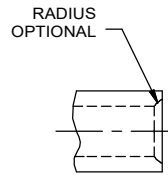
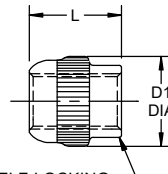


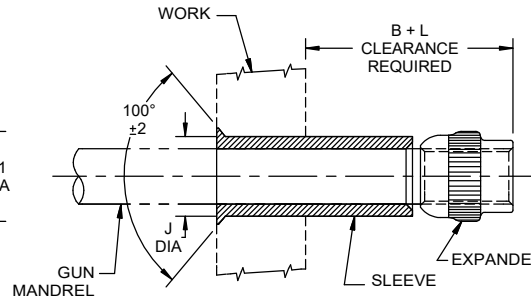
**SLEEVE**



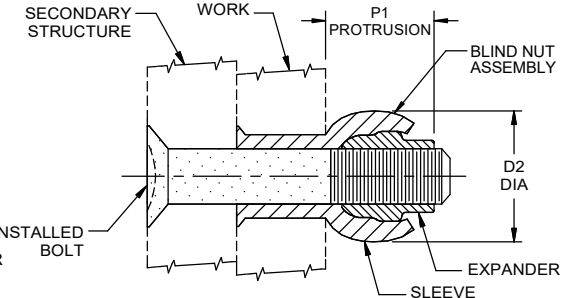
ELLIPTICAL SELF-LOCKING  
ACTION AND MANUFACTURER'S  
TRADEMARK. LOCATION OPTIONAL  
ON THIS SURFACE.



**EXPANDER**



**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					BB500, BB500PB OR BB500G EXPANDER				SUGGESTED HOLE PREPARATION	PROTRUSION AFTER INSTALLATION	
FIRST DASH NO.	FIRST DASH NO.	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	PART NO.	D1 DIA	L LENGTH	THREAD	J HOLE DIA	D2 DIA REF	P1 REF
440	440	.229 .224	.210	-	-	.169 .167	BB500-5	.167	.141	.1120-40UNJC-3B	.173 .170	.210	.175
632	632	.278 .273	.280	-	-	.218 .216	BB500-632	.217	.180	.1380-32UNJC-3B	.222 .219	.285	.210
832	832	.317 .312	.315	.330	-	.257 .255	BB500-8	.255	.205	.1640-32UNJC-3B	.264 .258	.335	.247
1032	1032	.372 .367	.380	.420	.460	.312 .309	BB500-1032	.309	.240	.1900-32UNJF-3B	.319	.410	.283
1024							BB500-1024			.1900-24UNJC-3B	.313		
428	428	.450 .445	.450	.450	.450	.390 .387	BB500-12	.383	.300	.2500-28UNJF-3B	.397 .391	.510	.343
420							BB500-420			.2500-20UNJC-3B	.391		
524	524	.528 .523	.500	.500	.500	.468 .465	BB500-14	.458	.351	.3125-24UNJF-3B	.477 .469	.600	.395
518							BB500-518			.3125-18UNJC-3B	.469		
624	624	.590 .585	.550	.550	.550	.530 .527	BB500-16	.521	.406	.3750-24UNJF-3B	.539 .531	.662	.450
616							BB500-616			.3750-16UNJC-3B	.531		
720	720	.652 .647	.600	.600	.600	.592 .589	BB500-720	.585	.460	.4375-20UNJF-3B	.601 .593	.720	.503
714							BB500-714			.4375-14UNJC-3B	.593		
820	820	.714 .709	.650	.650	.650	.654 .651	BB500-820	.643	.510	.5000-20UNJF-3B	.664 .656	.785	.555
813							BB500-813			.5000-13UNJC-3B	.656		

**BN330 SLEEVE**

**NOTE:** 1. Concentricity: Hole to "D" diameter within .005 FIM.  
Head to "D" diameter within .005 FIM.

⑤ **MATERIAL:** Type CRES: 305 per AMS-QQ-S-763, 302 HQ, or 18-9 LW (ASTM A-493).

**HEAT TREAT:** Anneal per AMS2759.

⑤ **FINISH:** BN330-( )-( ) = Abrasive clean (Process No.5), and Passivate per AMS2700, Method 1, Type 8.  
BN330PB( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.  
**CODE:** First dash number indicates size of bolt to be used.  
Second dash number indicates grip length (thickness of work) in 16ths.  
See "Finish" note for explanation of code letters.

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

**BB500 EXPANDER**

**NOTES:** 1. Threads per AS8879.  
2. Expander length accommodates NAS bolt thread lengths.

**MATERIAL:** Type AISI 431 stainless steel per AMS5628.

**HEAT TREAT:** 125,000 psi shear minimum.

**FINISH:** ⑤ BB500-( ) = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.  
BB500PB( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.  
⑤ BB500G( ) = Silver plate per AMS2410 (.0002-.0004 thick), and cetyl alcohol lube per Hi-Shear Spec. 305.

**CODE:** Dash number indicates expander used in assembly.  
See "Finish" note for explanation of code letters.

**EXAMPLE:** BB500-12 = Expander for 1/4 bolt.

**BN1360 BLIND NUT ASSEMBLY**

**EXAMPLE:** BN1360PB428 - 12

— Grip Length in 16ths = 3/4 Grip Length  
— Expander Finish Code, Cadmium plate, Type I, Class 2 (BB500-12)  
(See Expander "Finish" note for explanation of code letters)  
— Size of Bolt To Be Used = 1/4-28 Bolt  
— Sleeve Finish Code, Cadmium plate, Type II, Class 2 (BN330PB428)  
(See Sleeve "Finish" note for explanation of code letters)  
— Blind Nut Assembly

BN1360PB428PB12 = As example, except with BN330PB Sleeve and BB500PB Expander.

**SPECIFICATION:** Product Specification HS396.

⑤ "BLIND NUT" IS A TRADEMARK OF HI-SHEAR CORPORATION			
DRAWN BY J. H.	DATE 1974-05-15	TITLE BLIND NUT ASSEMBLY 100° COUNTERSUNK SHALLOW HEAD SHORT EXPANDER	
APPROVED GUNDERSON	DATE 1974-05-15	DRAWING NUMBER <b>BN1360</b>	
REVISION ⑤	DATE K. PHAM 2022-10-24	1 OF 1	