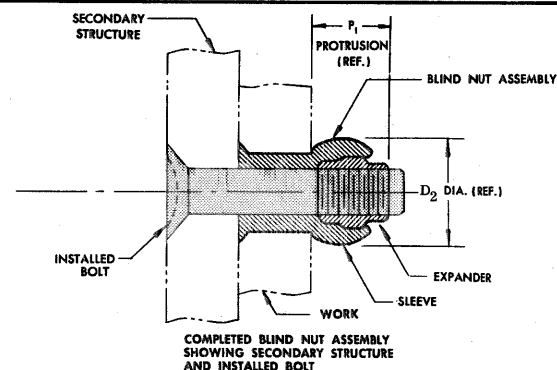
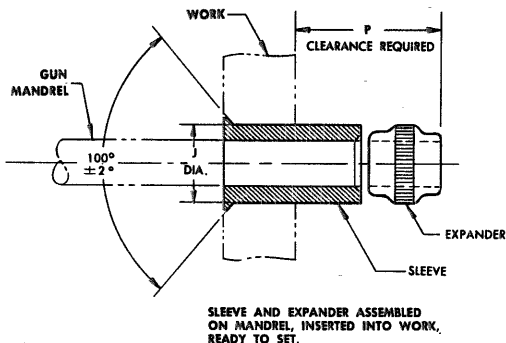
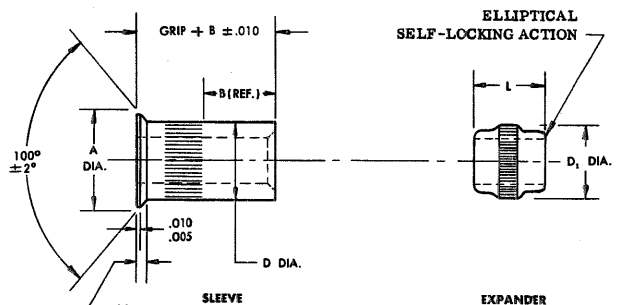




BN1557 NUT ASSEMBLY		BN517 SLEEVE							BB500, BB500PB OR BB500G EXPANDER				HOLE PREPARATION				PROTRUSION AFTER INSTALLATION	
FIRST DASH NUMBER		FIRST DASH NUMBER	A	B GRIP RANGE 0-1/8	B GRIP RANGE 1/8-1/4	B GRIP RANGE 1/4-1/2		D	PART NUMBER	D1	L	THREAD	J HOLE DIA.			P	P1	D2
-440		-440	.229 .224	.210	.225			.169 .167	BB500-5	.167	.141	4-40NC-3B	.173 .170			.373	.175	.210
-632		-632	.278 .273	.280	.295	.350		.218 .216	BB500-632	.217	.180	6-32NC-3B	.222 .219			.505	.210	.285
-832		-832	.317 .312	.315	.330	.370		.257 .255	BB500-8	.255	.205	8-32NC-3B	.264 .258			.570	.247	.335
-1032		-1032	.372 .367	.380	.420	.460		.312 .309	BB500-1032	.309	.240	10-32NF-3B	.319 .313			.697	.283	.410
-428		-428	.450 .445	.450	.450	.450		.390 .387	BB500-12	.383	.300	1/4-28UNF-3B	.397 .391			.828	.343	.510
-420		-428	.450 .445	.450	.450	.450		.390 .387	BB500-420	.383	.300	1/4-20UNC-3B	.397 .391			.828	.343	.510
-524		-524	.528 .523	.500	.500	.500		.468 .465	BB500-14	.458	.351	5/16-24UNF-3B	.477 .469			.939	.395	.600
-518		-524	.528 .523	.500	.500	.500		.468 .465	BB500-518	.458	.351	5/16-18UNC-3B	.477 .469			.939	.395	.600
-624		-624	.590 .585	.550	.550	.550		.530 .527	BB500-16	.521	.406	3/8-24UNF-3B	.539 .531			1.050	.450	.662
-616		-624	.590 .585	.550	.550	.550		.530 .527	BB500-616	.521	.406	3/8-16UNC-3B	.539 .531			1.050	.450	.662
-720		-720	.652 .647	.600	.600	.600		.592 .589	BB500-720	.585	.460	7/16-20UNF-3B	.605 .593			1.162	.503	.720
-714		-720	.652 .647	.600	.600	.600		.592 .589	BB500-714	.585	.460	7/16-14UNC-3B	.605 .593			1.162	.503	.720
-820		-820	.714 .709	.650	.650	.650		.654 .651	BB500-820	.643	.510	1/2-20UNF-3B	.664 .656			1.275	.555	.785
-813		-820	.714 .709	.650	.650	.650		.654 .651	BB500-813	.643	.510	1/2-13UNC-3B	.664 .656			1.275	.555	.785

BN517 SLEEVE

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

MATERIAL: Aluminum 2017 per QQ-A-430.

HEAT TREAT: Anneal.

FINISH: Anodize (clear).

CODE: First dash number indicates size of bolt to be used.
Second dash number indicates grip length (thickness of work) in 16ths.

EXAMPLE: BN517-428-12 = Sleeve for 1/4-28 or 1/4-20 bolt, 3/4 grip length.

BB500, BB500PB OR BB500G EXPANDER

NOTES: 1. Threads per MIL-S-8879.
2. Expander length accommodates NAS bolt thread lengths.

MATERIAL: Type 431 stainless steel per Spec. AMS 5628.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: BB500 - Cadmium plate per QQ-P-416, Type I, Class 2.
BB500PB - Cadmium plate per QQ-P-416, Type II, Class 2.
BB500G - Silver plate per AMS 2410, .0002-.0004 thick.

CODE: Dash number indicates expander used in assembly.

EXAMPLE: BB500-12 = Expander for 1/4-28 bolt.

BN1557 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: BN1557-428-12
└─ 3/4 Grip Length
└─ For 1/4-28 Bolt
└─ Blind Nut Assembly which includes:
BN517 Sleeve and BB500 Expander

TITLE
BLIND NUT ASSEMBLY
100° COUNTERSUNK SHALLOW HEAD

DRAWN	DATE	APPROVED	DATE	REVISION	DATE	DRAWING NUMBER
D.P.S.	3-3-87	ELINS	3-4-87			BN1557