



BN377 BLIND NUT ASSEMBLY		BN502 SLEEVE						BB415 EXPANDER				HOLE PREPARATION		PROTRUSION AFTER INSTALLATION		INSTALLATION PRESSURE PSI USING HI-SHEAR TOOLING	
FIRST DASH NUMBER	FIRST DASH NUMBER	A DIA.	B GRIP RANGE 0-3/8	B GRIP RANGE 3/8-1 1/4	B GRIP RANGE 1 1/4-1 3/4	D DIA.	PART NUMBER	D ₁ DIA.	L	THREAD	J HOLE DIA.	P	D ₂ DIA.	P ₁	GUN NO. BG1750	GUN NO. BG2500	
-440	-440	.229 .224	.210			.169 .167	BB415-5	.167	.153	4-40UNJC-3B	.173 .170	B+.163	.210	.175	600	300	
-632	-632	.278 .273	.280			.218 .216	BB415-632	.217	.215	6-32UNJC-3B	.222 .219	B+.225	.285	.260	900	450	
-832	-832	.317 .312	.315	.330		.257 .255	BB415-8	.255	.245	8-32UNJC-3B	.264 .258	B+.255	.335	.290	1250	700	
-1024	-1032	.372	.380	.420	.460	.312	BB415-1024	.309	.307	10-24UNJC-3B	.319	B+.317	.410	.350		1100	
-1032		.367				10-32UNJF-3B	.313										
-420	-428	.450	.450	.450	.450	.390	BB415-420	.383	.368	1/4-20UNJC-3B	.397	B+.378	.510	.420		1550	
-428		.445				1/4-28UNJF-3B	.391										
-518	-524	.528	.500	.500	.500	.468	BB415-518	.458	.429	5/16-18UNJC-3B	.477	B+.439	.600	.470		2000	
-524		.523				5/16-24UNJF-3B	.469										
-616	-624	.590	.550	.550	.550	.530	BB415-616	.621	.491	3/8-16UNJC-3B	.539	B+.501	.662	.530		2350	
-624		.585				3/8-24UNJF-3B	.531										
-714	-720	.652	.600	.600	.600	.592	BB415-714	.585	.552	7/16-14UNJC-3B	.605	B+.562	.720	.592		2350	
-720		.647				7/16-20UNJF-3B	.593										
-813	-820	.714	.650	.650	.650	.654	BB415-813	.643	.614	1/2-13UNJC-3B	.664	B+.624	.785	.650		2350	
-820		.709				1/2-20UNJF-3B	.656										

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

MATERIAL: Type A-286 per AMS5731

HEAT TREAT: Heat treated to meet the requirements of AMS5736.

FINISH: Sandblast.

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

EXAMPLE: BN502-624-12 = Sleeve for 3/8-24 or 3/8-16 bolt, 3/4 grip length.

BB415 EXPANDER

NOTE: Threads per MIL-S-8879.

MATERIAL: Type A-286 per AMS5731, cold worked 40-50% and aged to meet double shear strength requirements of 110,000 psi minimum.

FINISH: BB415-() = Solid film lube per MIL-L-4610, Type I.
BB415GA-() = Silver plate per AMS2411.
BB415DP-() = Solid film lube per Kalgard KG 100-10.

CODE: Dash number indicates expander used in assembly.

EXAMPLE: BB415-16 = Expander for 3/8-24 bolt.

BN377 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: BN377-624-12
└── 3/4 Grip Length
└── For 3/8-24 Bolt
└── Blind Nut Assembly which includes:
 BN502 Sleeve and BB415 Expander
BN377GA-()-() = As example except with Expander BB415GA.