

12

PART NUMBER	Ø NOM		Ø A		Ø B		C MAX		Ø D		F WRENCH FLATS		H		Ø J MAX		K MAX		R. R	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
PLT1091-08-()	.2900	7.366	.427 .415	10.85 10.54	.380 .340	9.65 8.64	.398	10.11	.291 .289	7.39 7.34	.135 .130	3.43 3.30	.063 .053	1.60 1.35	.401	10.19	.366	9.30	.025 .015	0.64 0.38

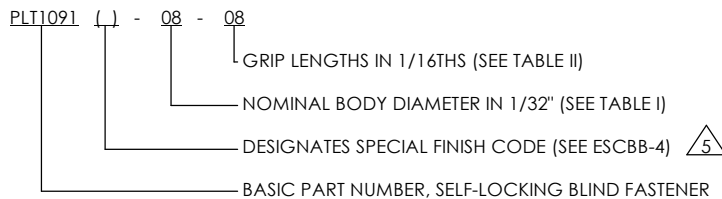
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PART NUMBER	BREAK-OFF LIMITS		MINIMUM AVAILABLE GRIP LENGTH (TABLE II)	HOLE SIZE		PREVAILING TORQUE MIN		DOUBLE SHEAR STRENGTH MIN		TENSILE STRENGTH MIN	
	INCH	mm		INCH	mm	IN-LBS	Nm	LBS	N	LBS	N
PLT1091-08-()	+0.053 -0.035	+1.35 -0.89	-03	.294 .291	7.47 7.39	2.5	0.282	9000	40030	2100	9340

EXAMPLE PART NUMBER:



TITLE:

VISU-LOK® II, FASTENER, BLIND,
DOMED HEAD, SELF-LOCKING,
ALLOY STEEL, 1/32" OVERSIZE

DRAWING NO:

PLT1091()-()-()

DRAWN BY:

A PEREZ

DRAWN DATE:

03/25/2014

APPROVED BY:

CHECKED DATE:



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2ND DASH NO.	TABLE II							
	G +.040/-0.10 [+1.02/-0.25 mm]		GRIP RANGE				(L)	
	INCH	mm	MIN		MAX		-08	
INCH			mm	INCH	mm	INCH	mm	
-03	.202	5,13	.162	4,11	.202	5,13	.944	23,98
-04	.244	6,20	.203	5,16	.244	6,20	1,006	25,55
-05	.285	7,24	.245	6,22	.285	7,24	1,069	27,15
-06	.320	8,13	.280	7,11	.320	8,13	1,131	28,73
-07	.447	11,35	.407	10,34	.447	11,35	1,194	30,33

APPLICABLE SPECIFICATIONS:

PROCUREMENT SPECIFICATION: ESCBB-2, CLASS 1, EXCEPT AS SPECIFIED HEREIN.

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.

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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 DICHROMATE POST TREATMENT PER AMS-QQ-P-416.
SLEEVE: PASSIVATE PER AMS2700. CADMIUM PLATED PER AMS-QQ-P-416, TYPE I, CLASS 3.

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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, PARAFFIN 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.
3. LOCKING FEATURE CONSISTS OF THREE (3) INDENTATIONS LOCATED 120 ° APART ON THE PERIPHERY OF THE NUT COMPONENT AND APPROXIMATELY .040" [1,02 mm] ABOVE THE INTERSECTION OF THE NUT NOSE ANGLE AND O.D. (MEAN GRIP OF FASTENER).
4. HEAD MARKINGS ON NUT DEPRESSED .010 INCH [0,254 mm] MAXIMUM. POSITION OPTIONAL.
5. STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.
6. RECOMMENDED INSTALLATION TOOL: MPR-8A.
7. MUST ENTER A .292" [7,42 mm] HOLE WITH FINGER PRESSURE.
8. AMS-S-8802 SEALANT IN FAYING SURFACES.
9. STANDARD GRIP LENGTHS ARE SHOWN IN TABLE II. SHORTER OR LONGER GRIPS, OTHER THAN THOSE LISTED, MAY BE AVAILABLE AS SPECIALS. ON GRIP LENGTHS SHORTER THAN THOSE LISTED, THE BREAK-OFF LIMITS AND PREVAILING TORQUE VALUES SHOWN IN TABLE I DO NOT APPLY.
10. DISTORTION OF " ØD" PERMISSIBLE IN LOCKING AREA. DISTORTION OF " ØD" SHALL NOT PREVENT INSERTION OF THE FASTENER INTO A RING GAUGE OF LENGTH EQUAL TO ONE DIAMETER AND DIAMETER EQUAL TO MAXIMUM " ØD" + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS [22.23 N].
11. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.
12. DIMENSION " ØA" IS FOR ENGINEERING REFERENCE PURPOSES ONLY AND IS NOT TO BE USED FOR INSPECTION PURPOSES. THIS DIMENSION IS A THEORETICAL VALUE DERIVED FROM " ØB", "H", " ØD" AND HEAD EDGE RADIUS.



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TITLE:

VISU-LOK® II, FASTENER, BLIND,
DOMED HEAD, SELF-LOCKING,
ALLOY STEEL, 1/32" OVERSIZE

DRAWING NO:

PLT1091()-()-()

DRAWN BY:

A PEREZ

DRAWN DATE:

03/25/2014

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CHECKED DATE:

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ECN DATE: 11/12/14

REV: E
SHEET 2 OF 2