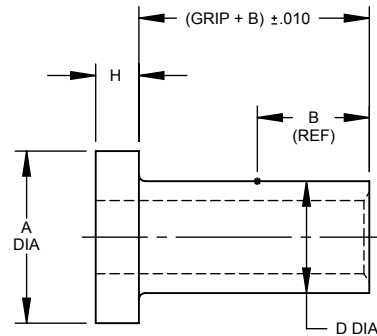
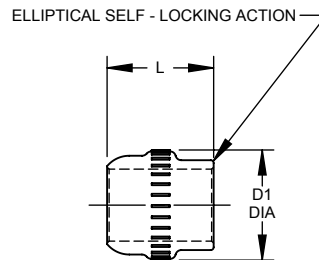


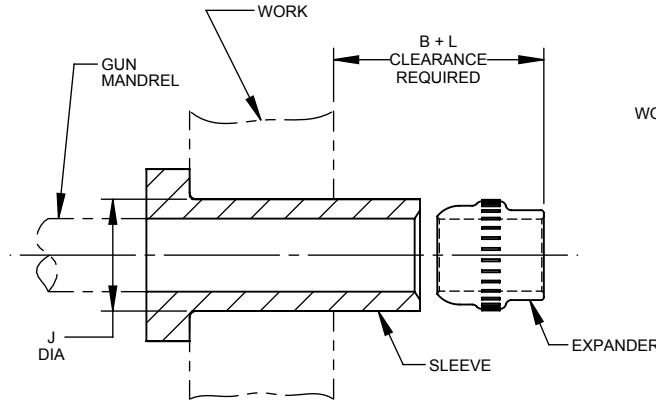
⑩



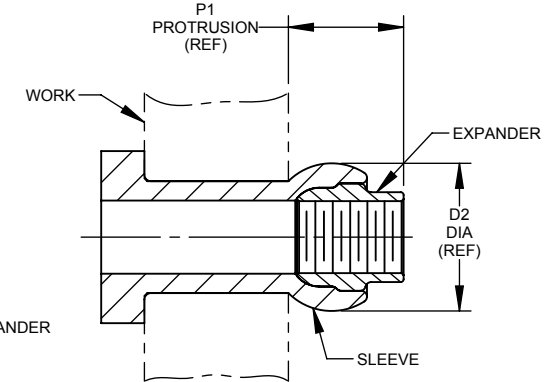
SLEEVE



EXPANDER



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



COMPLETED BLIND NUT ASSEMBLY

BLIND NUT ASSEMBLY		BN326 SLEEVE						BB341 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 (REF)	H	PART NUMBER	D1 DIA	L	THREAD	J HOLE DIA	D2 DIA	P1
440	440	.294 .274	.210	-	-	.169 .167	.055 .045	BB341-5	.167	.153	.1120-40UNJC-3B	.173 .170	.210	.175
632	632	.315 .295	.280	-	-	.218 .216	.065 .055	BB341-632	.217	.215	.1380-32UNJC-3B	.222 .219	.285	.260
832	832	.412 .387	.315	.330	-	.257 .255	.090 .080	BB341-8	.255	.245	.1640-32UNJC-3B	.264 .258	.335	.290
1032	1032	.505 .475	.380	.420	.460	.312 .309	.110 .100	BB341-1032	.309	.307	.1900-32UNJF-3B	.319 .313	.410	.350
1024	1024	.475	.380	.420	.460	.312 .309	.110 .100	BB341-1024	.309	.307	.1900-24UNJC-3B	.319 .313	.410	.350
428	428	.615 .580	.450	.450	.450	.390 .387	.155 .145	BB341-12	.383	.368	.2500-28UNJF-3B	.397 .391	.510	.420
420	420	.580	.450	.450	.450	.387 .384	.145 .140	BB341-420	.383	.368	.2500-20UNJC-3B	.391 .384	.510	.420
524	524	.803 .768	.500	.500	.500	.468 .465	.160 .150	BB341-14	.458	.429	.3125-24UNJF-3B	.477 .469	.600	.470
518	518	.768	.500	.500	.500	.465 .462	.150 .145	BB341-518	.458	.429	.3125-18UNJC-3B	.469 .462	.600	.470
624	624	.896 .861	.550	.550	.550	.530 .527	.185 .175	BB341-16	.521	.491	.3750-24UNJF-3B	.539 .531	.662	.530
616	616	.861	.550	.550	.550	.527 .524	.175 .170	BB341-616	.521	.491	.3750-16UNJC-3B	.531 .524	.662	.530

BN356 BLIND NUT ASSEMBLY

EXAMPLE: BN356 PB 428 - 12

⑩

- Grip Length in 16ths = 3/4 Grip Length
- Expander Finish Code, Cadmium plate, Type I, Class 2 (BB341-12) (See Expander "Finish" note for explanation of code letters)
- Size of Bolt To Be Used = 1/4-28 Bolt
- Sleeve Finish Code, Cadmium plate, Type II, Class 2 (BN326PB428) (See Sleeve "Finish" note for explanation of code letters)
- Blind Nut Assembly which includes: BN326 Sleeve and BB341 Expander
- BN356G428-12 = As example except with BB341G Expander
- BN356PB428PB12 = BN326PB Sleeve and BB341PB Expander.

BN326 SLEEVE

NOTE: 1. Concentricity: Hole to "D" diameter within .005 FIM.
Head to "D" diameter within .010 FIM.

MATERIAL: Type CRES: 305 per AMS-QQ-S-763.

FINISH: BN326(-)(-) = Sand Blast.
BN326PB(-)(-) = 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.
See "Finish" note for explanation of code letters.

EXAMPLE: BN326-428-12 = Sleeve for 1/4-28 bolt, 3/4 grip length.

BB341EXPANDER

NOTE: 1. Threads per AS8879.

MATERIAL: Type AISI 431 stainless steel per AMS5628.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: BB341(-) = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
BB341G(-) = Silver plate per AMS2410 (.0002-.0004 thick), and cetyl alcohol lube per Hi-Shear Spec. 305.
BB341PB(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

CODE: Dash number indicates expander used in assembly.
See "Finish" note for explanation of code letters.

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

SPECIFICATION: Product Specification HS396.

IS A TRADEMARK OF HI-SHEAR CORPORATION

DRAWN BY V.H.	DATE 1960-03-28	⑩	TITLE BLIND NUT ASSEMBLY PROTRUDING HEAD STYLE
APPROVED SCHUSTER	DATE 1960-03-28		
REVISION ⑩	DATE F.CARINGELLA 2018-01-02	DRAWING NUMBER BN356	

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