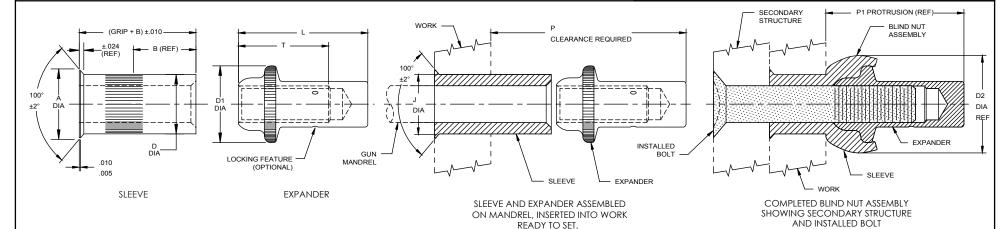
6

CAGE No. 73197

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BN527 BLIND NUT ASSEMBLY	BN517 SLEEVE					BB409 EXPANDER					HOLE PREPARATION		PROTRUSION AFTER INSTALLATION		
FIRST DASH NO.	FIRST DASH NO.	<b>A</b> DIA	B GRIP RANGE 0 - 3/4	<b>B</b> GRIP RANGE 13/16 - 1-1/16	<b>B</b> GRIP RANGE 1-1/8 - 1-5/8	<b>D</b> DIA	FIRST DASH NO.	<b>D1</b> DIA	L	T REF THREAD DEPTH	THREAD ⑥	<b>J</b> HOLE DIA	Р	D2 DIA	P1
-1024	-1032	.372	.380	.420	.460	.312	BB409-1024	.309	.830	.46	.1900-24UNJC-3B	.319	B+L	.410	.870
-1032		.367				.309	BB409-1032		.710		.1900-32UNJF-3B	.313			.750
-420	-428	.450	.450	.450	.450	.390	BB409-420	.383	.980	.60	.2500-20UNJC-3B	.397	B+L	.510	1.030
-428	720	.445				.387	BB409-12		.950		.2500-28UNJF-3B	.391			1.000
-518	-524 .528 .523	.500	.500	.500	.468	BB409-518	.458	1.100	.67	.3125-18UNJC-3B	.477	B + L	.600	1.140	
-524					.465	BB409-14		1.010		.3125-24UNJF-3B	.469			1.050	
-616	-624 .590 .585				.530	BB409-616	504	1.170		.3750-16UNJC-3B	.539	Б.,	000	1.210	
-624		.585	.550	.550 .	.550	.527	BB409-16	.521	1.070	.72	.3750-24UNJF-3B	.531	B+L	.662	1.110

## **BN527 BLIND NUT ASSEMBLY**

**BB409 EXPANDER BN517 SLEEVE** 

> Concentricity: Hole to "D" diameter within .005 FIM. "D" diamater to head within .005 FIM.

MATERIAL: Aluminum 2017 per AMS-QQ-A-430.

HEAT TREAT: Anneal

NOTE:

FINISH: BN517-()-() = Anodize (clear).

CODE: First dash number indicates size of bolt to be used.

Second dash number indicates grip length (thickness

of work) in 16ths.

BN517-624-12 = Sleeve for 3/4-23 or 3/8-16 bolt, EXAMPLE:

3/4 grip length.

NOTE: (6) Threads per AS8879.

MATERIAL: Type 303 stainless steel.

FINISH: BB409()() = Cadmium plate per AMS-QQ-P-416,

Type I, Class 3.

CODE: Dash number indicates expander used in assembly.

Letters "LK" after part number indicate expander

with locking feature.

EXAMPLE: BB409LK616 = Expander with locking feature for

3/8-16 bolt.

BB409-16 = Expander for 3/8-24 bolt.

BB409-616 = Expander for 3/8-16 bolt.

CODE: First dash number indicates size of bolt to be used. Second dash number indicates grip length (thickness

of work) in 16ths.

BN527-624-12 EXAMPLE:

☐ 3/4 Grip Length -For 3/8-24 Bolt

> Blind Nut Assembly which includes: BN517 Sleeve and BB409 Expander

BN527LK624-12 = Same as above, except Expander with locking type feature.

## ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY	DATE	TITLE
J.F.O.	1985-08-08	BLIND NUT ASSEMBLY
APPROVED	DATE	100° COUNTERSUNK SHALLOW HEAD
J. RAUSCH	1985-08-09	DOME TYPE
REVISION	DATE K. TRAN	DRAWING NUMBER
6	2017-12-21	BN527 1 OF 1

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