NUT & SCREW: ALLOY STEEL: 4130 PER AMS-S-6758, 4140 PER AMS6382 OR AMS6349 OR 8740 PER AMS622.
SLEEVE: CORROSION RESISTANT STEEL: 303 OR 304 PER AMS-QQ-S-763, AMS5639 OR AM5641.

HEAT TREAT:
NUT & SCREW: HEAT TREAT PER AMS2759. APPROXIMATELY 180,000-200,000 PSI TENSILE (HRC 39-43).
SLEEVE: AS REQUIRED FOR PERFORMANCE.

FINISH:
NUT & SCREW: CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2. CADMIUM PLATE PER NA5672 IS PERMISSIBLE PROVIDED IT IS FOLLOWED BY A DICROMATE POST TREATMENT PER AMS-QQ-P-416.
SLEEVE: PASSIVATE PER AMS2700. CADMIUM PLATE PER AMS-QQ-P-416, TYPE I, 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 MIL-L-87132.
SCREW & SLEEVE: DRY FILM LUBE PER ASS272 OR MIL-PRF-81329, WWM CARBO-WAX, PARAFFIN WAX, AND/or CETYL ALCOHOL PER AS87132.

PART CODE & EXAMPLE:
PLT1099 - 08 - 08

<table>
<thead>
<tr>
<th>G</th>
<th>GRIP LENGTHS IN 1/16THS.</th>
<th>NOMINAL BODY DIAMETER AS TABULATED.</th>
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<td></td>
<td>BASIC PART NUMBER, SELF-LOCKING BLIND FASTENER.</td>
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GENERAL NOTES:
1. CONCENTRICITY OF NUT HEAD CONICAL SURFACE TO "D" DIAMETER SHALL BE WITHIN 0.005" (0.13 mm) T.I.R. (EXCEPT OVER INDENTS)
2. REMOVE ALL LOOSE OR HANGING BURRS.
3. 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 SATISFORTILY WHEN INSTALLED IN THE TABULATED HOLE SIZES.

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 PERIPHERY OF THE NUT COMPONENT AND APPROXIMATELY .040" (1.02 mm) ABOVE THE INTERSECTION OF THE NUT ANGULAR O.D. AND "D" DIAMETER (MEAN GRIP OF FASTENER).

5. MANUFACTURER'S IDENTIFICATION:
LETTER "N" DESIGNATES MONOGRAM AEROSPACE FASTENERS.
LETTERS "VS" DESIGNATE ALCOA.

HEAD MARKINGS ON NUT DEPRESSED .010" (0.254 mm) MAXIMUM.

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

EXAMPLE: PLT1099-06-4.5 INDICATES A NOMINAL GRIP LENGTH OF 4.5 SIXTEENTHS = 0.281". THE GRIP RANGE FOR THESE HALF-GRIP SIZES WILL BE NOMINAL GRIP +/-0.031". 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 +0.031" 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.

12. PLT1099 IS A 1/64" OVERSIZE VERSION OF PLT114.