### Table I

<table>
<thead>
<tr>
<th>PART NUMBER</th>
<th>ØNOM</th>
<th>ØA</th>
<th>ØB</th>
<th>C MAX</th>
<th>ØD</th>
<th>F</th>
<th>H</th>
<th>ØJ MAX</th>
<th>K MAX</th>
<th>R R</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>mm</td>
<td>mm</td>
<td>mm</td>
<td>mm</td>
<td>mm</td>
<td></td>
<td></td>
<td>mm</td>
<td>mm</td>
<td>mm</td>
</tr>
</tbody>
</table>

### Table I (Continued)

<table>
<thead>
<tr>
<th>PART NUMBER</th>
<th>BREAK-OFF LIMITS</th>
<th>MINIMUM AVAILABLE GRIP LENGTH (TABLE II)</th>
<th>HOLE SIZE</th>
<th>PREVAILING TORQUE MIN</th>
<th>DOUBLE SHEAR STRENGTH MIN</th>
<th>TENSILE STRENGTH MIN</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>INCH</td>
<td>mm</td>
<td>IN-LBS</td>
<td>Nm</td>
<td>LBS</td>
<td>N</td>
</tr>
<tr>
<td>PLT1077-08-()</td>
<td>0.053</td>
<td>-0.35</td>
<td>-0.69</td>
<td>2.64</td>
<td>6.71</td>
<td>2.61</td>
</tr>
<tr>
<td>PLT1077-08-(4.5)</td>
<td>0.073</td>
<td>-0.35</td>
<td>-0.69</td>
<td>2.64</td>
<td>6.71</td>
<td>2.61</td>
</tr>
</tbody>
</table>

### Example Part Number:

**PLT1077 ( ) ( ) ( )**

- **Grip Lengths in 1/16ths (See Table II)**
- **Nominal Body Diameter in 1/32" (See Table I)**
- **Designates Special Finish Code (See ESCBB-4)**
- **Basic Part Number, Self-Locking Blind Fastener**

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**Visu-Lok®, Fastener, Blind, Domed Head, Self-Locking, Alloy Steel**

![Typical Installation Diagram](Diagram)
APPLICABLE SPECIFICATIONS:
PROCUREMENT SPECIFICATION: NAS1675, CLASS I, EXCEPT HEAD STYLE, GRIP RANGE AND BREAK-OFF LIMITS.

MATERIAL:
NUT AND SCREW: ALLOY STEEL 4130 PER AMS-S-6758, ALLOY STEEL 4140 PER AMS6382 OR AMS6349 OR ALLOY STEEL 8740 PER AMS6322.
SLEEVE: CRES 303 OR CRES 304 PER AMS-QQ-S-763, AMS5639 OR AMS5641.

HEAT TREAT:
NUT AND SCREW: HEAT TREAT TO 39-43 HRC (180-200 KSI) PER AMS2759.
SLEEVE: AS REQUIRED FOR PERFORMANCE.

FINISH:
NUT AND SCREW: CADMIUM PLATED PER AMS-QQ-P-416 TYPE II, CLASS 2. CADMIUM PLATE PER NAS672 IS PERMISSIBLE PROVIDED IT IS FOLLOWED BY A DICROMATE POST TREATMENT PER AMS-QQ-P-416.
SLEEVE: PASSIVATE PER AMS2700. CADMIUM PLATED PER AMS-QQ-P-416, TYPE I, CLASS 3.

LUBRICATION:
NUT: WWM CARBO-WAX, PARAFFIN WAX AND/OR CETYL ALCOHOL PER AS87132.
SCREW AND SLEEVE: SOLID DRY FILM LUBRICANT PER THE CHEMICAL REQUIREMENTS OF AS5272 TYPE I OR EVERLUBE 812 PER MIL-PRF-81329, WWM CARBO-WAX, PARAFIN WAX AND/OR CETYL ALCOHOL PER AS87132.

LUBRICANTS LISTED MAY BE APPLIED TO ANY OR ALL COMPONENTS AS REQUIRED FOR PERFORMANCE.

GENERAL NOTES:
1. OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT BE GREATER THAN MAXIMUM " ØD".
2. REMOVE ALL LOOSE OR HANGING BURRS.
4. THE PREVAILING TORQUE SHALL CONFORM TO THE VALUES AS TABULATED, WHEN TESTED IN ACCORDANCE WITH SPECIFICATION NAS1675.
5. HEAD MARKINGS ON NUT DEPRESSED .010 INCH [0,254 mm] MAXIMUM. POSITION OPTIONAL.
6. STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.
7. RECOMMENDED INSTALLATION TOOL: MPR-8A.
8. DISTORTION OF " ØD" PERMISSIBLE IN LOCKING AREA.
9. MUST ENTER A .2610" [6,63 mm] HOLE WITH FINGER PRESSURE.
10. AMS-S-8802 SEALANT IN FAYING SURFACES.
11. HALF GRIP SIZES MAY BE ORDERED BY ADDING ".5" TO THE GRIP DASH NUMBER.

TABLE II

<table>
<thead>
<tr>
<th>2ND DASH NO.</th>
<th>G x0.400/0.100</th>
<th>GRIP RANGE</th>
<th>( )</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>INCH</td>
<td>mm</td>
<td>MIN</td>
</tr>
<tr>
<td>-03</td>
<td>202</td>
<td>5,13</td>
<td>162</td>
</tr>
<tr>
<td>-04</td>
<td>244</td>
<td>6,20</td>
<td>203</td>
</tr>
<tr>
<td>-05</td>
<td>285</td>
<td>7,24</td>
<td>223</td>
</tr>
<tr>
<td>-06</td>
<td>320</td>
<td>8,37</td>
<td>280</td>
</tr>
<tr>
<td>-07</td>
<td>340</td>
<td>8,73</td>
<td>240</td>
</tr>
<tr>
<td>-08</td>
<td>500</td>
<td>12,70</td>
<td>460</td>
</tr>
</tbody>
</table>

TITLE: VISU-LOK®, FASTENER, BLIND, DOMED HEAD, SELF-LOCKING, ALLOY STEEL
DRAWING NO: PLT1077( )-( )-( )
DRAWN BY: A PEREZ 03/23/2014
APPROVED BY: M 11/10/14
REV: M
ECN NO: 14-0734
ECN DATE: 11/10/14
SHEET 2 OF 2