



BLIND NUT ASSEMBLY		BN554 SLEEVE							BB453 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	BC2500		
-832	-832	.3943 .3898	.315	.330		.257 .255	.0578 .0558	BB453-8	.255	.245	8-32UNJC-3B	.264 .253	.335	.290	1100	650		
-1024 -1032	-1032	.4739 .4689	.380	.420	.460	.312 .309	.0679 .0659	BB453-1024 BB453-1032	.309	.307	10-24UNJC-3B 10-32UNJF-3B	.319 .313	.410	.350	1850	950		
-420 -428	-428	.5604 .5554	.450	.450	.450	.390 .387	.0715 .0695	BB453-420 BB453-12	.383	.368	1/4-20UNJC-3B 1/4-28UNJF-3B	.397 .391	.510	.420		1450		
-518 -524	-524	.6880 .6620	.500	.500	.500	.468 .465	.0839 .0814	BB453-518 BB453-14	.458	.429	5/16-18UNJC-3B 5/16-24UNJF-3B	.477 .469	.600	.470		1900		
-616 -624	-624	.7540 .7480	.550	.550	.550	.530 .527	.0940 .0915	BB453-616 BB453-16	.521	.491	3/8-16UNJC-3B 3/8-24UNJF-3B	.539 .531	.662	.530		2250		

BN554 SLEEVE

- NOTES: 1. Concentricity: Hole to "D" diameter within .005 FIR. "D" diameter to head within .005 FIR.
2. "H" is dimensioned from maximum "D" diameter.

MATERIAL: Type A-236 meeting composition limits of the AMS specifications.

HEAT TREAT: Head and grip portion of the shank per AMS5732. The remainder per AMS5731.

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: BN554-428-12 = Sleeve for 1/4-28 or 1/4-20 bolt, 3/4 grip length.

BB453 EXPANDER

- GENERAL NOTES: 1. Threads per MIL-8-8879.

MATERIAL: A-286 alloy per AMS5731.

HEAT TREAT: 110,000 psi shear minimum.

① FINISH: BB453 = Fel-Pro C200 solid film lube. BB453DU = Solid film lube.

CODE: Dash number indicates expander used in assembly.

EXAMPLE: BB453-12 = Expander for 1/4-28 bolt.

BN555 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: BN555-428-12
 ↳ 3/4 Grip Length
 ↳ For 1/4-28 Bolt
 ↳ Blind Nut Assembly which includes:
 ↳ BN554 Sleeve and BB453DU Expander

① BN555DU-428-12
 ↳ Size and Grip Length,
 ↳ See Above Example
 ↳ Blind Nut Assembly which includes:
 ↳ BN554 Sleeve and BB453DU Expander

BN555

TITLE					
BLIND NUT™ ASSEMBLY					
100° COUNTERSUNK HEAD STYLE HIGH SHEAR STRENGTH (PRATT & WHITNEY SPECIAL)					
DRAWN	DATE	APPROVED	DATE	REVISION	DATE
<i>Spode</i>	1-18-72	<i>Spode</i>	2-24-72	3	
D. P. S.				DRAWING NUMBER	
3-6-85				BN555	