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TYPICAL INSTALLATION

TABLE I

PART NUMBER	A	C MAX. $\triangle 10$	D DIA.	E MAX. $\triangle 1$	F DRIVING FLATS	H MAX.	J DIA. MAX.	K MAX.	N MIN.	R RAD.	BREAK-OFF LIMITS $\triangle 9$	PREVAILING TORQUE IN. LBS. MIN. $\triangle 9$	DOUBLE SHEAR STRENGTH LBS. MIN.	TENSILE STRENGTH LBS. MIN.
PLT 1089-6-(*)	.312 .305	.364	.2335 .2330	.2300	.104 .099	.113	.300	.333	.340	.025 .015	+.098 +.010	1.5	4600	1400
PLT 1089-8-(*)	.375 .367	.398	.2945 .2940	.2910	.135 .130	.135	.384	.386	.409	.025 .015	+.135 +.047	2.5	7900	2100
PLT 1089-10-(*)	.437 .429	.482	.3460 .3455	.3425	.152 .147	.160	.427	.447	.479	.030 .015	+.146 +.043	3.5	11350	3600
PLT 1089-12-(*)	.500 .491	.567	.4090 .4085	.4055	.185 .180	.190	.516	.527	.548	.030 .015	+.152 +.049	4.0	16450	5600

(\*) SEE TABLE II FOR SECOND DASH NUMBER AND APPROVED CALLOUT.

TABLE II

SECOND DASH NUMBER	G GRIP $\triangle 6$ $\triangle 9$	GRIP RANGE $\triangle 6$ $\triangle 9$		L REF.				SECOND DASH NUMBER	G GRIP $\triangle 6$ $\triangle 9$	GRIP RANGE $\triangle 6$ $\triangle 9$		L REF.			
		MIN.	MAX.	PLT1089						MIN.	MAX.	PLT1089			
				-6-(*)	-8-(*)	-10-(*)	-12-(*)					-6-(*)	-8-(*)	-10-(*)	-12-(*)
-1	.093	.031	.093	.874	-	-	-	-17	1.094	1.032	1.094	1.874	1.944	2.096	2.242
-2	.156	.094	.156	.936	1.006	1.158	-	-18	1.156	1.095	1.156	1.936	2.006	2.158	2.304
-3	.219	.157	.219	.999	1.069	1.221	1.367	-19	1.219	1.157	1.219	1.999	2.069	2.221	2.367
-4	.281	.220	.281	1.061	1.131	1.283	1.429	-20	1.281	1.220	1.281	2.061	2.131	2.283	2.429
-5	.344	.282	.344	1.124	1.194	1.346	1.492	-21	1.344	1.282	1.344	2.124	2.194	2.346	2.492
-6	.406	.345	.406	1.186	1.256	1.408	1.554	-22	1.406	1.345	1.406	2.186	2.256	2.408	2.554
-7	.469	.407	.469	1.249	1.319	1.471	1.617	-23	1.469	1.407	1.469	2.249	2.319	2.471	2.617
-8	.531	.470	.531	1.311	1.381	1.533	1.679	-24	1.531	1.470	1.531	2.311	2.381	2.533	2.679
-9	.594	.532	.594	1.374	1.444	1.596	1.742	-25	1.594	1.532	1.594	2.374	2.444	2.596	2.742
-10	.656	.595	.656	1.436	1.506	1.658	1.804	-26	1.656	1.595	1.656	2.436	2.506	2.658	2.804
-11	.719	.657	.719	1.499	1.569	1.721	1.867	-27	1.719	1.657	1.719	2.499	2.569	2.721	2.867
-12	.781	.720	.781	1.561	1.631	1.783	1.929	-28	1.781	1.720	1.781	2.561	2.631	2.783	2.929
-13	.844	.782	.844	1.624	1.694	1.846	1.992	-29	1.844	1.782	1.844	2.624	2.694	2.846	2.992
-14	.906	.845	.906	1.686	1.756	1.908	2.054	-30	1.906	1.845	1.906	2.686	2.756	2.908	3.054
-15	.969	.907	.969	1.749	1.819	1.971	2.117	-31	1.969	1.907	1.969	2.749	2.819	2.971	3.117
-16	1.031	.970	1.031	1.811	1.881	2.033	2.179	-32	2.031	1.970	2.031	2.811	2.881	3.033	3.179

$\triangle 9$  TOLERANCES: FOR -6 SIZE +.030/-.010; FOR -8 & -10 SIZES +.040/-.010; FOR -12 SIZE +.050/-.010.

U.S. PATENT NO. 3643544, OTHER PATENTS PENDING.

**Fairchild**  
 CODE IDENT. NO.  
**92215**

**MONOGRAM**  
 CODE IDENT. NO.  
**98524**

APPROVED DATE  
 08-15-84 ECN #3935

REV. LETTER AND DATE  
 06-29-06  
 ECN#5799

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TITLE  
**VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE TITANIUM, 76 KSI SHEAR PROTRUDING HEX HEAD, SELF LOCKING GROUND SHANK, 1/32" OVERSIZE**

**STANDARD**

**PLT1089**

**SHEET 1 OF 2**



PROCUREMENT SPEC. : ESCBB-9, CLASS 2, EXCEPT AS NOTED HEREIN.

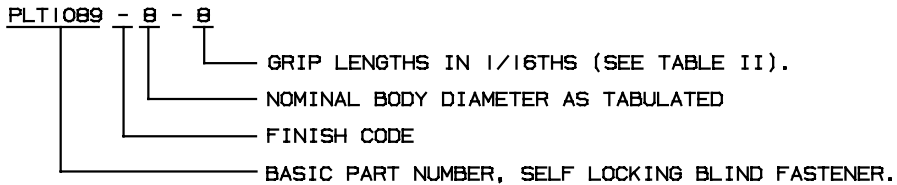
MATERIAL : NUT & SCREW : 6AL-4V TITANIUM PER AMS4928 OR AMS4967.  
 SLEEVE : CORROSION RESISTANT STEEL.

HEAT TREAT : NUT & SCREW : HEAT TREAT PER AMS-H-81200, HYDROGEN 125 PPM  
 MAX. SLEEVE : AS REQUIRED FOR PERFORMANCE.

FINISH: "-" NUT & SCREW : NONE. (SEE ESCBB-4 FOR SPECIAL LUBRICANTS AND FINISHES).  
 SLEEVE : PASSIVATE PER AMS-QQ-P-35.  
 "L" NUT : ALUMINUM COAT PER NAS4006.  
 SLEEVE : PASSIVATE PER AMS-QQ-P-35 AND ALUMINUM COAT PER NAS4006.  
 SCREW : NONE.

LUBRICANT : NUT: DRY FILM LUBRICANT PER MIL-PRF-46010 TYPE I OR EVERLUBE #812 PER MIL-PRF-81329. CETYL ALCOHOL PER MIL-L-87132, OPTIONAL.  
 SCREW & SLEEVE: DRY FILM LUBE PER MIL-PRF-46010 TYPE I OR EVERLUBE 812 PER MIL-PRF-81329, PARAFFIN WAX AND/OR CETYL ALCOHOL PER MIL-L-87132 MAY BE APPLIED AS REQUIRED FOR PERFORMANCE.

PART CODE & EXAMPLE :



GENERAL NOTES :

1. OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT BE GREATER THAN MAXIMUM "E" DIAMETER.
- 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 ABOVE THE INTERSECTION OF THE NUT NOSE ANGLE AND O.D. (MEAN GRIP OF FASTENER).
4. MANUFACTURER'S IDENTIFICATION:  
 LETTER "N" DESIGNATES MONOGRAM AEROSPACE FASTENERS.  
 LETTERS "VS" DESIGNATE VOI-SHAN.
- 5.) HEAD MARKINGS ON NUT DEPRESSED .010 MAX. LOCATION OPTIONAL.
6. HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBER.  
 EXAMPLE: PLT 1089-6-4.5 INDICATES A NOMINAL GRIP LENGTH OF 4.5 SIXTEENTHS = .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.
- 7.) THESE PARTS HAVE A CLOSE TOLERANCE (.0005 INCHES) GROUND SHANK AND ARE INTENDED FOR UP TO .0035 INCH DIAMETRICAL INTERFERENCE FIT APPLICATIONS.
8. STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.
9. STANDARD GRIP LENGTHS ARE SHOWN IN TABLE II, 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 SHOWN IN TABLE I DO NOT APPLY.
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. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.

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**STANDARD**  
**PLT1089**  
**SHEET 2 OF 2**

REV. LETTER AND DATE  
 06-29-08  
 ECN#3799