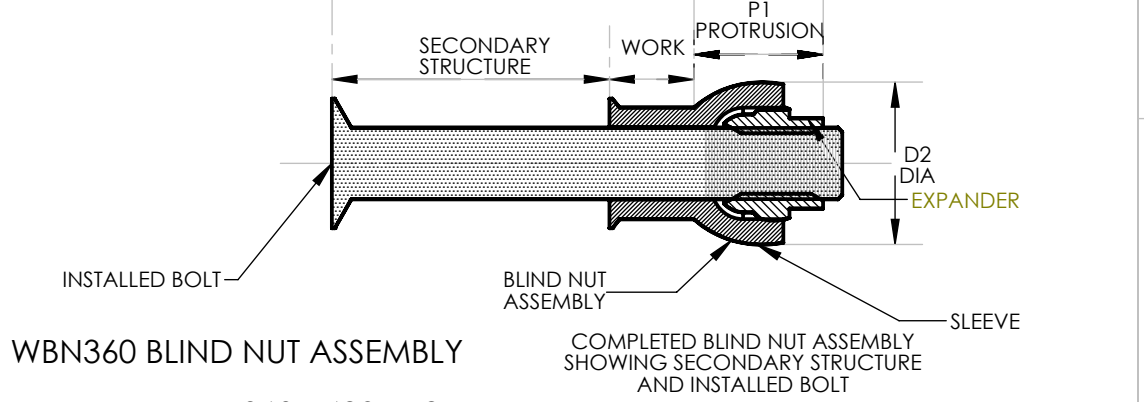


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DATE	SYM	REVISION RECORD	DR	CHK	APP
3/17/2020	A	REMOVED "REF" FROM "D" DIA	BEJ	DW	DW
3/17/2020	B	UPDATED ±.005 IN SOLIDWORKS 2009	BEJ	DW	DW
8/6/2020	C	LUBE PER AS87132 (WAS) PS3040.	BEJ	DW	DW
10/9/2020	D	SEE ECN	BEJ	DW	DW
11/10/2020	E	SEE ECN	BEJ	DW	DW
11/30/2020	F	SEE ECN	BEJ	KL	DW
1/29/2021	G	SEE ECN	BEJ	DW	DW
2/8/2022	H	SEE ECN	BEJ	DW	DW

BLIND NUT ASSEMBLY		WBN330 SLEEVE					WBB341 EXPANDER			SUGGESTED HOLE PREPARATION		PROTRUSION AFTER INSTALLATION			
FIRST DASH NO.	FIRST DASH NO.	(A) DIA. (REF)	A DIA. ±.005	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 NUMBER	D1 DIA. ±.005	L LENGTH ±.010	THREAD	J HOLE DIA.	100°±2° CSK X DIA.	D2 DIA. (REF)	P1 (REF)
440	440	.229 .224	.209	.210	-	-	.169 .167	WBB341-5	.167	.153	.112 - 40 UNJC - 3B	.173 .170	.229 .224	.220	.175
632	632	.278 .273	.258	.280	-	-	.218 .216	WBB341-632	.217	.215	.138 - 32 UNJC - 3B	.222 .219	.278 .273	.295	.260
832	832	.317 .312	.283	.315	.330	-	.257 .255	WBB341-8	.255	.245	.164 - 32 UNJC - 3B	.264 .258	.317 .312	.335	.290
1032	1032	.372	.348	.380	.420	.460	.312	WBB341-1032	.309	.307	.190 - 32 UNJF - 3B	.319	.372	.410	.350
1024		.309					WBB341-1024	.190 - 24 UNJC - 3B			.313				
428	428	.450	.430	.450	.450	.450	.390	WBB341-12	.383	.368	.250 - 28 UNJF - 3B	.397	.450	.510	.420
420		.387					WBB341-420	.250 - 20 UNJC - 3B			.391				
524	524	.528	.508	.500	.500	.500	.468	WBB341-14	.458	.429	.312 - 24 UNJF - 3B	.477	.528	.600	.470
518		.465					WBB341-518	.312 - 18 UNJC - 3B			.469				
624	624	.590	.562	.550	.550	.550	.530	WBB341-16	.521	.491	.375 - 24 UNJF - 3B	.539	.590	.662	.530
616		.527					WBB341-616	.375 - 16 UNJC - 3B			.531				
720	720	.652	.632	.600	.600	.600	.592	WBB341-720	.585	.552	.437 - 20 UNJF - 3B	.601	.652	.720	.592
714		.589					WBB341-714	.437 - 14 UNJC - 3B			.593				
820	820	.714	.694	.650	.650	.650	.654	WBB341-820	.643	.614	.500 - 20 UNJF - 3B	.664	.714	.785	.650
813		.651					WBB341-813	.500 - 13 UNJC - 3B			.656				



WBN360 BLIND NUT ASSEMBLY
 EXAMPLE: WBN360 - 428 - 12

- GRIP LENGTH IN 16THS = .750 GRIP LENGTH
- EXPANDER FINISH, CADMIUM PLATE, TYPE I, CLASS 2 (WBB341-12) (SEE EXPANDER "FINISH" NOTE FOR EXPLANATION OF CODE LETTERS)
- SIZE OF BOLT TO BE USED = .250 - 28 BOLT
- SLEEVE FINISH, ABRASIVE CLEAN AND PASSIVATION, (WBN330-428-12) (SEE SLEEVE "FINISH" NOTE FOR EXPLANATION OF CODE LETTERS)
- BLIND NUT ASSEMBLY

- AFTER PLATING, AN INSTALLATION MANDREL SHALL BE INSERTED A MINIMUM OF THREE THREADS INTO EXPANDER.
- A PLUG GO GAUGE SHALL BE INSERTED A MINIMUM OF 4 THREADS INTO THE EXPANDER AFTER ADDITION OF LOCKING FEATURE.
- THIS DRAWING MEETS THE REQUIREMENTS OF U.S. ARMY DWG 1143809 REV AC.

GENERAL NOTES : 1. THIS DRAWING MEETS THE REQUIREMENTS OF RAYTHEON DWG 3264499 (REV G).

WBN330 SLEEVE
 NOTES: 1. CONCENTRICITY - HOLE TO "D" DIAMETER WITHIN .005". HEAD TO "D" DIAMETER WITHIN .005".
 2. (A) REF DIMENSION REFERENCE TO THEORETICAL KNIFE POINT.
 MATERIAL: 304L/305 STAINLESS STEEL PER AMS-QQ-S-763.
 FINISH: WBN330-()-() = ABRASIVE CLEANING AND PASSIVATION PER ASTM-A-967.
 WBN330PB()-() = CADMIUM PLATE PER SAE-AMS-QQ-P-416, TYPE II, CLASS 2.
 CODE: FIRST DASH 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: WBN330-428-12 = SLEEVE FOR .250 - 28 OR .250 - 20 BOLT, .750 GRIP LENGTH.

WBB341 EXPANDER
 NOTE: 1. THREADS PER AS8879.
 MATERIAL: TYPE AISI 431 STAINLESS STEEL PER AMS5628.
 HEAT TREAT: 125,000 PSI SHEAR MINIMUM.
 FINISH: WBB341-() = CADMIUM PLATE PER SAE-AMS-QQ-P-416, TYPE I, CLASS 2 AND CETYL ALCOHOL LUBE PER AS87132.
 WBB341DU() = SOLID FILM LUBE PER AS5272, TYPE I.
 WBB341G() = SILVER PLATE PER AMS2410 (.0002-.0004 THICK) AND CETYL ALCOHOL LUBE PER AS87132.
 WBB341GU() = SILVER PLATE PER AMS2410 (.0002-.0004 THICK), NO LUBE.
 WBB341PB() = CADMIUM PLATE PER SAE-AMS-QQ-P-416, TYPE II, CLASS 2 AND CETYL ALCOHOL LUBE PER AS87132.
 WBB341PV() = CADMIUM PLATE PER SAE-AMS-QQ-P-416, TYPE II, CLASS 2, SOLID FILM LUBE PER AS5272, TYPE I, AND CETYL ALCOHOL LUBE PER AS87132.
 WBB341TF() = HI-KOTE 2 SOLID FILM LUBE PER HI-SHEAR SPEC 292.
 CODE: DASH NUMBER INDICATES EXPANDER USED IN ASSEMBLY. SEE "FINISH" NOTE FOR EXPLANATION OF CODE LETTERS.
 EXAMPLE: WBB341-12 = EXPANDER FOR .250 BOLT

UNLESS OTHERWISE SPECIFIED:	CAGE: 0JHK5	NAME	DATE
DIMENSIONS ARE IN INCHES	DRAWN	D.WITTEN	3/29/2019
TOLERANCES:	CHECKED	K.LATIMER	3/29/2019
FRACTIONAL ±1/16	ENG APP	D.WITTEN	3/29/2019
ANGULAR: MACH ±2 DEG			
TWO PLACE DECIMAL ±.02			
THREE PLACE DECIMAL ±.010			
SURFACE FINISH 125 RMS MIN.			

PROPRIETARY AND CONFIDENTIAL	INTERPRET GEOMETRIC TOLERANCING PER: ASME Y14.5M - 1994	COMMENTS:
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DO NOT SCALE DRAWING		THIRD ANGLE PROJECTION

TECH DATA SHEET



TITLE: **BLIND NUT ASSEMBLY**
 100° COUNTERSUNK SHALLOW HEAD

SIZE B	DWG. NO. WBN360	REV H
SCALE: NONE		SHEET 1 OF 2

TABLE I CROSS - REFERENCE			
U.S. ARMY PART NUMBER	THREAD	GRIP	MFR PART NO. WITTEN CO.
11438039-1	.190-32 UNJF-3B	.125	WBN360-1032PB2
11438039-2	.138-32 UNJC-3B	.125	WBN360-632PB2
11438039-3	.190-32 UNJF-3B	.250	WBN360-1032PB4
11438039-4	.250-28 UNJF-3B	.125	WBN360-428PB2
11438039-5	.3125-24 UNJF-3B	.125	WBN360-524PB2
11438039-6	.164-32 UNJC-3B	.062	WBN360-832PB1
11438039-7	.164-32 UNJC-3B	.125	WBN360-832PB2
11438039-8	.190-32 UNJF-3B	.187	WBN360-1032PB3
11438039-9	.190-32 UNJF-3B	.312	WBN360-1032PB5
11438039-10	.250-28 UNJF-3B	.250	WBN360-428PB4
11438039-11	.138-32 UNJC-3B	.062	WBN360-632PB1
11438039-12	.164-32 UNJC-3B	.250	WBN360-832PB4
11438039-13	.164-32 UNJC-3B	.187	WBN360-832PB3
11438039-14	.250-28 UNJF-3B	.312	WBN360-428PB5
11438039-15	.250-28 UNJF-3B	.187	WBN360-428PB3
11438039-16	.190-32 UNJF-3B	.062	WBN360-1032PB1
11438039-17	.500-20 UNJF-3B	.250	WBN360-820PB4
11438039-18	.190-32 UNJF-3B	.375	WBN360-1032PB6
11438039-19	.500-20 UNJF-3B	.312	WBN360-820PB5
11438039-20	.138-32 UNJC-3B	.187	WBN360-632PB3
11438039-21	.138-32 UNJC-3B	.312	WBN360-632PB5
11438039-22	.250-28 UNJF-3B	.375	WBN360-428PB6
11438039-23	.375-24 UNJF-3B	.312	WBN360-624PB5
11438039-24	.164-32 UNJC-3B	.687	WBN360-832PB11
11438039-25	.190-32 UNJF-3B	.687	WBN360-1032PB11
11438039-26	.3125-24 UNJF-3B	.250	WBN360-524PB4
11438039-27	.375-24 UNJF-3B	.187	WBN360-624PB3
11438039-28	.375-24 UNJF-3B	.437	WBN360-624PB7
11438039-29	.138-32 UNJC-3B	.250	WBN360-632PB4
11438039-30	.164-32 UNJC-3B	.375	WBN360-832PB6

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1/29/2021	G	SEE ECN	BEJ	DW	DW
2/8/2022	H	SEE ECN	BEJ	DW	DW

U.S. ARMY MISSILE COMMAND
 REDSTONE ARSENAL, ALABAMA
 CROSS-REFERENCE
 DRAWING 11438039 REV AC

TECH DATA SHEET



TITLE: **BLIND NUT ASSEMBLY**
 100° COUNTERSUNK SHALLOW HEAD

SIZE B	DWG. NO. WBN360	REV H
SCALE: NONE		SHEET 2 OF 2

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ±1/16 ANGULAR: MACH ±2 DEG TWO PLACE DECIMAL ±.02 THREE PLACE DECIMAL ±.010 SURFACE FINISH 125 RMS MIN.	CAGE: 0JHK5	NAME	DATE
	DRAWN	D.WITTEN	3/29/2019
	CHECKED	K.LATIMER	3/29/2019
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	COMMENTS: SOLIDWORKS STANDARD 2009 SP4.1		
DO NOT SCALE DRAWING	THIRD ANGLE PROJECTION		

D

C

B

A

D

C

B

A

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1