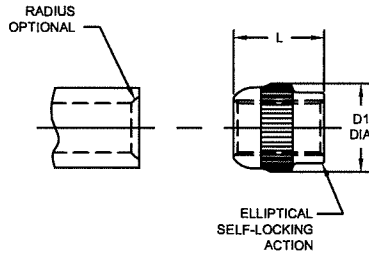
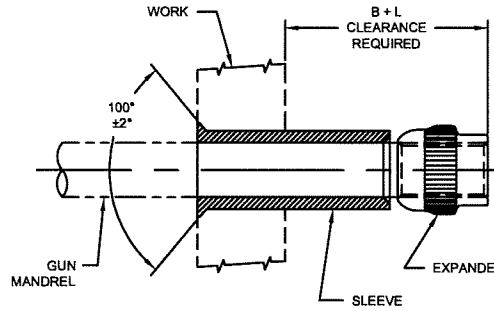


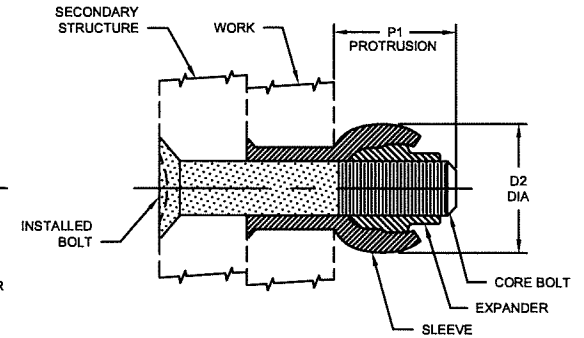
SLEEVE



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		BN515PB SLEEVE						BB500PBT 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	DASH NO.	D1 DIA REF	L LENGTH	THREAD	HOLE DIA		D2 DIA REF	P1 REF
-832		-832	.317 .312	.315	.330	.370	.254 .251	-8	.255	.205	8-32UNJC-3B	.264 .258		.335	.247
-1032		-1032	.372 .367	.380	.420	.460	.309 .305	-1032 -1024	.309	.240	10-32UNJF-3B 10-24UNJC-3B	.319 .313		.410	.283
-428		-428	.450 .445	.450	.450	.450	.387 .383	-12 -420	.383	.300	1/4-28UNJF-3B 1/4-20UNJC-3B	.397 .391		.510	.343
-524		-524	.528 .523	.500	.500	.500	.465 .461	-14 -518	.458	.351	5/16-24UNJF-3B 5/16-18UNJC-3B	.477 .469		.600	.395

BN515PB SLEEVE

NOTE: 1. Concentricity: Hole to "D1" diameter within .005 FIM. "D" diameter to head within .005 FIM.

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

HEAT TREAT: Anneal.

FINISH: 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.

EXAMPLE: BN515PB428-12 = Sleeve for 1/4-28 or 1/4-20 bolt, 3/4 grip length.

BB500PBT EXPANDER

NOTE: 1. Threads per AS8879. 2. Expander length accommodates NAS bolt thread length.

MATERIAL: Type AISI 431 stainless steel per AMS5628.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: BB500PBT(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and Hi-Kote 2.

CODE: Dash number indicates expander used in assembly.

EXAMPLE: BB500PBT12 = Expander for 1/4-28 bolt.

BN338 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: BN338PBT428-12
 Nominal Grip Length For 1/4-28 Bolt
 Blind Nut Assembly which includes: BN515PB Sleeve and BB500PBT Expander.

BN338

DRAWN		DATE	TITLE	
J.F.Obispo		9-5-90	BLIND NUT™ ASSEMBLY	
APPROVED		DATE	100° COUNTERSUNK SHALLOW HEAD SHORT EXPANDER	
E.E.Beeles		9-5-90		
REVISION		DATE	DRAWING NUMBER	
⑤		JFO 4-27-09	BN338	