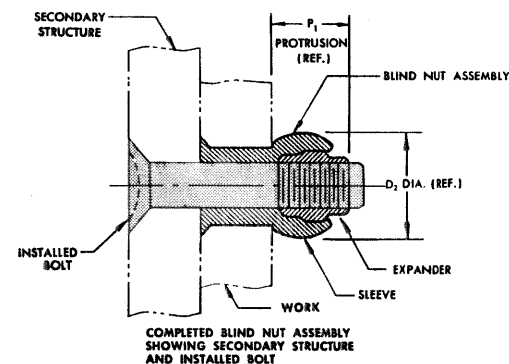
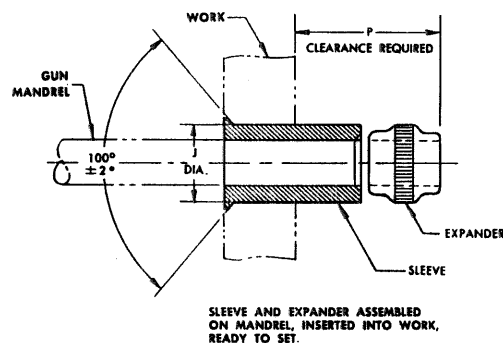
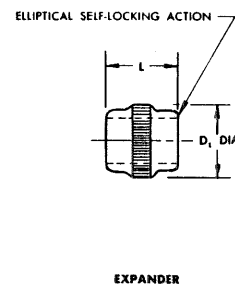
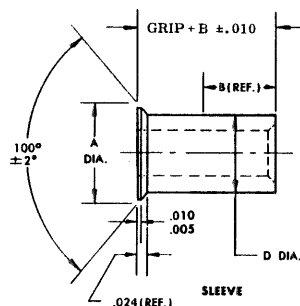


hi-shear
CORPORATION

2600 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90509
AREA CODE 213 • 775-3181 • 328-8110



BN377 BLIND NUT ASSEMBLY		BN502 SLEEVE						BB415 EXPANDER				HOLE PREPARATION			PROTRUSION AFTER INSTALLATION		INSTALLATION PRESSURE PSI USING HI-SHEAR TOOLING	
FIRST DASH NUMBER		FIRST DASH NUMBER	A DIA.	B GRIP RANGE 0-1/4"	B GRIP RANGE 1/4-1/2"	B GRIP RANGE 1/2-1 1/4"	D DIA.	PART NUMBER	D ₁ DIA.	L	THREAD	J HOLE DIA.	P		D ₂ DIA.	P ₁	GUN NO. BG1750	GUN NO. BG2500
-440		-440	.229 .224	.210			.169 .167	BB415-5	.167	.153	4-40UNJC-3B	.173 .170	B+.163		.210	.175	600	300
-632		-632	.278 .273	.280			.218 .216	BB415-632	.217	.215	6-32UNJC-3B	.222 .219	B+.225		.285	.260	900	450
-832		-832	.317 .312	.315	.330		.257 .255	BB415-8	.255	.245	8-32UNJC-3B	.264 .258	B+.255		.335	.290	1250	700
-1024		-1032	.372 .367	.380	.420	.460	.312 .309	BB415-1024 BB415-1032	.309 .307	.307	10-24UNJC-3B 10-32UNJF-3B	.319 .313	B+.317		.410	.350		1100
-420		-428	.450 .445	.450	.450	.450	.390 .387	BB415-420 BB415-12	.383	.368	1/4-20UNJC-3B 1/4-28UNJF-3B	.397 .391	B+.378		.510	.420		1550
-518		-524	.528 .523	.500	.500	.500	.468 .465	BB415-518 BB415-14	.458	.429	5/16-18UNJC-3B 5/16-24UNJF-3B	.477 .469	B+.439		.600	.470		2000
-616		-624	.590 .585	.550	.550	.550	.530 .527	BB415-616 BB415-16	.521	.491	3/8-16UNJC-3B 3/8-24UNJF-3B	.539 .531	B+.501		.662	.530		2350
-714		-720	.652 .647	.600	.600	.600	.592 .589	BB415-714 BB415-720	.585	.552	7/16-14UNJC-3B 7/16-20UNJF-3B	.605 .593	B+.562		.720	.592		2350
-813		-820	.714 .709	.650	.650	.650	.654 .651	BB415-813 BB415-820	.643	.614	1/2-13UNJC-3B 1/2-20UNJF-3B	.664 .656	B+.624		.785	.650		2350

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

MATERIAL: Type A-286 per AMS5731

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.

BB415 EXPANDER

NOTE: Threads per MIL-S-8879.

MATERIAL: Type A-286 per AMS5731, cold worked 40-50% and aged to meet double shear strength requirements of 110,000 psi minimum.

① FINISH: BB415-() = Solid film lube per MIL-L-46010, Type I.
BB415GA-() = Silver plate per AMS2411.
BB415DP-() = Solid film lube per Kalgard KG 100-10.

CODE: Dash number indicates expander used in assembly.

EXAMPLE: BB415-16 = Expander for 3/8-24 bolt.

BN377 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: BN377-624-12
└─ 3/4 Grip Length
└─ For 3/8-24 Bolt
└─ Blind Nut Assembly which includes:
BN502 Sleeve and BB415 Expander
BN377GA-()-() = As example except with
Expander BB415GA.

TITLE T.M. BLIND NUT ASSEMBLY 100° COUNTERSUNK SHALLOW HEAD					
DRAWN RKH 10-12-91	DATE 10-12-91	APPROVED [Signature]	DATE 10-12-91	REVISION 6	D.P.S. 2-15-91
DRAWING NUMBER BN377					

BN377