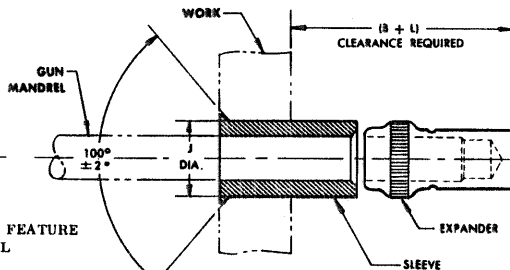
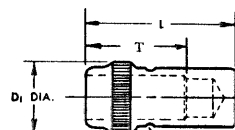
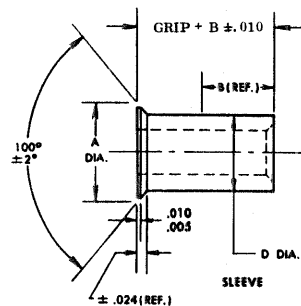
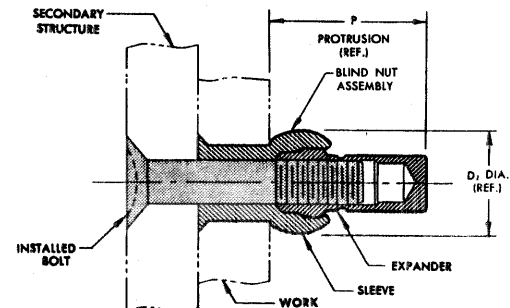


hi-shear
CORPORATION

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



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



COMPLETED BLIND NUT ASSEMBLY
SHOWING SECONDARY STRUCTURE
AND INSTALLED BOLT

BN388 BLIND NUT ASSEMBLY		BN330 SLEEVE						BB348 EXPANDER					HOLE PREPARATION		PROTRUSION AFTER INSTALLATION	
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	D1 DIA.	L	THREAD	T (REF)	J HOLE DIA.		D2 DIA.	P
-632	-632	.278 .273	.280			.218 .216		BB348-632	.217	.610	6-32UNJC-3B	.39	.222 .219		.285	.655
-832	-832	.317 .312	.315	.330		.257 .255		BB348-832	.255	.650	8-32UNJC-3B	.43	.264 .258		.335	.695
-1024	-1032	.372 .367	.380	.420	.460	.312 .309		BB348-1024	.309	.830	10-24UNJC-3B	.47	.319 .313		.410	.870
-1032	-1032	.372 .367	.380	.420	.460	.312 .309		BB348-1032	.309	.710	10-32UNJF-3B	.47	.319 .313		.410	.750
-420	-428	.450 .445	.450	.450	.450	.390 .387		BB348-420	.383	.980	1/4-20UNJC-3B	.61	.397 .391		.510	1.030
-428	-428	.450 .445	.450	.450	.450	.390 .387		BB348-12	.383	.950	1/4-28UNJF-3B	.61	.397 .391		.510	1.000
-518	-524	.528 .523	.500	.500	.500	.468 .465		BB348-518	.458	1.100	5/16-18UNJC-3B	.68	.477 .469		.600	1.140
-524	-524	.528 .523	.500	.500	.500	.468 .465		BB348-14	.458	1.010	5/16-24UNJF-3B	.68	.477 .469		.600	1.050
-616	-624	.590 .585	.550	.550	.550	.530 .527		BB348-616	.521	1.170	3/8-16UNJC-3B	.73	.539 .531		.662	1.210
-624	-624	.590 .585	.550	.550	.550	.530 .527		BB348-16	.521	1.070	3/8-24UNJF-3B	.73	.539 .531		.662	1.110

BN330 SLEEVE

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

⑥ MATERIAL: Type 305 stainless steel per QQ-S-763.

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

EXAMPLE: BN330-624-12 = Sleeve for 3/8-24 bolt, 3/4 grip length.

BB348 EXPANDER

NOTE: Threads per MIL-S-8879.

MATERIAL: Type 431 stainless steel per Spec. AMS6628.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: BB348-() = Cadmium plate per QQ-P-416, Type I, Class 3.
BB348-()PB = Cadmium plate per QQ-P-416, Type II, Class 2.
BB348-()TF = Hi-Kote 2.

CODE: Dash number indicates expander used in assembly.
Letters "LK" after part number indicate expander with locking feature.

EXAMPLE: BB348-16 = Expander for 3/8-24 bolt with cadmium plate per
QQ-P-416, Type I, Class 3 finish, no lock.
BB348LK-16TF = Expander for 3/8-24 bolt with locking feature and
Hi-Kote 2 finish.

BN388 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: BN388LK-624-12
— Grip Length (Thickness of Work)
in 16ths = 3/4 Grip Length
— Expander Finish
— Size of Bolt To Be Used = 3/8-24 Bolt
— Locking Feature (Optional)
— Blind Nut Assembly

BN388LK-624TF12 = Same as above except expander
with Hi-Kote 2 finish.

TITLE							
BLIND NUT™ ASSEMBLY							
100° COUNTERSUNK SHALLOW HEAD							
DOME TYPE							
DRAWN	DATE	APPROVAL	DATE	REVISION	DATE	D. P. S.	DRAWING NUMBER
				10		8-20-91	BN388

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