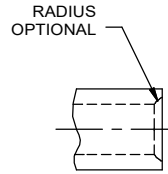
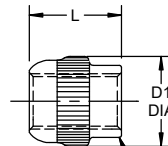


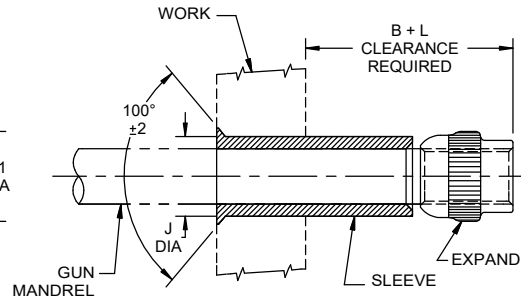
SLEEVE



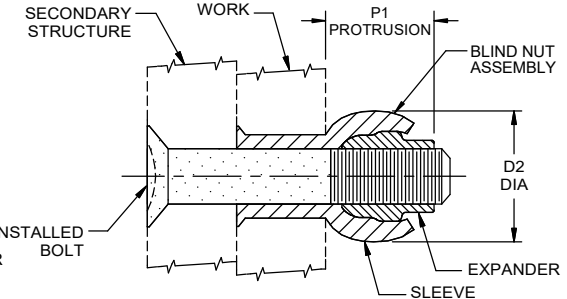
ELLIPTICAL SELF-LOCKING
ACTION AND MANUFACTURER'S
TRADEMARK. LOCATION OPTIONAL
ON THIS SURFACE.



EXPANDER



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



**COMPLETED BLIND NUT ASSEMBLY
SHOWING SECONDARY STRUCTURE
AND INSTALLED BOLT**

| BLIND NUT ASSEMBLY | | BN330 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 5/8 | D DIA | PART NO. | D1 DIA | L LENGTH | THREAD | J HOLE DIA | D2 DIA REF | P1 REF |
| 440 | 440 | .229 .224 | .210 | - | - | .169 .167 | BB341-5 | .167 | .153 | .1120-40UNJC-3B | .173 .170 | .210 | .175 |
| 632 | 632 | .278 .273 | .280 | - | - | .218 .216 | BB341-632 | .217 | .215 | .1380-32UNJC-3B | .222 .219 | .285 | .260 |
| 832 | 832 | .317 .312 | .315 | .330 | - | .257 .255 | BB341-8 | .255 | .245 | .1640-32UNJC-3B | .264 .258 | .335 | .290 |
| 1032 | 1032 | .372 .367 | .380 | .420 | .460 | .312 .309 | BB341-1032 BB341-1024 | .309 | .307 | .1900-32UNJC-3B .1900-24UNJC-3B | .319 .313 | .410 | .350 |
| 428 | 428 | .450 .445 | .450 | .450 | .450 | .390 .387 | BB341-12 BB341-420 | .383 | .368 | .2500-28UNJF-3B .2500-20UNJC-3B | .397 .391 | .510 | .420 |
| 524 | 524 | .528 .523 | .500 | .500 | .500 | .468 .465 | BB341-14 BB341-518 | .458 | .429 | .3125-24UNJF-3B .3125-18UNJC-3B | .477 .469 | .600 | .470 |
| 624 | 624 | .590 .585 | .550 | .550 | .550 | .530 .527 | BB341-16 BB341-616 | .521 | .491 | .3750-24UNJF-3B .3750-16UNJC-3B | .539 .531 | .662 | .530 |
| 720 | 720 | .652 .647 | .600 | .600 | .600 | .592 .589 | BB341-720 BB341-714 | .585 | .552 | .4375-20UNJF-3B .4375-14UNJC-3B | .601 .593 | .720 | .592 |
| 820 | 820 | .714 .709 | .650 | .650 | .650 | .654 .651 | BB341-820 BB341-813 | .643 | .614 | .5000-20UNJF-3B .5000-13UNJC-3B | .664 .656 | .785 | .650 |

BN360 BLIND NUT ASSEMBLY

EXAMPLE: BN360PB428 - 12

- 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 (BN330PB428)
- (See Sleeve "Finish" note for explanation of code letters)
- Blind Nut Assembly

BN360PB428PB12 = As example, except with BN330PB Sleeve and BB341PB Expander.

SPECIFICATION: Product Specification HS396.

BN330 SLEEVE

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

MATERIAL: Type CRES: 305 per AMS-QQ-S-763, 302 HQ, or 18-9 LW (ASTM A-493).

HEAT TREAT: Anneal per AMS2759.

(45) **FINISH:** BN330-()-() = Abrasive clean (Process No.5), and Passivate per AMS2700, Method 1, Type 8.
BN330PB()-() = 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: BN330-428-12 = Sleeve for 1/4-28 or 1/4-20 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 Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

BB341DU() = Solid film lube per AS5272, Type I.

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

BB341GF() = Silver plate per AMS2410 (.0002-.0004 thick), solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.

BB341GU() = Silver plate per AMS2410 (.0002-.0004 thick), no lube.

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

BB341PV() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, solid film lube per AS5272, Type I and cetyl alcohol lube per Hi-Shear Spec. 305.

BB341TF() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.

(45) BB341HK() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

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

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

| (45) "BLIND NUT" AND "HI-KOTE" ARE TRADEMARKS OF HI-SHEAR CORPORATION | | |
|---|-------------------------------|--|
| DRAWN BY HALES | DATE 1955-07-16 | TITLE BLIND NUT ASSEMBLY 100° COUNTERSUNK SHALLOW HEAD |
| APPROVED CESSNA | DATE 1955-07-16 | |
| REVISION (45) | DATE K. PHAM 2022-10-25 | DRAWING NUMBER BN360 1 OF 1 |