



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		BN515.64PB SLEEVE						BB500PBT EXPANDER				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.	DASH NO.	D1 DIA.	L	THREAD	HOLE DIA.	D2 DIA.	P1		
-832	-832	.332 .327	.315	.330	----	.272 .270	-8	.255	.245	8-32UNC-3B	.279 .273	.350	.290		
-1032	-1032	.387 .382	.380	.420	.460	.327 .324	-1032 -1024	.309	.307	10-32UNF-3B	.334 .328	.440	.350		
-428	-428	.465 .460	.450	.450	.450	.405 .402	-12 -420	.383	.368	1/4-28UNF-3B 1/4-20UNC-3B	.414 .406	.525	.420		
-524	-524	.543 .538	.500	.500	.500	.483 .480	-14 -518	.458	.429	5/16-24UNF-3B 5/16-20UNC-3B	.482 .484	.615	.470		

BN515.64PB 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: Cadmium plate per 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.

EXAMPLE: BN515.64PB-428-12 = Sleeve for 1/4-28 bolt, 3/4" grip length.

BB500PBT EXPANDER

NOTE: 1. Threads per MIL-S-8879. 2. Expander length accommodates NAS bolt thread lengths.

MATERIAL: Type 431 stainless steel per Spec. AMS5628.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: Cadmium plate per QQ-P-416, Type II, Class 2, and Hi-Kote 2.

CODE: Dash number indicates expander used in assembly.

EXAMPLE: BB500PBT-12 = Expander for 1/4-28 bolt.

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: BN388.64PBT-428-12

3/4 Grip Length
For 1/4-28 Bolt
Blind Nut Assembly which includes
BN515.64PB Sleeve & BB500PBT Expander

"BLIND NUT" is a trademark of Hi-Shear Corporation.

DRAWN D.P.S.	DATE 8-20-93	TITLE BLIND NUT™ ASSEMBLY
APPROVED <i>JAT</i>	DATE 8-23-93	100° COUNTERSUNK SHALLOW HEAD SHORT EXPANDER 1/64" OVERSIZE
REVISION	DATE	DRAWING NUMBER BN338.64

BN338.64