

BLIND NUT ASSEMBLY		BN330 SLEEVE					BB500, BB500G, BB500KW OR BB500PB EXPANDER				HOLE PREPARATION		PROTRUSION AFTER INSTALLATION	
FIRST DASH NUMBER	FIRST DASH NUMBER	A DIA.	B GRIP RANGE 0-1/4	B GRIP RANGE 1/4-1/2	B GRIP RANGE 1/2-3/4	D DIA.	PART NUMBER	D1 DIA.	L	THREAD	J HOLE DIA.		D2 DIA.	P1 MAX.
-440	-440	.229	.210	—	—	.169	BB500-5	.167	.141	4-40UNJC-3B	.173	.170	.210	.262
		.224				.167								
-632	-632	.278	.280	—	—	.218	BB500-632	.217	.180	6-32UNJC-3B	.222	.219	.285	.297
		.273				.216								
-832	-832	.317	.315	.330	—	.257	BB500-8	.255	.205	8-32UNJC-3B	.264	.258	.335	.334
		.312				.255								
-1032	-1032	.372	.380	.420	.460	.312	BB500-1032	.309	.240	10-32UNJF-3B	.319	.313	.410	.370
-1024		BB500-1024					10-24UNJC-3B							
-428	-428	.450	.450	.450	.450	.390	BB500-12	.383	.300	1/4-28UNJF-3B	.397	.391	.510	.430
-420		BB500-420					1/4-20UNJC-3B							
-524	-524	.528	.500	.500	.500	.468	BB500-14	.458	.351	5/16-24UNJF-3B	.477	.469	.600	.482
-518		BB500-518					5/16-18UNJC-3B							
-624	-624	.590	.550	.550	.550	.530	BB500-16	.521	.406	3/8-24UNJF-3B	.539	.531	.662	.537
-616		BB500-616					3/8-16UNJC-3B							
-720	-720	.652	.600	.600	.600	.592	BB500-720	.585	.460	7/16-20UNJF-3B	.601	.593	.720	.590
-714		BB500-714					7/16-14UNJC-3B							
-820	-820	.714	.650	.650	.650	.654	BB500-820	.643	.510	1/2-20UNJF-3B	.664	.656	.785	.642
-813		BB500-813					1/2-13UNJC-3B							

BN330 SLEEVE

NOTE: Concentricity: Hole to "D" diameter within .005 FIR. "D" diameter to head within .005 FIR.

MATERIAL: Type CRES: 305 per QQ-S-763, or 302HQ.

HEAT TREAT: Anneal.

FINISH: Abrasive clean.

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

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

BB500, BB500G, BB500KW OR BB500PB EXPANDER

NOTE: Threads per MIL-S-8879.

MATERIAL: Type CRES: 431 per Spec. AMS5628.

HEAT TREAT: 125 ksi shear minimum.

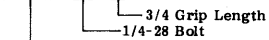
FINISH: BB500 = Cadmium plate per QQ-P-416, Type I, Class 2.
BB500G = Silver plate per AMS2410, .0002-.0004 thick.
BB500KW = Lubeco 905.
BB500PB = Cadmium plate per QQ-P-416, Type II, Class 2.

CODE: Dash number indicates expander used in assembly. "LK" indicates locking feature included.

EXAMPLE: BB500-12 = Expander without locking feature and cadmium plated for 1/4-28 bolt.

BN1558 BLIND NUT ASSEMBLY

EXAMPLES: BN1558-428-12



BN1558KW428-12 = Same as above except with Lubeco 905 on expander.

BN1558LKKW428-12 = Same as above except with Locking Feature and Lubeco 905 on expander.

TITLE					
T.M.					
BLIND NUT ASSEMBLY					
100° COUNTERSUNK SHALLOW HEAD					
DRAWN	DATE	APPROVED	DATE	REVISION	DATE
D.P.S.	6-26-89	LSB	6-26-89	1	D.P.S.
					8-20-91
					DRAWING NUMBER
					BN1558

"Blind Nut" is a trademark of Hi-Shear Corporation.