

| PART NUMBER | NOM. DIAM. | | A HEX. | | C MAX. | | D DIA. | | E DIA. MAX. | | F FLATS | | H HEAD HEIGHT | | J DIA. MAX. | | K MAX. | | L REF. | | N. MIN. | |
|----------------|------------|-------|--------------|----------------|--------|-------|----------------|----------------|-------------|-------|--------------|--------------|---------------|--------------|-------------|-------|--------|-------|--------|-------|---------|-------|
| | INCH | mm | INCH | mm | INCH | mm | INCH | mm | INCH | mm | INCH | mm | INCH | mm | INCH | mm | INCH | mm | INCH | mm | INCH | mm |
| PLT1089-06-(-) | .2332 | 5,92 | .312 .305 | 7,92 7,75 | .364 | 9,25 | .2335 .2330 | 5,93 5,92 | .2300 | 5,84 | .104 .099 | 2,64 2,52 | .113 .074 | 2,87 1,88 | .315 | 8,00 | .333 | 8,46 | .780 | 19,81 | .340 | 8,64 |
| PLT1089-08-(-) | .2942 | 7,47 | .375 .367 | 9,52 9,32 | .398 | 10,11 | .2945 .2940 | 7,48 7,47 | .2910 | 7,39 | .135 .130 | 3,43 3,30 | .135 .084 | 3,43 2,13 | .401 | 10,19 | .366 | 9,30 | .850 | 21,59 | .409 | 10,39 |
| PLT1089-10-(-) | .3457 | 8,78 | .437 .429 | 11,10 10,90 | .482 | 12,24 | .3460 .3455 | 8,79 8,78 | .3425 | 8,70 | .152 .147 | 3,86 3,73 | .160 .106 | 4,06 2,69 | .442 | 11,23 | .447 | 11,35 | 1,002 | 25,45 | .479 | 12,17 |
| PLT1089-12-(-) | .4087 | 10,38 | .500 .491 | 12,70 12,47 | .567 | 14,40 | .4090 .4085 | 10,39 10,38 | .4055 | 10,30 | .185 .180 | 4,70 4,57 | .190 .127 | 4,83 3,22 | .531 | 13,49 | .527 | 13,39 | 1,148 | 29,16 | .548 | 13,92 |

| PART NUMBER | R RAD. | | BREAK-OFF LIMITS | | MINIMUM AVAILABLE GRIP LENGTH | HOLE SIZE | | PREVAILING TORQUE MIN. | | DOUBLE SHEAR STRENGTH MIN. | | TENSILE STRENGTH MIN. | |
|----------------|--------------|--------------|------------------|----------------|-------------------------------|--------------|----------------|------------------------|-------|----------------------------|-------|-----------------------|-------|
| | INCH | mm | INCH | mm | | INCH | mm | IN-LB | Nm | LBS. | N | LBS. | N |
| PLT1089-06-(-) | .025 .015 | 0,63 0,38 | +0,98 +0,10 | +2,49 +0,25 | -01 | .237 .234 | 6,02 5,94 | 1.5 | 0,170 | 4600 | 20460 | 1400 | 6230 |
| PLT1089-08-(-) | .025 .015 | 0,63 0,38 | +1,35 +0,47 | +3,43 +1,19 | -02 | .298 .295 | 7,57 7,49 | 2.5 | 0,282 | 7900 | 35140 | 2100 | 9340 |
| PLT1089-10-(-) | .030 .015 | 0,76 0,38 | +1,46 +0,43 | +3,71 +1,09 | -02 | .349 .346 | 8,87 8,79 | 3.5 | 0,400 | 11350 | 50480 | 3600 | 16010 |
| PLT1089-12-(-) | .030 .015 | 0,76 0,38 | +1,52 +0,49 | +3,86 +1,24 | -03 | .412 .409 | 10,47 10,39 | 4.0 | 0,452 | 16450 | 73170 | 5600 | 24910 |

▲ "G" TOLERANCE: FOR -06 SIZES +.030/-010; FOR -08 & -10 SIZES +.040/-010; FOR -12 SIZES +.050/- .010.



PROCUREMENT SPEC: ESCBB-9, CLASS 2, EXCEPT AS SPECIFIED 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. MAX. HYDROGEN 125 PPM.
SLEEVE: AS REQUIRED FOR PERFORMANCE.

FINISH :

"-" NUT & SCREW: NONE.
SLEEVE: PASSIVATE PER AMS2700.
"L" NUT: ALUMINUM COAT PER NAS4006.
SLEEVE: NONE.
SCREW: PASSIVATE PER AMS2700 AND ALUMINUM COAT PER NAS4006.

LUBRICANT:

SOLID DRY FILM LUBRICANT PER THE CHEMICAL REQUIREMENTS OF AS5272 TYPE I OR EVERLUBE 812 PER MIL-PRF-81329, PARAFFIN WAX, CETYL ALCOHOL PER AS87132 MAY BE APPLIED TO ANY OR ALL COMPONENTS AS REQUIRED FOR PERFORMANCE. (SEE ESCBB-4 FOR SPECIAL LUBRICANTS AND FINISHES).

"X" NUT:

I.V.D. ALUMINUM COATING PER MIL-DTL-83488, CLASS 3, TYPE II WITH A SUPPLEMENTARY TREATMENT OF MIL-DTL-5541, TYPE II, CLASS IA (TRIVALENT CHROMATE).

SLEEVE: PASSIVATE PER AMS2700.

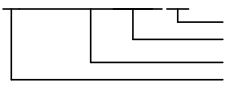
SCREW: KALGARD ANN-RO #1012 OPTIONAL.

LUBRICANT:

WWM CARBO WAX, PARAFFIN WAX AND/OR CETYL ALCOHOL PER AS87132 MAY BE USED ON ANY/OR ALL COMPONENTS AS REQUIRED FOR PERFORMANCE. TIOLON A20, TIOLON X20, AND KAL-GARD FC-2 MAY BE USED ON THE SCREW AND SLEEVE COMPONENTS.

PART CODE & EXAMPLE:

PLT1089 () - 08 - 08



GRIP LENGTHS IN 1/16THS
NOMINAL BODY DIAMETER AS TABULATED
DESIGNATES SPECIAL FINISH CODE, SEE ESCBB-4
BASIC PART NUMBER, SELF LOCKING BLIND FASTENER

GENERAL NOTES:

- HEAD MARKINGS ON NUT DEPRESSED .010 MAX.
- REMOVE ALL LOOSE OR HANGING BURRS.
- 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).
- 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.
- HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.

PLT1089-06-4.5 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.
- 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.
- THESE PARTS HAVE A CLOSE TOLERANCE (.0005 INCHES) GROUND SHANK AND ARE INTENDED FOR UP TO .0035 INCH DIAMETRICAL INTERFERENCE FIT INSTALLATION.
- DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.
- FOR ALUMINUM APPLICATION, SHANK "D" MEASUREMENT MAY INCREASE .0002 INCH OVER THE MAXIMUM DIAMETER AND DECREASE .0005 INCH UNDER THE MINIMUM DIAMETER.

| 5 SECOND DASH NUMBER | G GRIP | | GRIP RANGE | | | |
|-------------------------------|-----------|-------|------------|-------|-------|-------|
| | | | MIN | | MAX | |
| | INCH | mm | INCH | mm | INCH | mm |
| -01 | .093 | 2,36 | .032 | 0,81 | .093 | 2,36 |
| -02 | .156 | 3,96 | .094 | 2,39 | .156 | 3,96 |
| -03 | .219 | 5,56 | .157 | 3,99 | .219 | 5,56 |
| -04 | .281 | 7,14 | .220 | 5,59 | .281 | 7,14 |
| -05 | .344 | 8,74 | .282 | 7,16 | .344 | 8,74 |
| -06 | .406 | 10,31 | .345 | 8,76 | .406 | 10,31 |
| -07 | .469 | 11,91 | .407 | 10,34 | .469 | 11,91 |
| -08 | .531 | 13,49 | .470 | 11,94 | .531 | 13,49 |
| -09 | .595 | 15,11 | .532 | 13,51 | .595 | 15,11 |
| -10 | .656 | 16,66 | .595 | 15,11 | .656 | 16,66 |
| -11 | .719 | 18,26 | .657 | 16,69 | .719 | 18,26 |
| -12 | .781 | 19,84 | .720 | 18,29 | .781 | 19,84 |
| -13 | .844 | 21,44 | .782 | 19,86 | .844 | 21,44 |
| -14 | .906 | 23,01 | .845 | 21,46 | .906 | 23,01 |
| -15 | .969 | 24,61 | .907 | 23,04 | .969 | 24,61 |
| -16 | 1,031 | 26,19 | .970 | 24,64 | 1,031 | 26,19 |
| -17 | 1,094 | 27,79 | 1,032 | 26,21 | 1,094 | 27,79 |
| -18 | 1,156 | 29,36 | 1,095 | 27,81 | 1,156 | 29,36 |
| -19 | 1,219 | 30,96 | 1,157 | 29,39 | 1,219 | 30,96 |
| -20 | 1,281 | 32,54 | 1,220 | 30,99 | 1,281 | 32,54 |
| -21 | 1,344 | 34,14 | 1,282 | 32,56 | 1,344 | 34,14 |
| -22 | 1,406 | 35,71 | 1,345 | 34,16 | 1,406 | 35,71 |
| -23 | 1,469 | 37,31 | 1,407 | 35,74 | 1,469 | 37,31 |
| -24 | 1,531 | 38,89 | 1,470 | 37,34 | 1,531 | 38,89 |
| -25 | 1,594 | 40,49 | 1,532 | 38,91 | 1,594 | 40,49 |
| -26 | 1,656 | 42,06 | 1,595 | 40,51 | 1,656 | 42,06 |
| -27 | 1,719 | 43,66 | 1,657 | 42,09 | 1,719 | 43,66 |
| -28 | 1,781 | 45,24 | 1,720 | 43,69 | 1,781 | 45,24 |
| -29 | 1,844 | 46,84 | 1,782 | 45,26 | 1,844 | 46,84 |
| -30 | 1,906 | 48,41 | 1,845 | 46,86 | 1,906 | 48,41 |
| -31 | 1,969 | 50,01 | 1,907 | 48,44 | 1,969 | 50,01 |
| -32 | 2,031 | 51,59 | 1,970 | 50,04 | 2,031 | 51,59 |

3423 SOUTH GARFIELD AVENUE
COMMERCE, CALIFORNIA 90040
(323) 722-4760 FAX (323) 727-1029

TITLE:
VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE TITANIUM, SELF LOCKING PROTRUDING HEX HEAD, GROUND SHANK 1/32" O/S TO PLT1087; 1/64" O/S TO PLT1088

DRAWING NO:
PLT1089 () - () - ()

DRAWN BY:
B. GEE

DRAWN DATE:
01/15/14

APPROVED BY:

CHECKED DATE:

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SHEET 2 OF 2