



BN527 BLIND NUT ASSEMBLY		BN517 SLEEVE						BB409 EXPANDER					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	FIRST DASH NO.	D1 DIA	L	T REF THREAD DEPTH	THREAD ⑥	HOLE DIA	P	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				.1900-32UNJF-3B					.313
-420	-428	.450	.450	.450	.450	.390	BB409-420	.383	.980	.60	.2500-20UNJC-3B	.397	B + L	.510	1.030	
-428		.445				.387	BB409-12				.2500-28UNJF-3B					.391
-518	-524	.528	.500	.500	.500	.468	BB409-518	.458	1.100	.67	.3125-18UNJC-3B	.477	B + L	.600	1.140	
-524		.523				.465	BB409-14				.3125-24UNJF-3B					.469
-616	-624	.590	.550	.550	.550	.530	BB409-616	.521	1.170	.72	.3750-16UNJC-3B	.539	B + L	.662	1.210	
-624		.585				.527	BB409-16				.3750-24UNJF-3B					.531

BN527 BLIND NUT ASSEMBLY

BN517 SLEEVE

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

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

HEAT TREAT: Anneal.

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.

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

BB409 EXPANDER

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 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.

EXAMPLE:

BN527-624-12
 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 J.F.O.	DATE 1985-08-08	TITLE BLIND NUT ASSEMBLY 100° COUNTERSUNK SHALLOW HEAD DOME TYPE	
APPROVED J. RAUSCH	DATE 1985-08-09	DRAWING NUMBER BN527	
REVISION ⑥	DATE 2017-12-21	1 OF 1	