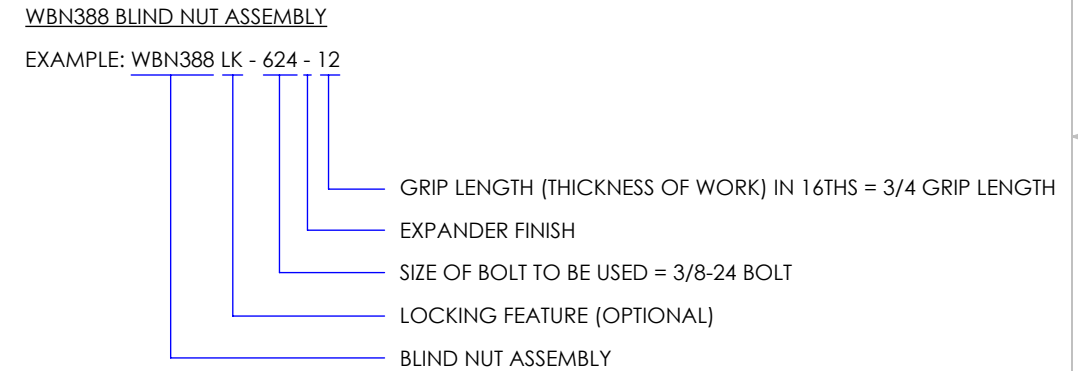


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	11/27/2018	A	REMOVED "REF" FROM "D" DIA	DW	SN	DW
	3/17/2020	B	UPDATED IN SOLIDWORKS 2009	BEJ	DW	DW
	2/8/2022	C	SEE ECN	BEJ	DW	DW

WBN 388 BLIND NUT ASSEMBLY		WBN388 SLEEVE						WBB348 EXPANDER				SUGGESTED HOLE PREPARATION		PROTRUSION AFTER INSTALLATION		
FIRST DASH NO.	FIRST DASH NO.	A DIA. (REF)	A1 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. (REF)	PART NUMBER	D1 DIA.	L LENGTH	THREAD	T (REF)	J HOLE DIA.	100°±2° CSK X DIA.	D2 DIA. (REF)	P (REF)
632	632	.278	.258	.280	-	-	.218	WBB348-632	.217	.610	6 - 32 UNJC - 3B	.39	.222	.278	.285	.655
		.273					.216						.219	.273		
832	832	.317	.283	.315	.330	-	.257	WBB348-832	.255	.650	8 - 32 UNJC - 3B	.43	.264	.317	.335	.695
		.312					.255						.258	.312		
1032	1032	.372	.348	.380	.420	.460	.312	WBB348-1032	.309	.710	10 - 32 UNJF - 3B	.47	.319	.372	.410	.750
1024		.367					.309	WBB348-1024		.830	10 - 24 UNJC - 3B		.313	.367		.870
428	428	.450	.430	.450	.450	.450	.390	WBB348-12	.383	.950	1/4 - 28 UNJF - 3B	.61	.397	.450	.510	1.000
420		.445					.387	WBB348-420		.980	1/4 - 20 UNJC - 3B		.391	.445		1.030
524	524	.528	.508	.500	.500	.500	.468	WBB348-14	.458	1.010	5/16 - 24 UNJF - 3B	.68	.477	.528	.600	1.050
518		.523					.465	WBB348-518		1.100	5/16 - 18 UNJC - 3B		.469	.523		1.140
624	624	.590	.562	.550	.550	.550	.530	WBB348-16	.521	1.070	3/8 - 24 UNJF - 3B	.73	.539	.590	.662	1.110
616		.585					.527	WBB348-616		1.170	3/8 - 16 UNJC - 3B		.531	.585		1.210



WBN330 SLEEVE
 NOTE: 1. CONCENTRICITY - HOLE TO "D" DIAMETER WITHIN .005". HEAD TO "D" DIAMETER WITHIN .005".
 2. "A" DIMENSION REFERENCE TO THEORETICAL KNIFE POINT.
 MATERIAL: 304L/305 STAINLESS STEEL PER AMS-QQ-S-763.
 CODE: FIRST DASH INDICATES SIZE OF BOLT TO BE USED. SECOND DASH NUMBER INDICATES GRIP LENGTH (THICKNESS OF WORK) IN 16ths.
 EXAMPLE: WBN330-624-12 = SLEEVE FOR 3/8-24 BOLT, 3/4 GRIP LENGTH.

WBB348 EXPANDER
 NOTE: THREADS PER AS8879.
 MATERIAL: TYPE 431 STAINLESS STEEL PER AMS5628.
 HEAT TREAT: 125,000 PSI TENSILE MINIMUM.
 FINISH: WBB348-() = CADMIUM PLATE PER SAE-AMS-QQ-P-416, TYPE I, CLASS 3
 WBB348-()PB = CADMIUM PLATE PER SAE-AMS-QQ-P-416, TYPE II, CLASS 2
 WBB348-()TF = HI-KOTE 2 SOLID FILM LUBE PER HI-SHEAR SPEC 292.
 CODE: DASH NUMBER INDICATES EXPANDER USED IN ASSEMBLY. LETTERS "LK" AFTER PART NUMBER INDICATE EXPANDER WITH LOCKING FEATURE.
 EXAMPLE: WBB348-16 = EXPANDER FOR 3/8-24 BOLT WITH CADMIUM PLATE PER SAE-AMS-QQ-P-416, TYPE I, CLASS 3 FINISH, NO LOCK.
 WBB348LK-16TF = EXPANDER FOR 3/8-24 BOLT WITH LOCKING FEATURE AND HI-KOTE 2 FINISH.

CODE: FIRST DASH NUMBER INDICATES SIZE OF BOLT TO BE USED. SECOND DASH NUMBER INDICATES GRIP LENGTH (THICKNESS OF WORK) IN 16ths.

TECH DATA SHEET



CAGE: 0JHK5	NAME	DATE
DRAWN	T.WITTEN	6/4/2018
CHECKED	D.WITTEN	6/4/2018
ENG APP	D.WITTEN	6/4/2018
COMMENTS:		
SOLIDWORKS STANDARD 2009 SP4.1		
THIRD ANGLE PROJECTION		

TITLE: **BLIND NUT ASSEMBLY**
 100° COUNTERSUNK SHALLOW HEAD
 DOME TYPE CLOSED END

SIZE B	DWG. NO. WBN388	REV C
SCALE: NONE		SHEET 1 OF 2

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	11/27/2018	A	REMOVED "REF" FROM "D" DIA	DW	SN	DW
	3/17/2020	B	UPDATED IN SOLIDWORKS 2009	BEJ	DW	DW
	2/8/2022	C	SEE ECN	BEJ	DW	DW

TABLE I CROSS - REFERENCE				
U.S. ARMY PART NUMBER	THREAD	GRIP	HI-SHEAR	MFR PART NO. WITTEN CO.
10274114-1	.3125-24 UNJF-3B	.250	BN388LK524TF4	WBN388LK-524TF4
10274114-2	.190-32 UNJF-3B	.187	BN388LK1032TF3	WBN388LK-1032TF3
10274114-3	.190-32 UNJF-3B	.250	BN388LK1032TF4	WBN388LK-1032TF4
10274114-4	.250-28 UNJF-3B	.250	BN388LK428TF4	WBN388LK-428TF4
10274114-5	.250-28 UNJF-3B	.437	BN388LK428TF7	WBN388LK-428TF7
10274114-6	.164-32 UNJC-3B	.312	BN388LK832TF5	WBN388LK-832TF5
10274114-7	.250-28 UNJF-3B	.375	BN388LK428TF6	WBN388LK-428TF6
10274114-8	.164-32 UNJC-3B	.250	BN388LK832TF4	WBN388LK-832TF4
DELETED				
10274114-10	.250-28 UNJF-3B	.125	BN388LK428TF2	WBN388LK-428TF2
10274114-11	.250-28 UNF-3B	.500	BN388LK428TF8	WBN388LK-428TF8
DELETED				
10274114-13	.190-32 UNJC-3B	.125	BN388LK1032TF2	WBN388LK-1032TF2
10274114-14	.190-32 UNJF-3B	.312	BN388LK1032TF5	WBN388LK-1032TF5
10274114-15	.250-28 UNJF-3B	.312	BN388LK428TF5	WBN388LK-428TF5
10274114-16	.164-32 UNJC-3B	.125	BN388LK832TF2	WBN388LK-832TF2
10274114-17	.164-32 UNJC-3B	.187	BN388LK832TF3	WBN388LK-832TF3
DELETED				
10274114-19	.250-28 UNJF-3B	.125	BN388LK428PB2	WBN388LK-428PB2

U.S. ARMY MISSILE COMMAND
 REDSTONE ARSENAL, ALABAMA
 CROSS-REFERENCE
 DRAWING 10274114 REV U

TECH DATA SHEET



TITLE:
BLIND NUT ASSEMBLY
 100° COUNTERSUNK SHALLOW HEAD
 DOME TYPE CLOSED END

CAGE: 0JHK5	NAME	DATE
DRAWN	T.WITTEN	6/4/2018
CHECKED	D.WITTEN	6/4/2018
ENG APP	D.WITTEN	6/4/2018

COMMENTS:
 SOLIDWORKS STANDARD 2009 SP4.1
 THIRD ANGLE PROJECTION

SIZE B	DWG. NO. WBN388	REV C
SCALE: NONE		SHEET 2 OF 2