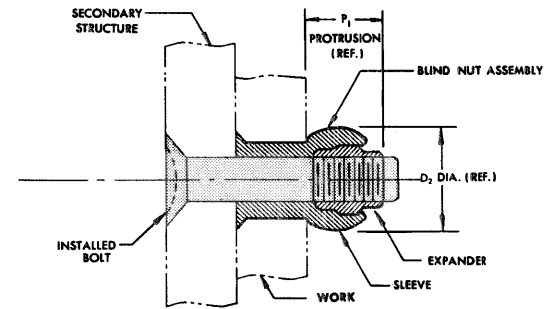


SLEEVE AND EXPANDER ASSEMBLED ON MANDREL, INSERTED INTO WORK, READY TO SET



COMPLETED BLIND NUT ASSEMBLY SHOWING SECONDARY STRUCTURE AND INSTALLED BOLT

BLIND NUT ASSEMBLY		BN330 SLEEVE						BB459 EXPANDER				HOLE PREPARATION		PROTRUSION AFTER INSTALLATION	
FIRST DASH NUMBER		FIRST DASH NUMBER	A DIA.	B GRIP RANGE 0-%	B GRIP RANGE 1/16-1/8	B GRIP RANGE 1/8-1/4	D DIA.	PART NUMBER	D ₂ DIA.	L	THREAD	J HOLE DIA.		D ₂ DIA.	P ₁
-440		-440	.229 .224	.210	—	—	.169 .167	BB459-5	.167	.153	4-40UNJC-3B	.173 .170		.210	.175
-632		-632	.278 .273	.280	—	—	.218 .216	BB459-632	.217	.215	6-32UNJC-3B	.222 .219		.285	.260
-832		-832	.317 .312	.315	.330	—	.257 .255	BB459-8	.255	.245	8-32UNJC-3B	.264 .258		.335	.290
-1032		-1032	.372 .367	.380	.420	.460	.312 .309	BB459-1032 BB459-1024	.309	.307	10-32UNJF-3B 10-24UNJC-3B	.319 .313		.410	.350
-428		-428	.450 .445	.450	.450	.450	.390 .387	BB459-12 BB459-420	.383	.368	1/4-28UNJF-3B 1/4-20UNJC-3B	.397 .391		.510	.420
-524		-524	.528 .523	.500	.500	.500	.468 .465	BB459-14 BB459-518	.458	.429	5/16-24UNJF-3B 5/16-18UNJC-3B	.477 .469		.600	.470
-624		-624	.590 .585	.550	.550	.550	.530 .527	BB459-16 BB459-616	.521	.491	3/8-24UNJF-3B 3/8-16UNJC-3B	.539 .531		.662	.530
-720		-720	.652 .647	.600	.600	.600	.592 .589	BB459-720 BB459-714	.585	.552	7/16-20UNJF-3B 7/16-14UNJC-3B	.601 .593		.720	.592
-820		-820	.714 .709	.650	.650	.650	.654 .651	BB459-820 BB459-813	.643	.614	1/2-20UNJF-3B 1/2-13UNJC-3B	.664 .656		.785	.650

BN330 SLEEVE

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

① 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.

BB459 EXPANDER

NOTE: Threads per MIL-S-8879.

MATERIAL: Type 431 stainless steel per Spec. AMS5628.

HEAT TREAT: 125 KSI shear minimum.

FINISH: BB459 = Cadmium plate per QQ-P-416, Type I, Class 2.
BB459G = Silver plate per AMS2410, .0002-.0004 thick.
BB459PB = Cadmium plate per QQ-P-416, Type II, Class 2.
BB459TF = Hi-Kote 2.

CODE: Dash number indicates expander used in assembly.

EXAMPLE: BB459-12 = Expander for 1/4-28 bolt.

BN362 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).
Letters "G," "PB" and "TF" after basic assembly number indicate type of finish.
No letter indicates expander cadmium plated, Type I.

EXAMPLE: BN362-428-12

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

TITLE					
BLIND NUT ASSEMBLY					
100° COUNTERSUNK SHALLOW HEAD					
DRAWN	DATE	APPROVED	DATE	REVISION	DATE
D. P. S.	2-1-84	E. L. B.	2-7-84	1	D. P. S. 8-20-91
					BN362