PROCUREMENT SPEC: ESCBB-2 CLASS 2.

MATERIAL:
NUT, SCREW, & SLEEVE: CORROSION RESISTANT STEEL, TYPE A286 PER AMS5731, AMS5732 OR AMS5737.

HEAT TREAT:
NUT & SCREW: SOLUTION HEAT TREATED AND AGED TO HARDNESS OF HRC 30 TO HRC 45. ALL CORE HARDNESS READINGS ARE TAKEN ON MOUNTED SPECIMEN, USING A BRALE PENETRATOR A 30 Kg LOAD (ROCKWELL 30N).

SLEEVE: SOLUTION TREATED.

FINISH:
NUT, SCREW, & SLEEVE: PASSIVATE PER AMS2700.

LUBRICANT:
LUBRICANTS LISTED BELOW MAY BE APPLIED TO ANY OR ALL COMPONENTS IF REQUIRED FOR PERFORMANCE.
DRY FILM LUBE PER AS5272 TYPE I OR MIL-PRF-81329, WWM CARBO-WAX, PARAFFIN WAX, AND/OR CYTALcohol PER AS87132.

PART CODE & EXAMPLE:
PLT124 - 05 - 05

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 EXCEED MAXIMUM "D" DIAMETER.
2. CONCENTRICITY OF NUT HEAD CONICAL SURFACE TO "D" DIAMETER SHALL BE WITHIN .005" T.I.R., EXCEPT OVER INDENTATIONS.
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: PLT121-06-4.5 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.
The BASIC "G" DIMENSION WILL BE NOMINAL GRIP +.031 AND THE OVERALL SCREW LENGTH "L" DIMENSION MAY VARY AT MANUFACTURER'S OPTION.
9. GROUND SHANK VISU-LOKS SHOULD NOT BE USED, EXCEPT WITH CONSIDERABLE CAUTION. IN APPLICATIONS WHICH EXCEED APPROXIMATELY .005" INTERFERENCE FIT. GROUND SHANK VISU-LOKS WILL PERFORM SATISFACTORIZELY WHEN INSTALLED IN THE TABULATED HOLE SIZES.
10. 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.
11. 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.
12. DIMENSIONS "A", "A'", "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.