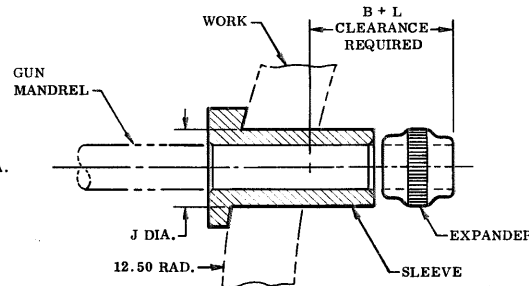
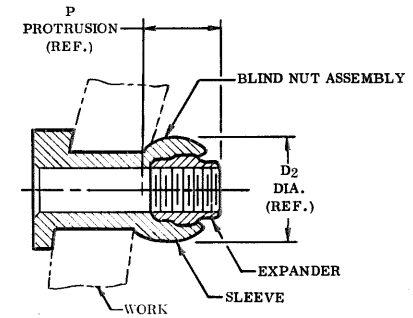


SLEEVE

EXPANDER



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



COMPLETED BLIND NUT ASSEMBLY

| BLIND NUT ASSEMBLY | BN131 SLEEVE      |                   |        |      |        |      |      | BB341 EXPANDER |             |                     | HOLE PREPARATION | PROTRUSION AFTER INSTALLATION |             |                     |      |
|--------------------|-------------------|-------------------|--------|------|--------|------|------|----------------|-------------|---------------------|------------------|-------------------------------|-------------|---------------------|------|
|                    | FIRST DASH NUMBER | FIRST DASH NUMBER | A DIA. | B    | D DIA. | H    | E    | K              | PART NUMBER | D <sub>1</sub> DIA. | L                | THREAD                        | J HOLE DIA. | D <sub>2</sub> DIA. | P    |
| -624               | -624              | .815              | .550   | .530 | .210   | .230 | .180 |                | BB341-16    | .521                | .491             | 3/8-24UNJF-3B                 | .539        | .662                | .530 |
| -616               |                   | .715              |        | .527 | .190   | .260 | .160 |                | BB341-616   |                     |                  | 3/8-16UNJC-3B                 | .531        |                     |      |
| -820               |                   | 1.015             |        | .654 | .310   | .420 | .230 |                | BB341-820   |                     |                  | 1/2-20UNJF-3B                 | .664        | .785                | .650 |
| -813               | -820              | .985              | .650   | .651 | .290   | .400 | .210 |                | BB341-813   | .643                | .614             | 1/2-13UNJC-3B                 | .656        |                     |      |

**BN131 SLEEVE**

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

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

HEAT TREAT: Anneal.

FINISH: Sandblast.

CODE: First dash number indicates size of bolt to be used. Second dash number indicates grip length (thickness of work) in 10ths.

EXAMPLE: EN131-820-12 = Sleeve for 1/2-20 or 1/2-13 bolt, 3/4 grip length.

**BB341 EXPANDER**

NOTE: 1. Threads per MIL-S-8879.

MATERIAL: Type 431 stainless steel per Spec. QQ-S-763.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: Cadmium plate per QQ-P-416, Type I, Class 3.

CODE: Dash number indicates Expander used in assembly.

EXAMPLE: BB341-820 = Expander for 1/2-20 Bolt.

**BN130 BLIND NUT ASSEMBLY**

CODE: First dash number indicates size of bolt to be used. Second dash number indicates grip length (thickness of work) in 10ths.

EXAMPLE: BN130-820-12  
 — 3/4 Grip Length  
 — For 1/2-20 Bolt  
 — Blind Nut Assembly which includes:  
 BN131 Sleeve and BB341 Expander

"Blind Nut" is a trademark of Hi-Shear Corporation.

| TITLE                         |        |                |        |          |                     |
|-------------------------------|--------|----------------|--------|----------|---------------------|
| BLIND NUT™ ASSEMBLY           |        |                |        |          |                     |
| 25" DIAMETER TUBE APPLICATION |        |                |        |          |                     |
| DRAWN                         | DATE   | APPROVED       | DATE   | REVISION | DRAWING NUMBER      |
| <i>Perkins</i>                | 6-9-72 | <i>Perkins</i> | 6-9-72 | ①        | D. P. S.<br>8-20-91 |
|                               |        |                |        |          | <b>BN130</b>        |