**TYPICAL INSTALLATION**

**TABLE I**

<table>
<thead>
<tr>
<th>PART NUMBER</th>
<th>( \odot \text{NOM} )</th>
<th>( \odot A )</th>
<th>( \odot B )</th>
<th>( \odot \text{MAX} )</th>
<th>( \odot D )</th>
<th>F WRENCH FLATS</th>
<th>WRENCH FLATS</th>
<th>H</th>
<th>( \odot J ) MAX</th>
<th>K MAX</th>
<th>R R</th>
</tr>
</thead>
<tbody>
<tr>
<td>INCH</td>
<td>mm</td>
<td>INCH</td>
<td>mm</td>
<td>INCH</td>
<td>mm</td>
<td>INCH</td>
<td>mm</td>
<td>INCH</td>
<td>mm</td>
<td>INCH</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</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>INCH</td>
<td>mm</td>
<td>INCH</td>
<td>mm</td>
<td>IN-LBS</td>
<td>LBS</td>
<td>LBS</td>
</tr>
<tr>
<td>PLT1091-08-( )</td>
<td>+.053</td>
<td>+.135</td>
<td>-.013</td>
<td>9000</td>
<td>4000</td>
<td>2100</td>
</tr>
</tbody>
</table>

**EXAMPLE PART NUMBER:**

PLT091(-08-08)

- 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
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. CRES 303 OR CRES 304 PER AMS-QQ-S-763, AMS5639 OR AMS6349.
- **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 DICHROMATE 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 ASS272 TYPE I OR EVERLUBE 812 PER MIL-PRF-81329, WWM CARBO-WAX, PARAFFIN WAX AND/OR CETYL ALCOHOL PER AS87132.

LUBRICATIONS 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 "$ \Phi D$".
2. REMOVE ALL LOOSE OR HANGING BURRS.
3. LOCKING FEATURE CONSISTS OF THREE (3) INDENTATIONS LOCATED 120° APART ON THE PERIPHERY OF THE NUT COMPONENT AND APPROXIMATELY .040" (.102 mm) ABOVE THE INTERSECTION OF THE NUT NOSE ANGLE AND O.D. (MEAN GRIP OF FASTENER).
4. HEAD MARKINGS ON NUT DEPRESSED .010 INCH (.0254 mm) MAXIMUM. POSITION OPTIONAL.
5. STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.
6. RECOMMENDED INSTALLATION TOOL: MPR-8A.
7. MUST ENTER A .292" (.742 mm) HOLE WITH FINGER PRESSURE.
8. AMS-S-8802 SEALANT IN FACING SURFACES.
9. STANDARD GRIP LENGTHS ARE SHOWN IN TABLE II. SHORTER OR LONGER GRIPS, OTHER THAN THOSE LISTED, MAY BE AVAILABLE AS SPECIALS. ON GRIP LENGTHS SHORTER THAN THOSE LISTED, THE BREAK-OFF LIMITS AND PREVAILING TORQUE VALUES SHOWN IN TABLE I DO NOT APPLY.
10. DISTORTION OF "$ \Phi D$" PERMISSIBLE IN LOCKING AREA. DISTORTION OF "$ \Phi D$" SHALL NOT PREVENT INSERTION OF THE FASTENER INTO A RING GAUGE OF LENGTH EQUAL TO ONE DIAMETER AND DIAMETER EQUAL TO MAXIMUM "$ \Phi D$" +.001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS (22.23 N).
11. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.
12. DIMENSION "$ A $" IS FOR ENGINEERING REFERENCE PURPOSES ONLY AND IS NOT TO BE USED FOR INSPECTION PURPOSES. THIS DIMENSION IS A THEORETICAL VALUE DERIVED FROM " $ B $", " $ H $", "$ \Phi D $" AND HEAD EDGE RADIUS.