OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT BE GREATER THAN MAXIMUM "D" DIAMETER.

HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.

STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.

LOCKING FEATURE CONSISTS OF THREE (3) INDENTATIONS LOCATED 120° APART ON THE PERIPHERY OF THE NUT COMPONENT AND MANUFACTURER'S IDENTIFICATION:

DISTORTION OF "D" DIAMETER SHALL NOT PREVENT INSERTION OF THE FASTENER INTO A RING GAUGE OF LENGTH EQUAL TO ONE DIAMETER AND DIAMETER EQUAL TO MAXIMUM BE USED IN THE MANUFACTURE OR REPRODUCTION OF THE ARTICLE DISCLOSED, AND THE DELIVERY OF THIS DOCUMENT SHALL NOT CONSTITUTE ANY RIGHT OR LICENSE TO DO SO.

B: REVEALED IN ANY MANNER TO ANY PERSON EXCEPT TO MEET THE PURPOSE FOR WHICH IT WAS DELIVERED.

ASSUME CUSTODY THEREOF AND AGREES:

NOTICE: PROPRIETARY AND CONFIDENTIAL:

a TriMas company

PROCUREMENT SPEC: ESCBB-10 / MIL-F-81177, TYPE II, EXCEPT AS SPECIFIED HEREIN.

MATERIAL:

NUT & SCREW: 5% CHROME STEEL (H-11) PER AMS5647.
SLEEVE: INCONEL X-750 PER AMS5667 OR AMS5582: OR A-286 PER AMS5731, AMS5732 OR AMS5737.

HEAT TREAT:

NUT & SCREW: ROCKWELL "C" 48-53.
SLEEVE: AS REQUIRED FOR PERFORMANCE.

FINISH:

"*" NUT & SCREW: CADMIUM PLATE PER NAS672 (.0003 MIN. THICKNESS) EXCEPT THERMAL INDICATOR MAY BE OMITTED. SUPPLEMENTARY CHROMIUM TREATMENT PER AMS-QQ-P-416 AFTER BAKE.
SLEEVE: PASSIVE PER AMS2700. CADMIUM PLATE PER AMS-QQ-P-416, TYPE 1, CLASS 3.
"L" NUT: ALUMINUM COAT PER NAS4006.
SLEEVE: PASSIVE PER AMS2700 AND ALUMINUM COAT PER NAS4006.
SCREW: CADMIUM PLATE PER NAS672 (.0003 MIN. THICKNESS) EXCEPT THERMAL INDICATOR MAY BE OMITTED. SUPPLEMENTARY CHROMIUM TREATMENT PER AMS-QQ-P-416 AFTER BAKE.

LUBRICANT: LUBRICANTS LISTED BELOW MAY BE APPLIED TO ANY OR ALL COMPONENTS IF REQUIRED FOR PERFORMANCE:

DRY FELT LUBE PER ASS5272 TYPE 1 OR EVERLUBE 812 PER MIL-PRF-81329, PARAFFIN WAX, CETYL ALCOHOL PER AS87132. AND/OR WWW CARBO-WAX.

PART CODE & EXAMPLE:

PLT1028 L - 08 - 08

GRIP LENGTHS IN 1/16THS OF AN INCH.

MIN MAX

-01 .093 2.36 .032 .081 .093 2.36
-02 .156 3.96 .039 2.13 .156 3.96
-03 .219 5.56 .157 3.99 .219 5.56
-05 .344 8.74 .276 7.16 .344 8.74
-06 .406 10.31 .345 8.76 .406 10.31
-07 .469 11.91 .407 10.34 .469 11.91
-08 .531 13.49 .470 11.94 .531 13.49
-09 .594 15.11 .532 13.51 .595 15.11
-10 .656 16.66 .595 15.11 .656 16.66
-12 .781 19.84 .720 18.29 .781 19.84
-13 .843 21.44 .782 19.86 .844 21.44
-14 .906 23.01 .845 21.96 .906 23.01
-15 .969 24.61 .907 23.04 .969 24.61
-16 1.032 26.19 .970 24.64 .103 26.19
-17 1.094 27.79 1.032 26.21 1.094 27.79
-18 1.156 29.36 1.095 27.81 1.156 29.36
-19 1.219 30.96 1.157 29.39 1.219 30.97
-20 1.282 32.54 1.220 30.99 1.281 32.54
-21 1.344 34.14 1.282 32.56 1.344 34.14
-22 1.406 35.71 1.346 34.16 1.406 35.71
-23 1.469 37.31 1.407 35.74 1.469 37.31
-24 1.531 38.89 1.470 37.34 1.531 38.89
-25 1.594 40.49 1.533 38.91 1.594 40.49
-26 1.656 42.06 1.595 40.51 1.656 42.06
-27 1.719 43.66 1.657 42.09 1.719 43.66
-28 1.781 45.24 1.720 43.69 1.781 45.24
-29 1.844 46.84 1.782 45.26 1.844 46.84
-30 1.906 48.41 1.845 46.86 1.906 48.41
-31 1.969 50.01 1.907 48.44 1.969 50.01
-32 2.031 51.59 1.970 49.04 2.031 51.59

GENERAL NOTES:

OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT BE GREATER THAN MAXIMUM "D" DIAMETER.
2. CONCENTRICITY OF NUT HEAD CONICAL SURFACE TO "D" DIAMETER SHALL BE WITHIN 0.005" (0.13mm) T.I.R. EXCEPT OVER INDENTATIONS.
3. REMOVE ALL LOOSE OR HANGING BURRS.
4. LOCKING FEATURE CONSISTS OF THREE (3) INDENTATIONS LOCATED 120° APART ON THE PERIPHERY OF THE NUT COMPONENT AND APPROXIMATELY .040 (.102 mm) ABOVE THE INTERSECTION OF THE NUT NOSE ANGLE AND O.D. (MEAN GRIP OF FASTENER).
5. MANUFACTURER'S IDENTIFICATION: LETTER "N" DESIGNATES MONOGRAM AEROSPACE FASTENERS. LETTERS "VS" DESIGNATE ALCOA.
6. HEAD MARKINGS ON NUT DEPRESSED .010" MAXIMUM.
7. HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS. EXAMPLE: PLT1028-06-4.5 INDICATES A NOMINAL GRIP LENGTH OF 4.5 SIXTEENTHS (.281 = 7.14MM).

THE BASIC "G" DIMENSION WILL BE NOMINAL GRIP + .031 (+0.79) AND THE OVERALL SCREW LENGTH "L" DIMENSION MAY VARY AT MANUFACTURER'S OPTION.
8. STANDARD GRIP LENGTHS ARE SHOWN IN TABLE I. SHORTER OR LONGER GRIPS THAN THOSE LISTED MAY BE AVAILABLE AS SPECIALS. ON GRIP LENGTHS SHORTER THAN THOSE LISTED, THE BREAKOFF AND PREVAILING TORQUES DO NOT APPLY.
9. DISTORTION OF "D" DIAMETER SHALL NOT PREVENT INSERTION OF THE FASTENER INTO A RING GAUGE OF LENGTH EQUAL TO ONE DIAMETER AND DIAMETER EQUAL TO MAXIMUM "D" MAX + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS (22.23 NEWTONS).
10. STANDARD FINISHES AND LUBRICANTS ARE ShOWN ABOVE. REFER TO SPECIFICATION ESCCB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.
11. DIMENSIONS "A", "A'", AND "W" ARE FOR ENGINEERING REFERENCE PURPOSES ONLY AND ARE NOT TO BE USED FOR INSPECTION PURPOSES. THESE DIMENSIONS ARE THEORETICAL VALUES DERIVED FROM "D", "S", "V", "W" AND HEAD ANGLE DIMENSIONS.
12. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.