



BN545G BLIND NUT ASSEMBLY		BN544 SLEEVE							BB341G EXPANDER				HOLE PREPARATION		PROTRUSION AFTER INSTALLATION		INSTALLATION PRESSURE USING HI-SHEAR TOOLING (PSI)	
FIRST DASH NUMBER	FIRST DASH NUMBER	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.	H	PART NUMBER	D1 DIA.	L	THREAD	J HOLE DIA.	D2 DIA.	P	BG1750	BG2500		
-832	-832	.3948 .3898	.315	.330		.257 .255	.0578 .0558	BB341G-8	.255	.245	8-32UNJC-3B	.264 .258	.385	.290	1100	650		
-1024	-1032	.4739 .4689	.380	.420	.460	.312 .309	.0679 .0659	BB341G-1024 BB341G-1032	.309	.307	10-24UNJC-3B 10-32UNJF-3B	.319 .313	.410	.350	1850	950		
-420	-428	.5604 .5554	.450	.450	.450	.390 .387	.0715 .0695	BB341G-420 BB341G-12	.383	.368	1/4-20UNJC-3B 1/4-28UNJF-3B	.397 .391	.510	.420		1450		
-518	-524	.6680 .6620	.500	.500	.500	.468 .465	.0839 .0814	BB341G-518 BB341G-14	.458	.429	5/16-18UNJC-3B 5/16-24UNJF-3B	.477 .469	.600	.470		1900		
-616	-624	.7540 .7480	.550	.550	.550	.530 .527	.0940 .0915	BB341G-616 BB341G-16	.521	.491	3/8-16UNJC-3B 3/8-24UNJF-3B	.539 .531	.662	.530		2250		

BN544 SLEEVE

- NOTE: 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 A-286 meeting composition limits of the AMS specifications and heat treated to meet the requirements of AMS5736.

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: BN544-428-12 = Sleeve for 1/4-28 or 1/4-20 bolt, 3/4 grip length.

BB341G EXPANDER

- NOTE: 1. Threads per MIL-S-8879.

MATERIAL: Type AISI 431 stainless steel.

HEAT TREAT: 125 ksi shear minimum

FINISH: Silver plated per AMS2410,
.0002 - .0004 thick.

CODE: Dash number indicates Expander used in assembly.

EXAMPLE: BB341G-12 = Expander for 1/4-28 bolt.

BN545G 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: BN545G-428-12
3/4 Grip Length
For 1/4-28 Bolt
Blind Nut Assembly which includes:
BN544 Sleeve and BB341G Expander

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

TITLE					
BLIND NUT ASSEMBLY					
100° CSK HEAD STYLE					
DRAWN	DATE	APPROVED	DATE	REVISION	DRAWING NUMBER
AHS	9/17/69	ESH	9-18-69	(5)	Vargas 2-10-76 BN545G

CODE IDENTIFICATION NO. 73197

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