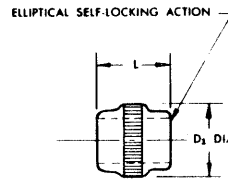
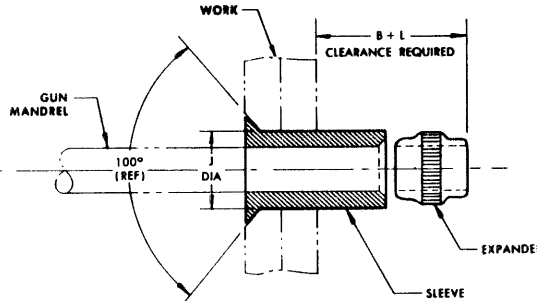


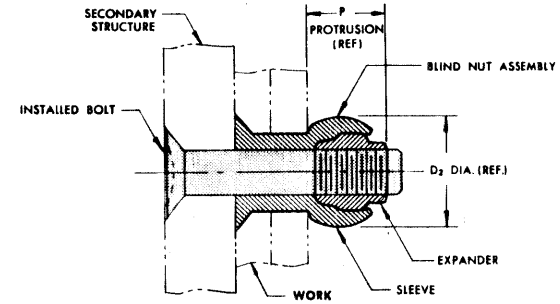
SLEEVE



EXPANDER



SLEEVE AND EXPANDER ASSEMBLED ON MANDREL, INSERTED INTO WORK, READY TO SET.



COMPLETED BLIND NUT ASSEMBLY SHOWING SECONDARY STRUCTURE AND INSTALLED BOLT

BN520 BLIND NUT ASSEMBLY		BN329 SLEEVE							① BB415 EXPANDER				HOLE PREPARATION		PROTRUSION AFTER INSTALLATION	
FIRST DASH NUMBER	FIRST DASH NUMBER	A DIA.	B GRIP RANGE 0-3/4	B GRIP RANGE 1 1/16-1 1/4	B GRIP RANGE 1 1/2-1 3/4	D DIA.	H	PART NUMBER	D1 DIA.	L	THREAD	J HOLE DIA.	D2 DIA.	P		
-832	-832	.3948 .3898	.315	.330	.370	.257 .255	.0578 .0558	BB415-8	.255	.245	8-32UNJC-3B	.264 .258	.335	.290		
-1032	-1032	.4739 .4689	.380	.420	.460	.312 .309	.0679 .0659	BB415-1032	.309	.307	10-32UNJF-3B	.319 .313	.410	.350		
-428	-428	.5604 .5554	.450	.450	.450	.390 .387	.0715 .0695	BB415-12	.383	.368	1/4-28UNJF-3B	.397 .391	.510	.420		
-524	-524	.6680 .6620	.500	.500	.500	.468 .465	.0839 .0814	BB415-14	.458	.429	5/16-24UNJF-3B	.477 .469	.600	.470		
-624	-624	.7540 .7480	.550	.550	.550	.530 .527	.0940 .0915	BB415-16	.521	.491	3/8-24UNJF-3B	.539 .531	.662	.530		

BN329 SLEEVE

GENERAL NOTES: 1. Concentricity: Hole to "D" diameter within .005 TIR; "D" diameter to head within .005 TIR.
2. "H" is dimensioned from maximum "D" diameter.

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

FINISH: Sandblast.

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

EXAMPLE: BN329-428-12 = Sleeve for 1/4-28 bolt, 3/4 grip length.

① BB415 EXPANDER

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

① MATERIAL: A-286 alloy per AMS5731.

HEAT TREAT: 110,000 psi shear minimum.

① FINISH: BB415 - Solid film lube.
BB415GA - Silver plate per AMS2411.

CODE: Dash number indicates expander used in assembly.

① EXAMPLE: BB415-12 = Expander for 1/4-28 bolt.
BB415GA-12 = Expander for 1/4-28 bolt, silver plated.

BN520 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.

① EXAMPLE: BN520-428-12
└─┬─ 3/4 Grip Length
└─┬─ For 1/4-28 Bolt
└─┬─ Blind Nut Assembly which includes:
└─┬─ BN329 Sleeve and BB415 Expander

BN520GA-428-12 = Same as above except with BB415GA Expander.

U. S. Patent 2,959,999. Foreign patents issued and pending.

TITLE						
BLIND NUT™ ASSEMBLY						
100° COUNTERSUNK HEAD STYLE						
DRAWN	DATE	APPROVAL	DATE	REVISION	DATE	DRAWING NUMBER
Brlej	6-29-65	[Signature]	9-13-65	3	Shrode 10-21-71	BN520