PROCUREMENT SPEC.: ESB-9, CLASS I, EXCEPT AS NOTED HEREIN.

MATERIAL:
NUT & SCREW: BAL-4V TITANIUM PER AMS4928 OR AMS4967.
SLEEVE: CORROSION RESISTANT STEEL.

HEAT TREAT:
NUT & SCREW: HEAT TREAT PER MIL-H-132200 MAX. HYDROGEN <150 PPM.
SLEEVE: AS REQUIRED FOR PERFORMANCE.

FINISH:
NUT & SCREW: NONE, IF REQUIRED FOR FASTENER FUNCTION, THESE COMPONENTS MAY BE COATED WITH DRY FILM LUBE PER MIL-L-46010 OR EVERLUBE 812 PER MIL-L-61328.
SLEEVE: PASSIVATE G0-P-35 (MIL-S-5002) AND DRY FILM LUBE PER MIL-L-46010 OR EVERLUBE 812 PER MIL-L-61328.

LUBRICANT:
NO ADDITIONAL LUBRICANTS ARE ALLOWED. (SEE FINISH).

PART CODE & EXAMPLE:
PLT10645A - 8 B GRIP LENGTHS IN 1/16THS (SEE TABLE II).
NOMINAL BODY DIAMETER AS TABULATED.
BASIC PART NUMBER, SELF LOCKING BLIND FASTENER.
FOR SEALANT APPLICATIONS.

GENERAL NOTES:
1.) OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT BE GREATER THAN MAXIMUM "O" DIAMETER.
2.) CONCENTRICITY OF NUT HEAD "A" DIAMETER TO "O" DIAMETER SHALL BE WITHIN .005 T.I.R. EXCEPT OVER INDENTS.
3.) REMOVE ALL LOOSE OR HANGING BURRS.


MANUFACTURER'S IDENTIFICATION:
LETTER "N" DESIGNATES MONOGRAM AEROSPACE FASTENERS.
LETTERS "VS" DESIGNATE VS-DHAN.

HEAD MARKINGS ON NUT DEPRESSED .010 MAX. LOCATION OPTIONAL.

HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBER.
EXAMPLE: PLT10645A-6.4.5 INDICATES A NOMINAL GRIP LENGTH OF 6.5 SIXTEENTHS = .281.
THE GRIP RANGE FOR THESE HALF-GRIP SIZES WILL BE NOMINAL GRIP + .031/-.030.
THE BASIC "S" DIMENSION WILL BE NOMINAL GRIP + .031 AND THE OVERALL SCREW LENGTH "L" DIMENSION MAY VARY AT MANUFACTURER'S OPTION.

STANDARD GRIP LENGTHS ARE SHOWN IN TABLE II, SHORTER OR LONGER GRIPS THAN THOSE LISTED MAY BE AVAILABLE AS SPECIALS. ON GRIP LENGTHS SHORTER THAN THOSE LISTED, THE BREAKOFF LIMITS AND PREVAILING TORQUES SHOWN IN TABLE I DO NOT APPLY.

TEST SPECIMENS USED TO GENERATE THE "QUALITY CONFORMANCE INSPECTION" RESULTS MAY BE LUBRICATED OR SEALANT COATED.

DISTORTION OF "O" DIAMETER SHALL NOT PREVENT INSERTION OF THE FASTENER INTO A RING GAUGE OF LENGTH EQUAL TO ONE DIAMETER AND DIAMETER EQUAL TO "O" MAX + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS.

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

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 "O", "S", "W" AND HEAD ANGLE DIMENSIONS.

13. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.

THESE PARTS ARE SUPPLIED IN PARTIALLY DISASSEMBLED CONDITION TO ALLOW APPLICATION OF SEALANT ON THE EXPOSED SCREW THREADS.
DO NOT USE WITHOUT SEALANT.

APPLY SEALANT PRI1422 B-2 PER MIL-S-8802 OR MIL-S-22473, GRADE A, RETAINING COMPOUND PER ST73071 IN THIS AREA.

U.S. PATENT NO. 3643544, OTHER PATENTS PENDING.

APPROVED DATE: 05 AUGUST 1986
REV. LETTER AND DATE: 05-16-94

MONOGRAM AEROSPACE FASTENERS

STANDARD
PLT10645A
SHEET 2 OF 2