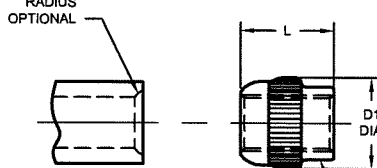
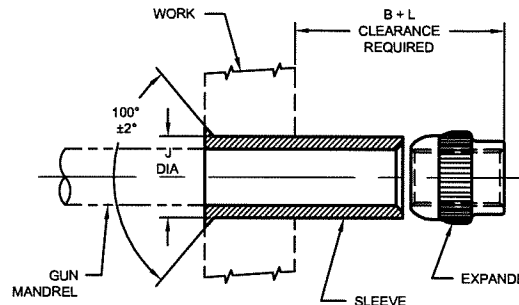


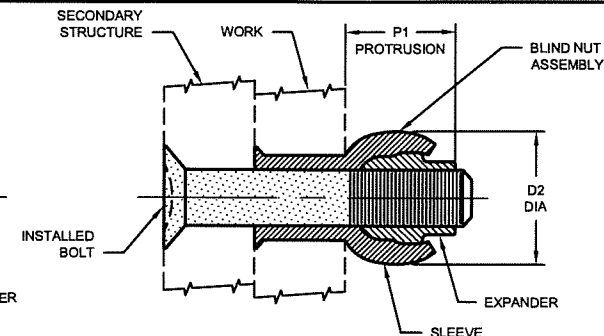
**SLEEVE**



**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		BN330 SLEEVE						BB341 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 (REF)	PART NO.	D1 DIA	L LENGTH	THREAD	J HOLE DIA		D2 DIA REF	P1 REF
440		440	.229 .224	.210	-	-	.169 .167	BB341-5	.167	.153	4-40UNJC-3B	.173 .170		.210	.175
632		632	.278 .273	.280	-	-	.218 .216	BB341-632	.217	.215	6-32UNJC-3B	.222 .219		.285	.260
832		832	.317 .312	.315	.330	-	.257 .255	BB341-8	.255	.245	8-32UNJC-3B	.264 .258		.335	.290
1032		1032	.372 .367	.380	.420	.460	.312 .309	BB341-1032 BB341-1024	.309	.307	10-32UNJF-3B 10-24UNJC-3B	.319 .313		.410	.350
428		428	.450 .445	.450	.450	.450	.390 .387	BB341-12 BB341-420	.383	.368	1/4-28UNJF-3B 1/4-20-UNJC-3B	.397 .391		.510	.420
524		524	.528 .523	.500	.500	.500	.468 .465	BB341-14 BB341-518	.458	.429	5/16-24UNJF-3B 5/16-18UNJC-3B	.477 .469		.600	.470
624		624	.590 .585	.550	.550	.550	.530 .527	BB341-16 BB341-616	.521	.491	3/8-24UNJF-3B 3/8-16UNJC-3B	.539 .531		.662	.530
720		720	.652 .647	.600	.600	.600	.592 .589	BB341-720 BB341-714	.585	.552	7/16-20UNJF-3B 7/16-14UNJC-3B	.601 .593		.720	.592
820		820	.714 .709	.650	.650	.650	.654 .651	BB341-820 BB341-813	.643	.614	1/2-20UNJF-3B 1/2-13UNJC-3B	.664 .656		.785	.650

**BN360 BLIND NUT ASSEMBLY**

**EXAMPLE:** BN360 - 428 - 12  
 Grip Length in 16ths = 3/4 Grip Length  
 Expander Finish, Cadmium plate, Type I, Class 2 (BB341-12)  
 (See Expander "Finish" note for explanation of code letters)  
 Size of Bolt To Be Used = 1/4-28 Bolt  
 Sleeve Finish, Abrasive clean, (BN330-428)  
 (See Sleeve "Finish" note for explanation of code letters)  
 Blind Nut Assembly

BN360PB428PB12 = As example, except with BN330PB Sleeve and BB341PB Expander.

**BN330 SLEEVE**

**NOTE:** 1. Concentricity: Hole to "D" diameter within .005 FIM.  
Head to "D" diameter within .005 FIM.

**MATERIAL:** Type CRES: 305 per AMS-QQ-S-763, 302 HQ, or 18-9 LW (ASTM A-493).

**FINISH:** BN330(-)(-) = Abrasive clean.  
BN330PB(-)(-) = 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.  
See "Finish" note for explanation of code letters.

**EXAMPLE:** BN330-428-12 = Sleeve for 1/4-28 or 1/4-20 bolt, 3/4 grip length.

**BB341 EXPANDER**

**NOTE:** 1. Threads per AS8879.

**MATERIAL:** Type AISI 431 stainless steel per AMS5628.

**HEAT TREAT:** 125,000 psi shear minimum.

**FINISH:** BB341(-) = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.  
BB341DU(-) = Solid film lube per AS5272, Type I.  
BB341G(-) = Silver plate per AMS2410 (.0002-.0004 thick), and cetyl alcohol lube per Hi-Shear Spec. 305.  
BB341GU(-) = Silver plate per AMS2410 (.0002-.0004 thick), no lube.  
BB341PB(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.  
BB341PV(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, solid film lube per AS5272, Type I and cetyl alcohol lube per Hi-Shear Spec. 305.  
BB341TF(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.

**CODE:** Dash number indicates expander used in assembly.  
See "Finish" note for explanation of code letters.

**EXAMPLE:** BB341-12 = Expander for 1/4 bolt.

**SPECIFICATION:** Product Specification HS396.

**BN360**

DRAWN		DATE	TITLE
Hales		7-18-55	<b>BLIND BOLT™ ASSEMBLY</b> 100° COUNTERSUNK SHALLOW HEAD
APPROVED	DATE		
Cassna		7-18-55	
REVISION		DATE	DRAWING NUMBER
(38)	J.F. Obispo	9-23-09	<b>BN360</b>