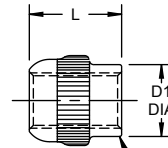
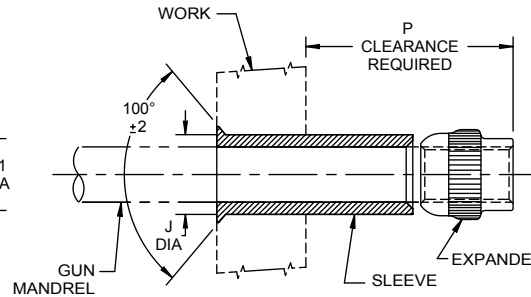


**SLEEVE**

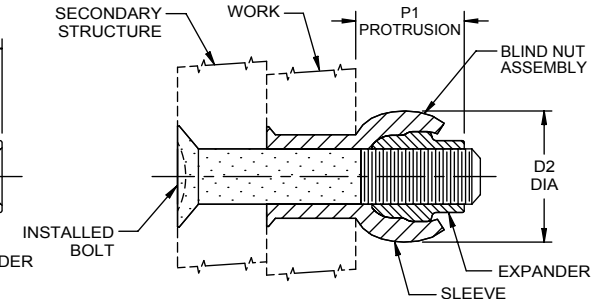


ELLIPTICAL SELF-LOCKING  
 ACTION AND MANUFACTURER'S  
 TRADEMARK. LOCATION OPTIONAL  
 ON THIS SURFACE.

**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		BN515 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)	PART NO.	D1 DIA	L LENGTH	THREAD	J HOLE DIA	P	D2 DIA REF	P1 REF
440		440	.229 .224	.210	-	-	.166 .162	BB341-5	.167	.153	.1120-40UNJC-3B	.173 .170	.373	.210	.175
632		632	.278 .273	.280	-	-	.215 .211	BB341-632	.217	.215	.1380-32UNJC-3B	.222 .219	.505	.285	.260
832		832	.317 .312	.315	.330	-	.254 .251	BB341-8	.255	.245	.1640-32UNJC-3B	.264 .258	.570	.335	.290
1032		1032	.372 .367	.380	.420	.460	.309 .305	BB341-1032	.309	.307	.1900-32UNJF-3B	.319 .313	.697	.410	.350
428		428	.450 .445	.450	.450	.450	.387 .383	BB341-12	.383	.368	.2500-28UNJF-3B	.397 .391	.828	.510	.420
420		420						BB341-420			.2500-20-UNJC-3B				
524		524	.528 .523	.500	.500	.500	.465 .461	BB341-14	.458	.429	.3125-24UNJF-3B	.477 .469	.939	.600	.470
518		518						BB341-518			.3125-18UNJC-3B				
624		624	.590 .585	.550	.550	.550	.527 .523	BB341-16	.521	.491	.3750-24UNJF-3B	.539 .531	1.050	.662	.530
616		616						BB341-616			.3750-16UNJC-3B				
720		720	.652 .647	.600	.600	.600	.589 .585	BB341-720	.585	.552	.4375-20UNJF-3B	.605 .593	1.162	.720	.592
714		714						BB341-714			.4375-14UNJC-3B				
820		820	.714 .709	.650	.650	.650	.651 .647	BB341-820	.643	.614	.5000-20UNJF-3B	.664 .656	1.275	.785	.650
813		813						BB341-813			.5000-13UNJC-3B				

**BN516 BLIND NUT ASSEMBLY**

**EXAMPLE:** BN516PB428 - 12

⑦

- 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 (BN330PB428)  
 (See Sleeve "Finish" note for explanation of code letters)
- Blind Nut Assembly

BN515PB428PB12 = As example, except with BN515PB Sleeve and BB341PB Expander.

**BN515 SLEEVE**

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

**MATERIAL:** Type CRES: 305 per AMS-QQ-S-763, 302 HQ, or 18-9 LW  
 (ASTM A-493).

**HEAT TREAT:** BN515-( )-( ) = Anneal.

**FINISH:** BN515-( )-( ) = None.  
 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.  
 See "Finish" note for explanation of code letters.

**EXAMPLE:** BN515PB-428-12 = Sleeve for 1/4-28 or 1/4-20 bolt, 3/4 grip  
 length. with cadmium plate, Type II, Class 2.

**BB341 EXPANDER**

**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.

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 = Self-locking Expander for 1/4-28 bolt, with  
 cadmium plate, Type I.

**SPECIFICATION:** Product Specification HS396.

IS A TRADEMARK OF HI-SHEAR CORPORATION

DRAWN BY RKN	DATE 1967-08-21	⑦	TITLE BLIND NUT ASSEMBLY 100° COUNTERSINK SHALLOW HEAD
APPROVED R. TRINGHAM	DATE 1967-08-24		
REVISION ⑦	DATE F. CARINGELLA 2018-01-02		DRAWING NUMBER <b>BN516</b>