



BLIND NUT ASSEMBLY		BN515 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 1/2-1 1/4	D DIA.	PART NUMBER	D1 DIA.	L	THREAD	J HOLE DIA.	P	D1 DIA.	P1
-440		-440	.229 .224	.210			.169 .167	BB415-5	.167	.153	4-40UNJC-3B	.173 .170	.373	.175	.210
-632		-632	.278 .273	.280			.218 .216	BB415-632	.217	.215	6-32UNJC-3B	.222 .219	.505	.260	.285
-832		-832	.317 .312	.315	.330		.257 .255	BB415-8	.255	.245	8-32UNJC-3B	.264 .258	.570	.290	.335
-1032		-1032	.372 .367	.380	.420	.460	.312 .309	BB415-1032	.309	.307	10-32UNJF-3B	.319 .313	.697	.350	.410
-428		-428	.450 .445	.450	.450	.450	.390 .387	BB415-12	.383	.368	1/4-28UNJF-3B	.397 .391	.828	.420	.510
-420		-428	.450 .445	.450	.450	.450	.390 .387	BB415-420	.383	.368	1/4-20UNJC-3B	.397 .391	.828	.420	.510
-524		-524	.528 .523	.500	.500	.500	.468 .465	BB415-14	.458	.429	5/16-24UNJF-3B	.477 .469	.939	.470	.600
-518		-524	.528 .523	.500	.500	.500	.468 .465	BB415-518	.458	.429	5/16-18UNJC-3B	.477 .469	.939	.470	.600
-624		-624	.590 .585	.550	.550	.550	.530 .527	BB415-16	.521	.491	3/8-24UNJF-3B	.539 .531	1.050	.530	.662
-616		-624	.590 .585	.550	.550	.550	.530 .527	BB415-616	.521	.491	3/8-16UNJC-3B	.539 .531	1.050	.530	.662
-720		-720	.652 .647	.600	.600	.600	.592 .589	BB415-720	.585	.552	7/16-20UNJF-3B	.605 .593	1.162	.592	.720
-714		-720	.652 .647	.600	.600	.600	.592 .589	BB415-714	.585	.552	7/16-14UNJC-3B	.605 .593	1.162	.592	.720
-820		-820	.714 .709	.650	.650	.650	.654 .651	BB415-820	.643	.614	1/2-20UNJF-3B	.664 .656	1.275	.650	.785
-813		-820	.714 .709	.650	.650	.650	.654 .651	BB415-813	.643	.614	1/2-13UNJC-3B	.664 .656	1.275	.650	.785

**BN515 SLEEVE**

GENERAL NOTES: 1. Concentricity: Hole to "D" diameter within .005 TIR;  
"D" diameter to head within .005 TIR.

① MATERIAL: Type 305 stainless steel per QQ-S-763.

HEAT TREAT: Anneal.

FINISH: None.

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

EXAMPLE: BN515-428-12 = Sleeve for 1/4-28 or 1/4-20 bolt, 3/4 grip length.

**BB415 EXPANDER**

GENERAL NOTES: 1. Threads per MIL-S-8879.

MATERIAL: A-286 per AMS5731.

HEAT TREAT: 110,000 psi minimum shear.

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

CODE: Dash number indicates expander used in assembly.

EXAMPLE: BB415-12 = Self-locking expander for 1/4-28 bolt.

**BN325 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: BN325-428-12  

 3/4 Grip Length  
 For 1/4-28 Bolt  
 Blind Nut Assembly which includes:  
 BN515 Sleeve and BB415 Expander

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

TITLE					
BLIND NUT™ ASSEMBLY					
100° COUNTERSUNK SHALLOW HEAD					
DRAWN	DATE	APPROVED	DATE	REVISION	DATE
<i>Shane 23075</i>				①	D. P. S. 8-20-91
					<b>BN325</b>