PROCUREMENT SPEC: ESCBB-2, CLASS 1, EXCEPT AS SPECIFIED HEREBIN.

MATERIAL: NUT & SCREW: ALLOY STEEL: 4130 PER AMS-S-6758, 4140 PER AMS6382 OR AMS6349 OR 8740 PER AMS6322.
SLEEVE: CORROSION RESISTANT STEEL: 303 OR 304 PER AMS-QQ-S-763, AMS5569 OR AMS5641.

HEAT TREAT: NUT & SCREW: HEAT TREAT PER AMS2759 TO HRC 39-46.
SLEEVE: AS REQUIRED FOR PERFORMANCE.

FINISH: NUT & SCREW: CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2. CADMIUM PLATE PER NAS672 OR AMS5639 OR AMS5641.
SLEEVE: PASSIVATE PER AMS2700. CADMIUM PLATE PER AMS-QQ-P-416, TYPE 1, CLASS 3.

LUBRICANT: LUBRICANTS LISTED BELOW MAY BE APPLIED TO ANY OR ALL COMPONENTS IF REQUIRED FOR FASTENER PERFORMANCE:
NUT: WWM CARBO-WAX, PARAFFIN WAX, AND/OR CETYL ALCOHOL PER AS87132.
SCREW & SLEEVE: DRY FILM LUBE PER AS5272 OR MIL-PRF-81329, WWM CARBO-WAX, PARAFFIN.

PART CODE & EXAMPLE: PLT1098 - 08 - 08
GRIP LENGTHS IN 1/16THS
NOMINAL BODY DIAMETER AS TABULATED
BASIC PART NUMBER, SELF LOCKING BLIND FASTENER

GENERAL NOTES:
1. OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT BE GREATER THAN MAXIMUM "D" DIAMETER.
2. CONCENTRICITY OF NUT HEAD CONICAL SURFACE TO "D" DIAMETER SHALL BE WITHIN .005 T.I.R., (EXCEPT OVER INDENTS).
3. REMOVE ALL LOOSE OR HANGING BURRS.
5. MANUFACTURER’S IDENTIFICATION:
LETTER "N" DESIGNATES MONOGRAM AEROSPACE FASTENERS.
LETTERS "VS" DESIGNATE VOI-SHAN.
6. HEAD MARKINGS ON NUT DEPRESSED .010" MAX. LOCATION OPTIONAL.
7. STANDARD FINISHES AND LUBES ARE SHOWN ABOVE. REFER TO ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBES, IF REQUIRED.
8. HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.
EXAMPLE: PLT1098-06-4.5 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"
9. STANDARD GRIP LENGTHS ARE AS TABULATED. 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 AS TABULATED DO NOT APPLY.
10. PLT1098 IS A 1/64" OVERSIZE VERSION OF PLT114.
11. 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 MAXIMUM "D" + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS.
12. 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.
13. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.
GROUND SHANK VISU-LOKS SHOULD NOT BE USED, EXCEPT WITH CONSIDERABLE CAUTION, IN APPLICATIONS WHICH EXCEED .0005 INTERFERENCE FIT. GROUND SHANK VISU-LOKS WILL PERFORM SATISFACTORILY WHEN INSTALLED IN THE TABULATED HOLE SIZES.