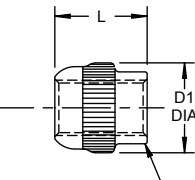
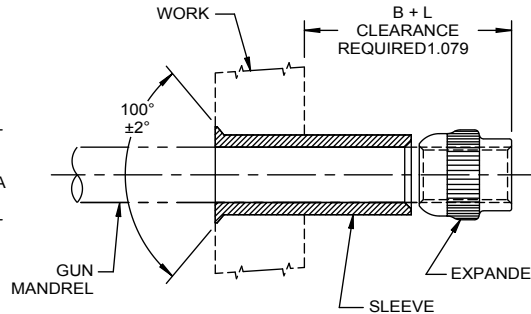


SLEEVE

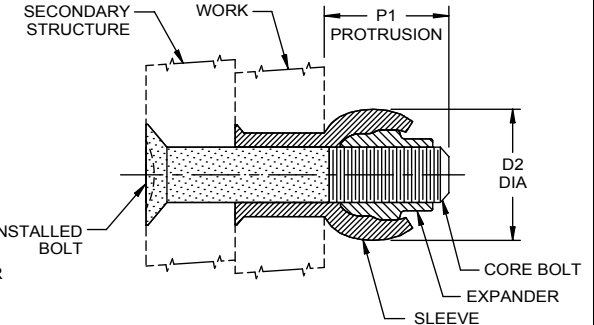
RADIUS
 OPTIONAL



EXPANDER



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



**COMPLETED BLIND NUT ASSEMBLY
 SHOWING SECONDARY STRUCTURE
 AND INSTALLED BOLT**

BLIND NUT ASSEMBLY		BN515PB SLEEVE					BB500PBT EXPANDER					SUGGESTED 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	DASH NO.	D1 DIA REF	L LENGTH	THREAD	HOLE DIA		D2 DIA REF	P1 REF
-832		-832	.317 .312	.315	.330	.370	.254 .251	-8	.255	.205	.1640-32UNJC-3B	.264 .258		.335	.247
-1032		-1032	.372 .367	.380	.420	.460	.309 .305	-1032 -1024	.309	.240	.1900-32UNJF-3B .1900-24UNJC-3B	.319 .313		.410	.283
-428		-428	.450 .445	.450	.450	.450	.387 .383	-12 -420	.383	.300	.2500-28UNJF-3B .2500-20UNJC-3B	.397 .391		.510	.343
-524		-524	.528 .523	.500	.500	.500	.465 .461	-14 -518	.458	.351	.3125-24UNJF-3B .3125-18UNJC-3B	.477 .469		.600	.395

⑥

BN515PB SLEEVE

NOTE: 1. Concentricity: Hole to "D1" diameter within .005 FIM. "D" diameter to head within .005 FIM.

MATERIAL: Type 305 stainless steel per AMS-QQ-S-763.

HEAT TREAT: Anneal.

FINISH: BN515PB()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.

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

EXAMPLE: BN515PB428-12 = Sleeve for 1/4-28 or 1/4-20 bolt, 3/4 grip length.

BB500PBT EXPANDER

NOTE: 1. Threads per AS8879.
 2. Expander length accommodates NAS bolt thread length.

MATERIAL: Type AISI 431 stainless steel per AMS5628.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: BB500PBT() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and HI-KOTE™ 2.

CODE: Dash number indicates expander used in assembly.

EXAMPLE: BB500PBT12 = Expander for 1/4-28 bolt.

BN338 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: ⑥ BN338PBT428-12
 Nominal Grip Length
 For 1/4-28 Bolt
 Finish Code
 Blind Nut Assembly which includes:
 BN515PB Sleeve and BB500PBT Expander.

IS A TRADEMARK OF HI-SHEAR CORPORATION

DRAWN BY J.F.OBISPO	DATE 1990-09-05	TITLE BLIND NUT ASSEMBLY 100° COUNTERSUNK SHALLOW HEAD SHORT EXPANDER
APPROVED E.E.BEELES	DATE 1990-09-05	
REVISION ⑥	DATE F.CARINGELLA 2018-01-02	DRAWING NUMBER BN338

1 OF 1