PROCUREMENT SPEC: ESCBB-9, CLASS 4, EXCEPT AS SPECIFIED HEREIN.

MATERIAL:

NUT & SCREW: 6AL-4V TITANIUM PER AMS4928 OR AMS4967.

SLEEVE: CORROSION RESISTANT STEEL.

HEAT TREAT:

NUT & SCREW: HEAT TREAT PER AMS-H-81200. MAX HYDROGEN 125 PPM.

SLEEVE: AS REQUIRED FOR PERFORMANCE.

FINISH:

“.” NUT & SCREW: NONE.

SLEEVE: PASSIVATE PER AMS2700.

LUBRICANT:

SOLID DRY FILM LUBRICANT PER THE CHEMICAL REQUIREMENTS OF AS5272.

TYPES I OR EVERLUBE 812 PER MIL-PRF-81329, PARAFFIN WAX OR CETYL ALCOHOL PER AS87132 MAY BE APPLIED TO ANY OR ALL COMPONENTS AS REQUIRED FOR PERFORMANCE. (SEE ESCBB4 FOR SPECIAL LUBRICANTS AND FINISHES)

PART CODE & EXAMPLE:

PLT1082 ( ) - 12 - 08

GRIP LENGTHS IN 1/16THS OF AN INCH.

NOMINAL BODY DIAMETER AS TABULATED. DESIGNATES SPECIAL FINISH CODE. SEE ESCBB-4.

BASIC PART NUMBER, SELF LOCKING BLIND FASTENER.

GENERAL NOTES:

1. CONCENTRICITY OF NUT HEAD CONICAL SURFACE TO "D" DIAMETER SHALL BE WITHIN .005" T.I.R. (EXCEPT OVER INDENTS).

2. REMOVE ALL LOOSE OR HANGING BURRS.

3. THESE PARTS HAVE A CLOSE TOLERANCE (.0005) GROUND SHANK AND ARE INTENDED FOR USE IN UP TO .0035 DIAMETRAL INTERFERENCE FIT APPLICATIONS.

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 DESPRESSED .010" MAXIMUM.

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

   EXAMPLE: PLT1082-04-4.5 INDICATES A NOMINAL GRIP LENGTH OF 4.5 SIXTEENTHS = 0.281".

   THE GRIP RANGE FOR THESE HALF-GRIP SIZES WILL BE NOMINAL GRIP + .031" - .030".

   EXCEPT: THE GRIP RANGE FOR -1.5 GRIP SHALL BE MAX GRIP = 0.125", MIN GRIP = 0.078".

   THE BASIC "G" DIMENSION WILL BE NOMINAL GRIP + .031" AND THE OVERALL SCREW LENGTH "L" DIMENSION MAY VARY AT MANUFACTURER'S OPTION.

8. STANDARD GRIP LENGTHS ARE SHOWN AS TABULATED, 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 "D" MAX + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS (22.23 NEWTONS).

10. DIMENSIONS "A", "A'", AND "H" 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.

11. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.

   FOR ALUMINUM APPLICATION, SHANK "D" MEASUREMENT MAY INCREASE .0002 INCH OVER THE MAXIMUM DIAMETER AND DECREASE .0005 INCH UNDER THE MINIMUM DIAMETER.