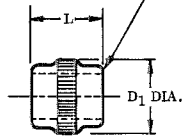


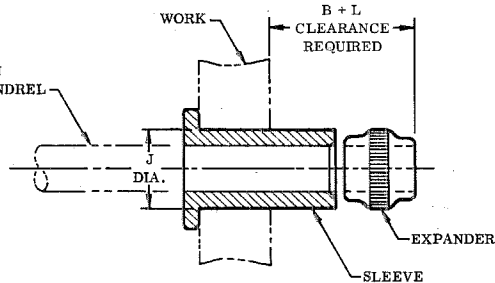
SLEEVE

ELLIPTICAL SELF-LOCKING ACTION

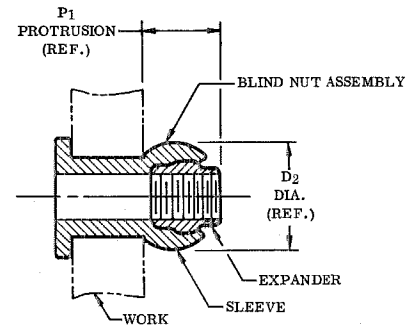


EXPANDER

GUN MANDREL



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



COMPLETED BLIND NUT ASSEMBLY

BN568 BLIND NUT ASSEMBLY		BN569 SLEEVE							BB341 EXPANDER				HOLE PREPARATION		PROTRUSION AFTER INSTALLATION	
FIRST DASH NUMBER		FIRST DASH NUMBER	A DIA.	B GRIP RANGE 0-1/4	C GRIP RANGE 1/4-1/2	D GRIP RANGE 1/2-3/4	D DIA.	H	PART NUMBER	D1 DIA.	L	THREAD	J HOLE DIA.	P	D2 DIA.	P1
-440		-440	.294 .274	.210			.169 .167	.038 .028	BB341-5	.167	.153	4-40UNJC-3B	.173 .170		.210	.175
-632		-632	.315 .295	.280			.218 .216	.045 .035	BB341-632	.217	.215	6-32UNJC-3B	.222 .219		.285	.260
-832		-832	.412 .387	.315	.330		.257 .255	.063 .053	BB341-8	.255	.245	8-32UNJC-3B	.264 .258		.335	.290
-1020		-1032	.505 .475	.380	.420	.460	.312 .309	.077 .067	BB341-1032 BB341-1024	.309	.307	10-32UNJF-3B 10-24UNJC-3B	.319 .313		.410	.350
-420		-428	.615 .580	.450	.450	.450	.390 .387	.110 .100	BB341-12 BB341-420	.383	.368	1/4-28UNJF-3B 1/4-20UNJC-3B	.397 .391		.510	.420
-518		-524	.803 .768	.500	.500	.500	.468 .465	.115 .105	BB341-14 BB341-518	.458	.429	5/16-24UNJF-3B 5/16-18UNJC-3B	.477 .469		.600	.470
-616		-624	.895 .861	.550	.550	.500	.530 .527	.130 .120	BB341-16 BB341-616	.521	.491	3/8-24UNJF-3B 3/8-16UNJC-3B	.539 .531		.662	.530

BN569 SLEEVE

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

MATERIAL: Aluminum 2017 per QQ-A-351 or QQ-A-430.

FINISH: Anneal.

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

EXAMPLE: BN569-428-12 = Sleeve for 1/4-28 bolt, 3/4 grip length.

BB341 EXPANDER

NOTE: 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 3.
BB341G = Silver plate per AMS2410.

CODE: Dash number indicates Expander used in assembly.

EXAMPLE: BB341-12 = Expander for 1/4-28 Bolt.

BN568 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: BN568-428-12
3/4 Grip Length
For 1/4-28 Bolt
Blind Nut Assembly which includes:
BN569 Sleeve and BB341 Expander

BN568G-428-12 = As example except with BB341G Expander.

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

TITLE					
BLIND NUT ASSEMBLY PROTRUDING HEAD STYLE ALUMINUM SLEEVE					
DRAWN	DATE	APPROVED	DATE	REVISION	DATE
Shrode	10-13-72	Shrode	10-13-72	2	Shrode 2-25-75
DRAWING NUMBER					BN568

CODE IDENTIFICATION NO. 73197

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