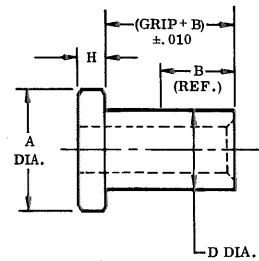


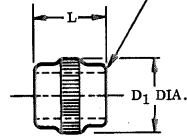
**hi-shear**  
CORPORATION

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



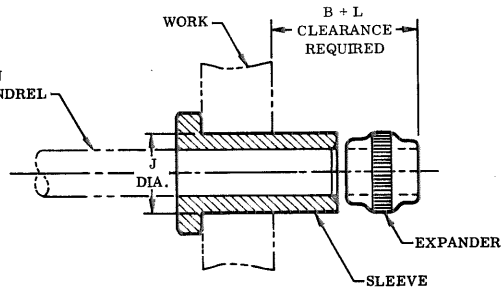
SLEEVE

ELLIPTICAL SELF-LOCKING ACTION

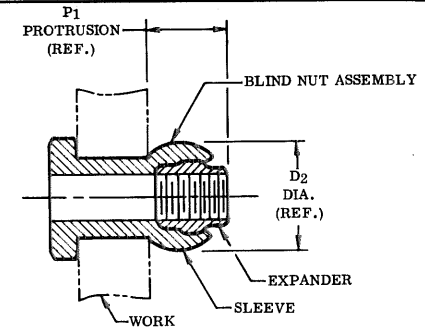


EXPANDER

GUN  
MANDREL



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



COMPLETED BLIND NUT ASSEMBLY

BLIND NUT ASSEMBLY		BN136 SLEEVE							BB567, BB567GA EXPANDER				HOLE PREPARATION			PROTRUSION AFTER INSTALLATION	
FIRST DASH NUMBER		FIRST DASH NUMBER	A DIA.	B GRIP RANGE 0-1/4	D GRIP RANGE 1/4-1/2	S GRIP RANGE 1/2-1 1/4	D DIA.	H	PART NUMBER	D1 DIA.	L	THREAD	J HOLE DIA.			D2 DIA.	P1
-440		-440	.294 .274	.210			.169 .167	.055 .045	BB567-5	.167	.153	4-40UNJC-3B	.173 .170			.210	.175
-632		-632	.315 .295	.280			.218 .216	.065 .055	BB567-632	.217	.215	6-32UNJC-3B	.222 .219			.285	.260
-832		-832	.412 .387	.315	.330		.257 .255	.090 .080	BB567-8	.255	.245	8-32UNJC-3B	.264 .258			.335	.290
-1020		-1032	.505 .475	.380	.420	.460	.312 .309	.110 .100	BB567-1020 BB567-1032	.309	.307	10-20UNJC-3B 10-32UNJF-3B	.319 .313			.410	.350
-420		-428	.615 .580	.450	.450	.450	.390 .387	.155 .145	BB567-420 BB567-12	.383	.368	1/4-20UNJC-3B 1/4-28UNJF-3B	.397 .391			.510	.420
-518		-524	.803 .768	.500	.500	.500	.468 .465	.160 .150	BB567-518 BB567-14	.458	.429	5/16-18UNJC-3B 5/16-24UNJF-3B	.475 .469			.600	.470
-616		-624	.896 .861	.550	.550	.550	.530 .527	.185 .175	BB567-616 BB567-16	.521	.491	3/8-16UNJC-3B 3/8-24UNJF-3B	.539 .531			.662	.530

#### BN136 SLEEVE

NOTE: Concentricity: Hole to "D" diameter within .005 FIR;  
head to "D" diameter within .010 FIR.

MATERIAL: Type 321 stainless steel per QQ-S-763.

① FINISH: Abrasive clean and passivate.

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

EXAMPLE: BN136-428-12 = Sleeve for 1/4-28 bolt, 3/4 grip length.

#### BB567 AND BB567GA EXPANDER

NOTE: Threads per MIL-S-8879.

MATERIAL: PH13-8Mo stainless steel per AMS5629.

HEAT TREAT: 125,000 psi shear minimum.

① FINISH: BB567 = Dry film lube per MIL-L-8937, and  
cetyl alcohol lube per Hi-Shear Spec. 305.  
BB567GA = Silver plate per AMS2411.

CODE: Dash number indicates Expander used in assembly.

① EXAMPLE: BB567-12 = Expander for 1/4-28 bolt,  
dry film lube.  
BB567GA-12 = Expander for 1/4-28 bolt, silver plated.

#### BN135 AND BN135GA BLIND NUT ASSEMBLY

① CODE: First dash number indicates size of bolt to be used.  
Second dash number indicates grip length (thickness  
of work) in 16ths. Letters "GA" after basic assembly  
number indicate type of finish. No letter indicates  
Expander with dry film lube.

EXAMPLE: BN135-428-12  
3/4 Grip Length  
For 1/4-28 Bolt  
Blind Nut Assembly which includes:  
BN136 Sleeve and BB567 Expander

BN135GA-428-12 = As example except with  
Expander BB567GA.

TITLE					
BLIND NUT ASSEMBLY					
PROTRUDING HEAD STYLE					
DRAWN	DATE	APPROVED	DATE	REVISION	DRAWING NUMBER
Shrode	2-14-73	Shrode	2-15-73	1	BN135
CODE IDENTIFICATION NO. 73197					© 1974, Hi-Shear Corporation

U.S. Patents 2,789,619; 2,946,208; and 2,959,999.  
Foreign patents granted and pending.

BN135