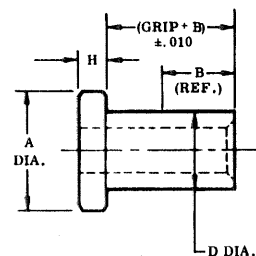
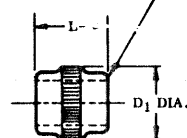


hi-shear
CORPORATION

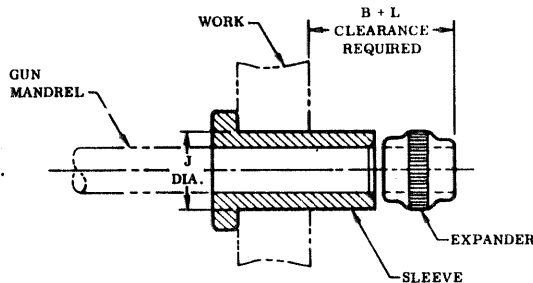
2800 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90508
AREA CODE 213 • 778-3181 • 328-8110



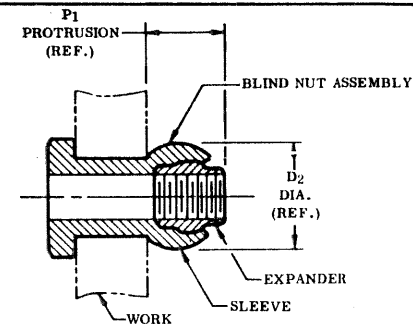
SLEEVE



EXPANDER



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



COMPLETED BLIND NUT ASSEMBLY

BN523 BLIND NUT ASSEMBLY		BN524 SLEEVE						BB415 EXPANDER				HOLE PREPARATION			PROTRUSION AFTER INSTALLATION		
FIRST DASH NUMBER		FIRST DASH NUMBER	A DIA.	B GRIP RANGE 0-1/8"	B GRIP RANGE 1/8-1/4"	B GRIP RANGE 1/4-1/2"	D DIA.	H	PART NUMBER	D1 DIA.	L	THREAD	J HOLE DIA.	P	D2 DIA.	P1	
-832		-832	.412 .387	.315	.330	—	.257 .255	.090 .080	BB415-8	.255	.245	8-32UNJC-3B	.264 .258		.335	.290	
-1032		-1032	.505 .475	.380	.420	.460	.312 .309	.110 .100	BB415-1032	.309	.307	10-32UNJF-3B	.319 .313		.410	.350	
-428		-428	.615 .580	.450	.450	.450	.390 .387	.155 .145	BB415-12	.383	.368	1/4-28UNJF-3B	.397 .391		.510	.420	
-524		-524	.803 .768	.500	.500	.500	.468 .465	.160 .150	BB415-14	.458	.429	5/16-24UNJF-3B	.475 .469		.600	.470	
-624		-624	.896 .861	.550	.550	.550	.530 .527	.185 .175	BB415-16	.521	.491	3/8-24UNJF-3B	.539 .531		.662	.530	

BN524 SLEEVE

GENERAL NOTES: 1. Concentricity: Hole to "D" diameter within .005 TIR;
Head to "D" diameter within .010 TIR.

MATERIAL: Type 347 stainless steel per QQ-S-763.

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

EXAMPLE: BN524-428-12 = Sleeve for 1/4-28 bolt, 3/4 mean assembly
grip length.

BB415 EXPANDER

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

MATERIAL: A-286 alloy steel per AMS5731.

HEAT TREAT: 110,000 psi shear minimum.

FINISH: Solid film lube per MIL-L-8937.

CODE: Dash number indicates expander used
in assembly.

EXAMPLE: BB415-12 = Expander for 1/4-28 bolt.

BN523 BLIND NUT ASSEMBLY

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

① EXAMPLE: BN523-428-12
— 3/4 Mean Assembly Grip Length
For 1/4-28 Bolt
Blind Nut Assembly which includes:
BN524 Sleeve and BB415 Expander

U.S. PATENT 2,959,999. FOREIGN PATENTS
ISSUED AND PENDING.

TITLE					
BLIND NUT ASSEMBLY					
PROTRUDING HEAD STYLE					
DRAWN	DATE	APPROVED	DATE	REVISION	DATE
Blj	7-30-65	Shrode	7-31-65	4	Shrode
DRAWING NUMBER					BN523

CODE IDENTIFICATION NO. 73107

© 1971 Hi-Shear Corporation

BN523