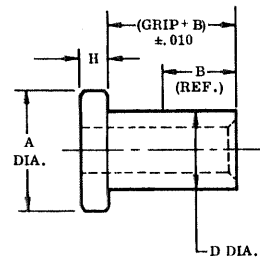


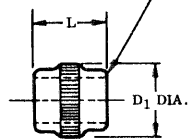
**hi-shear**  
CORPORATION

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

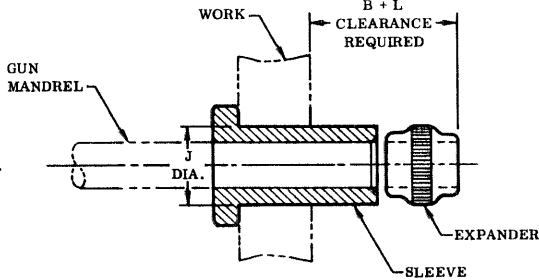


SLEEVE

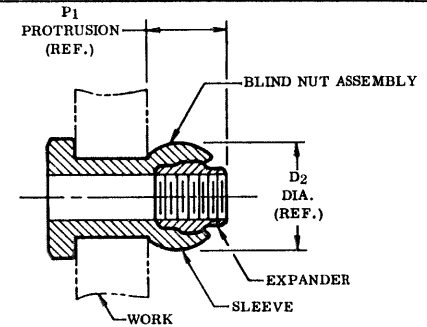
ELLIPTICAL SELF-LOCKING ACTION



EXPANDER



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



COMPLETED BLIND NUT ASSEMBLY

| BLIND NUT ASSEMBLY |  | BN326 SLEEVE      |              |                    |                      |                      |              |              | BB415 EXPANDER           |              |      |                                  | HOLE PREPARATION |  |  | PROTRUSION AFTER INSTALLATION |      |  |
|--------------------|--|-------------------|--------------|--------------------|----------------------|----------------------|--------------|--------------|--------------------------|--------------|------|----------------------------------|------------------|--|--|-------------------------------|------|--|
| FIRST DASH NUMBER  |  | FIRST DASH NUMBER | A DIA.       | B GRIP RANGE 0-1/4 | B GRIP RANGE 1/4-1/2 | B GRIP RANGE 1/2-3/4 | D DIA.       | H            | ① PART NUMBER            | D1 DIA.      | L    | THREAD                           | J HOLE DIA.      |  |  | D2 DIA.                       | P1   |  |
| -440               |  | -440              | .294<br>.274 | .210               | —                    | —                    | .169<br>.167 | .055<br>.045 | BB415-5                  | .167         | .153 | 4-40UNJC-3B                      | .173<br>.170     |  |  | .210                          | .175 |  |
| -632               |  | -632              | .315<br>.295 | .280               | —                    | —                    | .218<br>.216 | .065<br>.055 | BB415-632                | .217         | .215 | 6-32UNJC-3B                      | .222<br>.219     |  |  | .285                          | .260 |  |
| -832               |  | -832              | .412<br>.387 | .315               | .330                 | —                    | .257<br>.255 | .090<br>.080 | BB415-8                  | .255         | .245 | 8-32UNJC-3B                      | .264<br>.258     |  |  | .335                          | .290 |  |
| -1020              |  | -1032             | .505<br>.475 | .380               | .420                 | .460                 | .312<br>.309 | .110<br>.100 | BB415-1020<br>BB415-1032 | .309<br>.307 | .307 | 10-20UNJC-3B<br>10-32UNJF-3B     | .319<br>.313     |  |  | .410                          | .350 |  |
| -420               |  | -428              | .615<br>.580 | .450               | .450                 | .450                 | .390<br>.387 | .155<br>.145 | BB415-420<br>BB415-12    | .383         | .368 | 1/4-20UNJC-3B<br>1/4-28UNJF-3B   | .397<br>.391     |  |  | .510                          | .420 |  |
| -518               |  | -524              | .803<br>.768 | .500               | .500                 | .500                 | .468<br>.465 | .160<br>.150 | BB415-518<br>BB415-14    | .458         | .429 | 5/16-18UNJC-3B<br>5/16-24UNJF-3B | .475<br>.469     |  |  | .600                          | .470 |  |
| -616               |  | -624              | .896<br>.861 | .550               | .550                 | .550                 | .530<br>.527 | .185<br>.175 | BB415-616<br>BB415-16    | .521         | .491 | 3/8-16UNJC-3B<br>3/8-24UNJF-3B   | .539<br>.531     |  |  | .662                          | .530 |  |
|                    |  |                   |              |                    |                      |                      |              |              |                          |              |      |                                  |                  |  |  |                               |      |  |

BN326 SLEEVE

BB415 EXPANDER

BN542 BLIND NUT ASSEMBLY

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

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

FINISH: Sandblast.

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

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

NOTE: Threads per MIL-S-8879.

MATERIAL: A-286 stainless steel per AMS5731.

HEAT TREAT: 110,000 psi shear minimum.

FINISH: Solid film lube per MIL-L-8937.

CODE: Dash number indicates Expander used in assembly.

EXAMPLE: BB415-12 = Expander for 1/4-28 bolt.

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

EXAMPLE: BN542-428-12  
                  └─ 3/4 Grip Length  
                  └─ For 1/4-28 Bolt  
                  └─ Blind Nut Assembly which includes:  
                            BN326 Sleeve and BB415 Expander

U.S. PATENT 2,959,999. FOREIGN PATENTS  
ISSUED AND PENDING.

|                       |      |          |         |          |                |
|-----------------------|------|----------|---------|----------|----------------|
| TITLE                 |      |          |         |          |                |
| BLIND NUT ASSEMBLY    |      |          |         |          |                |
| PROTRUDING HEAD STYLE |      |          |         |          |                |
| DRAWN                 | DATE | APPROVED | DATE    | REVISION | DRAWING NUMBER |
| ASH 5-7-68            |      | Shrode   | 6-18-73 | 3        | BN542          |

CODE IDENTIFICATION NO. 73107

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