



BLIND NUT ASSEMBLY		BN330 SLEEVE						BB415G EXPANDER				HOLE PREPARATION		PROTRUSION AFTER INSTALLATION		INSTALLATION PRESSURE PSI USING HI-SHEAR TOOLING	
FIRST DASH NUMBER	FIRST DASH NUMBER	A DIA.	B GRIP RANGE 0-3/4	B GRIP RANGE 3/4-1 1/4	B GRIP RANGE 1 1/4-1 3/4	D DIA.	PART NUMBER	D ₁ DIA.	L	THREAD	J HOLE DIA.	P	D ₂ DIA.	P ₁	GUN NO. BG1750	GUN NO. BG2500	
-440	-440	.229 .224	.210	—	—	.169 .167	BB415G-5	.167	.153	4-40UNJC-3B	.173 .170	B+.163	.210	.175	600	300	
-632	-632	.278 .273	.280	—	—	.218 .216	BB415G-632	.217	.215	6-32UNJC-3B	.222 .219	B+.225	.285	.260	900	450	
-832	-832	.317 .312	.315	.330	—	.257 .255	BB415G-8	.255	.245	8-32UNJC-3B	.264 .258	B+.255	.335	.290	1250	700	
-1024	-1032	.372	.380	.420	.460	.312 .309	BB415G-1024	.309	.307	10-24UNJC-3B	.319 .313	B+.317	.410	.350		1100	
-1032		BB415G-1032					10-32UNJF-3B										
-420	-428	.450	.450	.450	.450	.390 .387	BB415G-420	.383	.368	1/4-20UNJC-3B	.397 .391	B+.378	.510	.420		1550	
-428		BB415G-12					1/4-28UNJF-3B										
-518	-524	.528	.500	.500	.500	.468 .465	BB415G-518	.458	.429	5/16-18UNJC-3B	.477 .469	B+.439	.600	.470		2000	
-524		BB415G-14					5/16-24UNJF-3B										
-616	-624	.590	.550	.550	.550	.530 .527	BB415G-616	.521	.491	3/8-16UNJC-3B	.539 .531	B+.501	.662	.530		2350	
-624		BB415G-16					3/8-24UNJF-3B										
-714	-720	.652	.600	.600	.600	.592 .589	BB415G-714	.585	.552	7/16-14UNJC-3B	.605 .593	B+.562	.720	.592		2350	
-720		BB415G-720					7/16-20UNJF-3B										
-813	-820	.714	.650	.650	.650	.654 .651	BB415G-813	.643	.614	1/2-13UNJC-3B	.664 .656	B+.624	.785	.650		2350	
-820		BB415G-820					1/2-20UNJF-3B										

BN330 SLEEVE

NOTE: 1. Concentricity: Hole to "D" diameter within .005 FIR.
"D" diameter to head within .005 FIR.

① MATERIAL: Type 305 stainless steel per QQ-S-763.

HEAT TREAT: Anneal.

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

BB415G EXPANDER

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

MATERIAL: A-286 stainless steel alloy per AMS5731.

HEAT TREAT: 110,000 psi shear minimum.

FINISH: Silver plate per AMS2410.

CODE: Dash number indicates diameter of blind bolt assembly in 32nds.

EXAMPLE: BB415G-5 = 5/32 nominal diameter blind bolt assembly using 4-40 expander.

BN556G 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: BN556G-624-12
 └── 3/4 Grip Length
 └── For 3/8-24 Bolt
 └── Blind Nut Assembly which includes:
 BN330 Sleeve and BB415G Expander

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

TITLE T.M. BLIND NUT ASSEMBLY 100° COUNTERSUNK SHALLOW HEAD					
DRAWN <i>Shrode 2.15.71</i>	DATE APPROVED <i>C. Johnson 2-26-71</i>	DATE REVISION 3	DATE D. P. S. 10-2-91	DRAWING NUMBER BN556G	