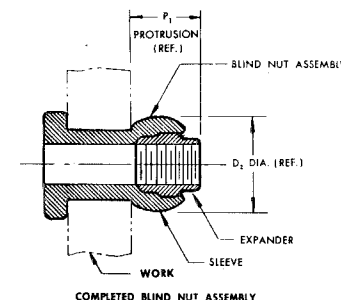
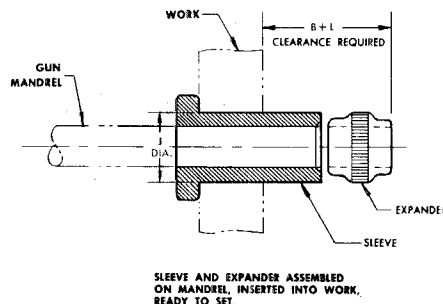
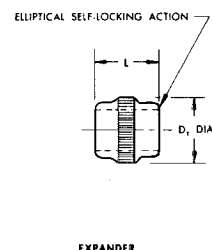
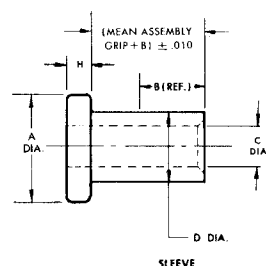


**hi-shear**  
CORPORATION

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TORRANCE, CALIFORNIA 90509  
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BLIND NUT ASSEMBLY		BN552 SLEEVE								BB415GA EXPANDER				HOLE PREPARATION				PROTRUSION AFTER INSTALLATION	
FIRST DASH NUMBER		FIRST DASH NUMBER	A DIA.	B GRIP RANGE D1-D2	B GRIP RANGE D2-D3	B GRIP RANGE D3-D4	D DIA.	H	C DIA.	PART NUMBER	D1 DIA.	L	THREAD	J HOLE DIA.				D2 DIA.	P1
-428		-428	.615 .580	.450	.450	.450	.390 .387	.100 .090	—	BB415GA-12	.383	.368	1/4-28UNJF-3B	.397 .391				.510	.420
-428A		-428A	.615 .580	.450	.450	.450	.390 .387	.100 .090	.259 .255	BB415GA-12	.383	.368	1/4-28UNJF-3B	.397 .391				.510	.420

#### BN552 SLEEVE

NOTE: Concentricity: Hole to "D" diameter within .005 TIR.  
Head to "D" diameter within .010 TIR.

① MATERIAL: Type A-286 per AMS5731.

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: BN552-428-12 = Sleeve for 1/4-28 bolt, 3/4 mean assembly grip length.

#### BB415GA EXPANDER

NOTE: Threads per MIL-S-8879.

① MATERIAL: Type A-286 per AMS5731, cold worked 40-50% and aged to meet double shear strength requirements of 110,000 psi minimum.

FINISH: Silver plate per AMS2411, .0002-.0004 thick.

CODE: Dash number indicates expander used in assembly.

EXAMPLE: BB415GA-12 = Expander for 1/4-28 bolt.

#### BN549 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.

EXAMPLE: BN549-428-12  
— 3/4 Mean Assembly Grip Length  
— For 1/4-28 Bolt  
— Blind Nut Assembly which includes:  
BN552 Sleeve and BB415GA Expander

U.S. Patent 2,959,999. Foreign patents issued and pending.

TITLE									
BLIND NUT™ ASSEMBLY									
PROTRUDING HEAD STYLE									
DRAWN	DATE	APPROVAL	DATE	REVISION	DATE	DRAWING NUMBER			
AHS	9-28-70	<i>[Signature]</i>	10/6/70	3	Shrode	BN549			

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BN549