN515 SLEEVE

NOTE: 1. Concentricity: Hole to "D" diameter within .005 TIR.
"D" diameter to head within .005 TIR.

① MATERIAL: Type 305 stainless steel per QQ-S-763.

HEAT TREAT: Anneal.

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: BN515-428-12 = Sleeve for 1/4-28 or 1/4-20 bolt, 3/4 grip length.

BB434 EXPANDER

NOTE: 1. Threads per MIL-S-8879.

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

HEAT TREAT: 125,000 psi shear minimum.

FINISH: BB434 – Silver plated per QQ-S-365, Grade B,
.0002-.0004 thick, dye color blue.

CODE: Dash number indicates Expander used in assembly.

EXAMPLE: BB434-12 = Expander for 1/4-28 Bolt, silver plated
with no self-locking feature.

BN557 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: BN557-428-12
└─ 3/4 Grip Length
└─ For 1/4-28 Bolt
Blind Nut Assembly which includes:
BN515 Sleeve and BB434 Expander

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

TITLE			
BLIND NUT ASSEMBLY			
100° COUNTERSUNK SHALLOW HEAD			
DRAWN	DATE	APPROVED	DATE
Shrode	3-12-71	Edgar & Wn	3-12-71
REVISION	DATE	REVISION	DATE
②			
DRAWING NUMBER	D. P. S.		
BN557	8-20-91		

CODE IDENTIFICATION NO. 73197

©1991, Hi-Shear Corporation

BN557