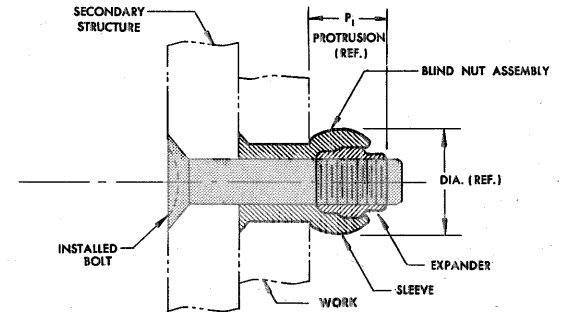
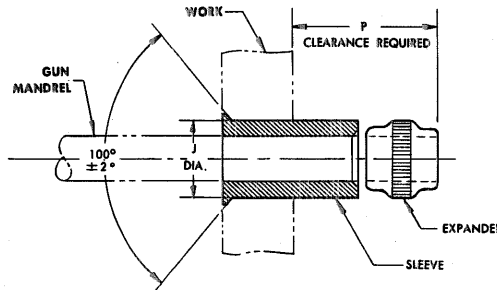
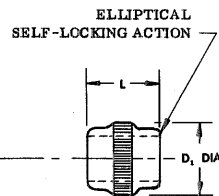
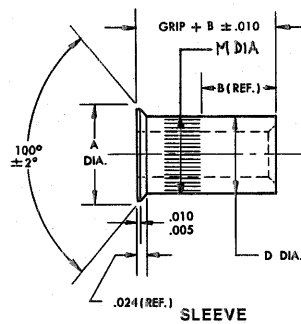


hi-shear
CORPORATION

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Torrance, California 90509 U.S.A.
Telephone (310) 326-8110
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EXPANDER

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

COMPLETED BLIND NUT ASSEMBLY
SHOWING SECONDARY STRUCTURE
AND INSTALLED BOLT

BN518 BLIND NUT ASSEMBLY		BN517 SLEEVE							BB341, BB341G EXPANDER				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.	M DIA.	PART NUMBER	D ₁ DIA.	L	THREAD	J HOLE DIA.	P	D ₂ DIA.		P ₁
-440		-440	.229 .224	.210	.225	-	.166 .162	.169 .167	BB341-5	.167	.153	4-40NC-3B	.173 .170	.373	.210		.175
-632		-632	.278 .273	.280	.295	.350	.215 .211	.218 .216	BB341-632	.217	.215	6-32NC-3B	.222 .219	.505	.285		.260
-832		-832	.317 .312	.315	.330	.370	.254 .251	.257 .255	BB341-8	.255	.245	8-32NC-3B	.264 .258	.570	.335		.290
-1032		-1032	.372 .367	.380	.420	.460	.309 .305	.312 .309	BB341-1032	.309	.307	10-32NF-3B	.319 .313	.697	.410		.350
-428		-428	.450 .445	.450	.450	.450	.387 .383	.390 .387	BB341-12	.383	.368	1/4-28UNF-3B	.397 .391	.828	.510		.420
-420		-428	.450 .445	.450	.450	.450	.387 .383	.390 .387	BB341-420	.383	.368	1/4-20UNC-3B	.397 .391	.828	.510		.420
-524		-524	.528 .523	.500	.500	.500	.465 .461	.468 .465	BB341-14	.458	.429	5/16-24UNF-3B	.477 .469	.939	.600		.470
-518		-524	.528 .523	.500	.500	.500	.465 .461	.468 .465	BB341-518	.458	.429	5/16-18UNC-3B	.477 .469	.939	.600		.470
-624		-624	.590 .585	.550	.550	.550	.527 .523	.530 .527	BB341-16	.521	.491	3/8-24UNF-3B	.539 .531	1.050	.662		.530
-616		-624	.590 .585	.550	.550	.550	.527 .523	.503 .527	BB341-616	.521	.491	3/8-16UNC-3B	.539 .531	1.050	.662		.530
-720		-720	.652 .647	.600	.600	.600	.589 .585	.592 .589	BB341-720	.585	.552	7/16-20UNF-3B	.605 .593	1.162	.720		.592
-714		-720	.652 .647	.600	.600	.600	.589 .585	.592 .589	BB341-714	.585	.552	7/16-14UNC-3B	.605 .593	1.162	.720		.592
-820		-820	.714 .709	.650	.650	.650	.651 .647	.654 .651	BB341-820	.643	.614	1/2-20UNF-3B	.664 .656	1.275	.785		.650
-813		-820	.714 .709	.650	.650	.650	.651 .647	.654 .651	BB341-813	.643	.614	1/2-13UNC-3B	.664 .656	1.275	.785		.650

"BLIND NUT" is a trademark of Hi-Shear Corporation

DRAWN		DATE		TITLE	
Brlej		2-9-65		BLIND NUT ASSEMBLY	
APPROVED		DATE		100° COUNTERSUNK SHALLOW HEAD	
R.W.T.		2-9-65			
REVISION		DATE		DRAWING NUMBER	
⑦		J.R.H. 3-17-99		BN518	

SHEET 1 OF 2

BN518



BN517 SLEEVE

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

MATERIAL: Aluminum 2017 per QQ-A-430.

HEAT TREAT: Anneal.

FINISH: Anodize (clear).

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

EXAMPLE: BN517-428-12 = Sleeve for 1/4-28 bolt, 3/4" grip length.

BB341 EXPANDER

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

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

HEAT TREAT: 125,000 psi shear minimum.

FINISH: BB341-() = Cadmium plate per QQ-P-416,
Type I, Class 2.
BB341G() = Silver plate per AMS2410, .0002-
.0004 thickness.

CODE: Dash number indicates expander used in assembly.

EXAMPLES: BB341-12 = Self-locking expander for 1/4-28 bolt.

BN518 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: BN518-428-12

└─ 3/4 Grip Length
└─ For 1/4-28 Bolt
└─ Blind Nut Assembly which includes
BN517 Sleeve and BB341 Expander

BN518

SHEET 2 OF 2

BN518