



BN518 BLIND NUT ASSEMBLY		BN517 SLEEVE							BB341, BB341G 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.	M DIA.	PART NUMBER	D <sub>1</sub> DIA.	L	THREAD	J HOLE DIA.	P	D <sub>2</sub> DIA.	P <sub>1</sub>	
-440	-440	.229 .224	.210	.225	-	.166 .167	.169 .167	BB341-5	.167	.153	4-40NC-3B	.173 .170	.373	.210	.175	
-632	-632	.278 .273	.280	.295	.350	.215 .211	.218 .216	BB341-632	.217	.215	6-32NC-3B	.222 .219	.505	.285	.260	
-832	-832	.317 .312	.315	.330	.370	.254 .251	.257 .255	BB341-8	.255	.245	8-32NC-3B	.264 .258	.570	.335	.290	
-1032	-1032	.372 .367	.380	.420	.460	.309 .305	.312 .309	BB341-1032	.309	.307	10-32NF-3B	.319 .313	.697	.410	.350	
-428	-428	.450 .445	.450	.450	.450	.387 .383	.390 .387	BB341-12	.383	.368	1/4-28UNF-3B	.397 .391	.828	.510	.420	
-420	-428	.450 .445	.450	.450	.450	.387 .383	.390 .387	BB341-420	.383	.368	1/4-20UNC-3B	.397 .391	.828	.510	.420	
-524	-524	.528 .523	.500	.500	.500	.465 .461	.468 .465	BB341-14	.458	.429	5/16-24UNF-3B	.477 .469	.939	.600	.470	
-518	-524	.528 .523	.500	.500	.500	.465 .461	.468 .465	BB341-518	.458	.429	5/16-18UNC-3B	.477 .469	.939	.600	.470	
-624	-624	.590 .585	.550	.550	.550	.527 .523	.530 .527	BB341-16	.521	.491	3/8-24UNF-3B	.539 .531	1.050	.662	.530	
-616	-624	.590 .585	.550	.550	.550	.527 .523	.530 .527	BB341-616	.521	.491	3/8-16UNC-3B	.539 .531	1.050	.662	.530	
-720	-720	.652 .647	.600	.600	.600	.589 .585	.592 .589	BB341-720	.585	.552	7/16-20UNF-3B	.605 .593	1.162	.720	.592	
-714	-720	.652 .647	.600	.600	.600	.589 .585	.592 .589	BB341-714	.585	.552	7/16-14UNC-3B	.605 .593	1.162	.720	.592	
-820	-820	.714 .709	.650	.650	.650	.651 .647	.654 .651	BB341-820	.643	.614	1/2-20UNF-3B	.664 .656	1.275	.785	.650	
-813	-820	.714 .709	.650	.650	.650	.651 .647	.654 .651	BB341-813	.643	.614	1/2-13UNC-3B	.664 .656	1.275	.785	.650	

\*BLIND NUT\* is a trademark of Hi-Shear Corporation

DRAWN Briej	DATE 2-9-65	TITLE <b>BLIND NUT ASSEMBLY</b>
APPROVED R.W.T.	DATE 2-9-65	100° COUNTERSUNK SHALLOW HEAD
REVISION ⑦	DATE J.R.H. 3-17-99	DRAWING NUMBER <b>BN518</b>

**BN517 SLEEVE**

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

**MATERIAL:** Aluminum 2017 per QQ-A-430.

**HEAT TREAT:** Anneal.

**FINISH:** Anodize (clear).

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

**EXAMPLE:** BN517-428-12 = Sleeve for 1/4-28 bolt, 3/4" grip length.

**BB341 EXPANDER**

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

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

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

**FINISH:** BB341-( ) = Cadmium plate per QQ-P-416,  
Type I, Class 2.  
BB341G( ) = Silver plate per AMS2410, .0002-  
.0004 thickness.

**CODE:** Dash number indicates expander used in assembly.

**EXAMPLES:** BB341-12 = Self-locking expander for 1/4-28 bolt.

**BN518 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:** BN518-428-12

└─ 3/4 Grip Length  
└─ For 1/4-28 Bolt  
└─ Blind Nut Assembly which includes  
BN517 Sleeve and BB341 Expander

**BN518**

SHEET 2 OF 2