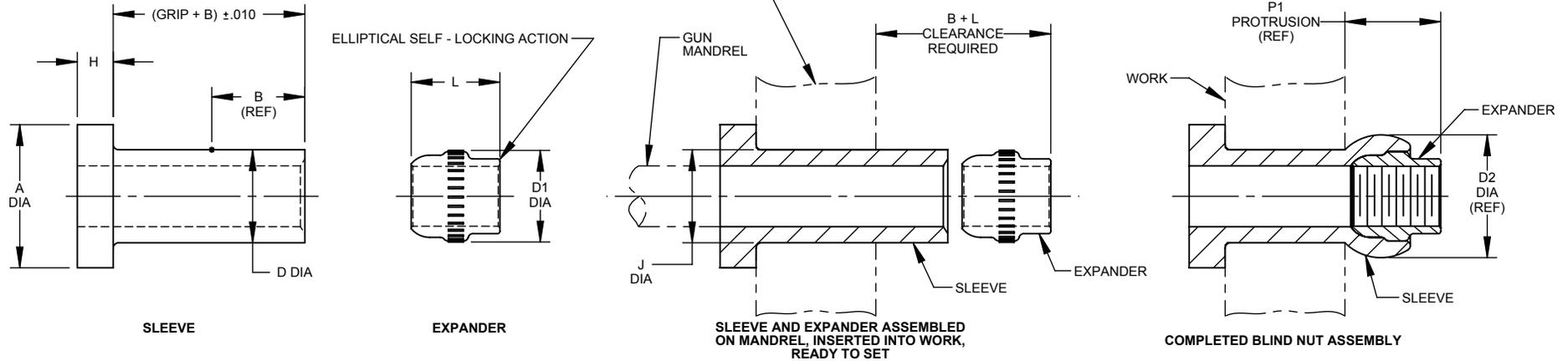


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BLIND NUT ASSEMBLY		BN326 SLEEVE						BB341 EXPANDER				SUGGESTED HOLE PREPARATION	PROTRUSION AFTER INSTALLATION	
FIRST DASH NO.	FIRST DASH NO.	A DIA	B GRIP RANGE 0 - 3/4	B GRIP RANGE 13/16 - 1-1/16	B GRIP RANGE 1 1/8 - 1 3/8	D DIA (REF)	H	PART NUMBER	D1 DIA	L	THREAD	J HOLE DIA	D2 DIA	P1
440	440	.294 .274	.210	-	-	.169 .167	.055 .045	BB341-5	.167	.153	.1120-40UNJC-3B	.173 .170	.210	.175
632	632	.315 .295	.280	-	-	.218 .216	.065 .055	BB341-632	.217	.215	.1380-32UNJC-3B	.222 .219	.285	.260
832	832	.412 .387	.315	.330	-	.257 .255	.090 .080	BB341-8	.255	.245	.1640-32UNJC-3B	.264 .258	.335	.290
1032	1032	.505	.380	.420	.460	.312	.110	BB341-1032	.309	.307	.1900-32UNJF-3B	.319	.410	.350
1024		BB341-1024						.1900-24UNJC-3B			.313			
428	428	.615	.450	.450	.450	.390	.155	BB341-12	.383	.368	.2500-28UNJF-3B	.397	.510	.420
420		BB341-420						.2500-20UNJC-3B			.391			
524	524	.803	.500	.500	.500	.468	.160	BB341-14	.458	.429	.3125-24UNJF-3B	.477	.600	.470
518		BB341-518						.3125-18UNJC-3B			.469			
624	624	.896	.550	.550	.550	.530	.185	BB341-16	.521	.491	.3750-24UNJF-3B	.539	.662	.530
616		BB341-616						.3750-16UNJC-3B			.531			

**BN356 BLIND NUT ASSEMBLY**

**EXAMPLE:** BN356 PB 428 - 12

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- Grip Length in 16ths = 3/4 Grip Length
- Expander Finish Code, Cadmium plate, Type I, Class 2 (BB341-12) (See Expander "Finish" note for explanation of code letters)
- Size of Bolt To Be Used = 1/4-28 Bolt
- Sleeve Finish Code, Cadmium plate, Type II, Class 2 (BN326PB428) (See Sleeve "Finish" note for explanation of code letters)
- Blind Nut Assembly which includes: BN326 Sleeve and BB341 Expander
- BN356G428-12 = As example except with BB341G Expander
- BN356PB428PB12 = BN326PB Sleeve and BB341PB Expander.

**BN326 SLEEVE**

**NOTE:** 1. Concentricity: Hole to "D" diameter within .005 FIM. Head to "D" diameter within .010 FIM.

**MATERIAL:** Type CRES: 305 per AMS-QQ-S-763.

**FINISH:** BN326-( )-( ) = Sand Blast.  
 BN326PB( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.

**CODE:** First dash number indicates size of bolt to be used. Second dash number indicates grip length (thickness of work) in 16ths. See "Finish" note for explanation of code letters.

**EXAMPLE:** BN326-428-12 = Sleeve for 1/4-28 bolt, 3/4 grip length.

**BB341 EXPANDER**

**NOTE:** 1. Threads per AS8879.

**MATERIAL:** Type AISI 431 stainless steel per AMS5628.

**HEAT TREAT:** 125,000 psi shear minimum.

**FINISH:** BB341-( ) = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

BB341G( ) = Silver plate per AMS2410 (.0002-.0004 thick), and cetyl alcohol lube per Hi-Shear Spec. 305.

BB341PB( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

**CODE:** Dash number indicates expander used in assembly. See "Finish" note for explanation of code letters.

**EXAMPLE:** BB341-12 = Expander for 1/4 bolt.

**SPECIFICATION:** Product Specification HS396.

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DRAWN BY V.H.	DATE 1960-03-28	⑩	TITLE BLIND NUT ASSEMBLY PROTRUDING HEAD STYLE
APPROVED SCHUSTER	DATE 1960-03-28		
REVISION ⑩	DATE F.CARINGELLA 2018-01-02		DRAWING NUMBER <b>BN356</b>