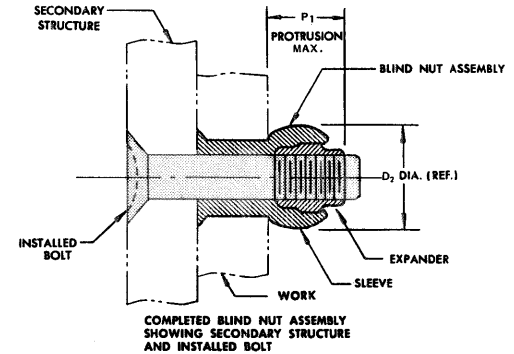
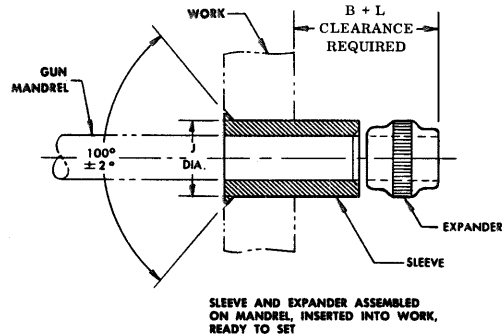
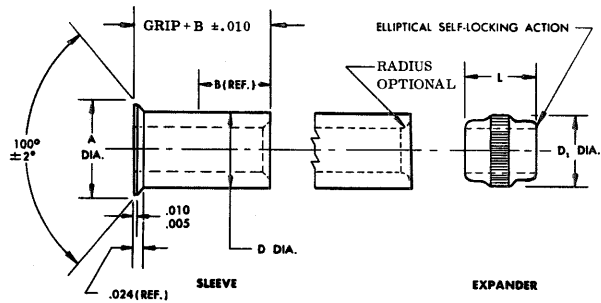




2600 SKYPARK DRIVE  
TORRANCE, CALIFORNIA 90509  
AREA CODE 213 • 775-3181 • 326-8110



| 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             |  | .210                          | .262    |
|                    |  |                   | .224   |                    |                      |                      | .167   |                                            |         |      |                |  | .170             |  |                               |         |
| -632               |  | -632              | .278   | .280               | —                    | —                    | .218   | BB500-632                                  | .217    | .180 | 6-32UNJC-3B    |  | .222             |  | .285                          | .297    |
|                    |  |                   | .273   |                    |                      |                      | .216   |                                            |         |      |                |  | .219             |  |                               |         |
| -832               |  | -832              | .317   | .315               | .330                 | —                    | .257   | BB500-8                                    | .255    | .205 | 8-32UNJC-3B    |  | .264             |  | .335                          | .334    |
|                    |  |                   | .312   |                    |                      |                      | .255   |                                            |         |      |                |  | .258             |  |                               |         |
| -1032              |  | -1032             | .372   | .380               | .420                 | .460                 | .312   | BB500-1032                                 | .309    | .240 | 10-32UNJF-3B   |  | .319             |  | .410                          | .370    |
| -1024              |  |                   | .367   |                    |                      |                      | .309   | BB500-1024                                 |         |      | 10-24UNJC-3B   |  | .313             |  |                               |         |
| -428               |  | -428              | .450   | .450               | .450                 | .450                 | .390   | BB500-12                                   | .383    | .300 | 1/4-28UNJF-3B  |  | .397             |  | .510                          | .430    |
| -420               |  |                   | .445   |                    |                      |                      | .387   | BB500-420                                  |         |      | 1/4-20UNJC-3B  |  | .391             |  |                               |         |
| -524               |  | -524              | .528   | .500               | .500                 | .500                 | .468   | BB500-14                                   | .458    | .351 | 5/16-24UNJF-3B |  | .477             |  | .600                          | .482    |
| -518               |  |                   | .523   |                    |                      |                      | .465   | BB500-518                                  |         |      | 5/16-18UNJC-3B |  | .469             |  |                               |         |
| -624               |  | -624              | .590   | .550               | .550                 | .550                 | .530   | BB500-16                                   | .521    | .406 | 3/8-24UNJF-3B  |  | .539             |  | .662                          | .537    |
| -616               |  |                   | .585   |                    |                      |                      | .527   | BB500-616                                  |         |      | 3/8-16UNJC-3B  |  | .531             |  |                               |         |
| -720               |  | -720              | .652   | .600               | .600                 | .600                 | .592   | BB500-720                                  | .585    | .460 | 7/16-20UNJF-3B |  | .601             |  | .720                          | .590    |
| -714               |  |                   | .647   |                    |                      |                      | .589   | BB500-714                                  |         |      | 7/16-14UNJC-3B |  | .593             |  |                               |         |
| -820               |  | -820              | .714   | .650               | .650                 | .650                 | .654   | BB500-820                                  | .643    | .510 | 1/2-20UNJF-3B  |  | .664             |  | .785                          | .642    |
| -813               |  |                   | .709   |                    |                      |                      | .651   | BB500-813                                  |         |      | 1/2-13UNJC-3B  |  | .656             |  |                               |         |

#### 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.

#### 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

3/4 Grip Length  
1/4-28 Bolt  
Blind Nut Assembly which includes:  
BN330 Sleeve and BB500 Expander  
with Cadmium Plate, Type I, Class 2

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<br>T.M.<br><b>BLIND NUT ASSEMBLY</b><br>100° COUNTERSUNK SHALLOW HEAD |                 |                            |                 |               |        |                 |                                 |
| DRAWN<br>D.P.S.                                                             | DATE<br>6-26-89 | APPROVED<br>L.S.B. 6-26-89 | DATE<br>8-20-91 | REVISION<br>① | D.P.S. | DATE<br>8-20-91 | DRAWING NUMBER<br><b>BN1558</b> |

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