



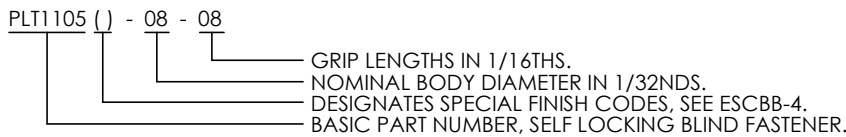
PROCUREMENT SPEC: ESCBB-9, CLASS 4.

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 & LUBRICANT: NUT: DRY FILM LUBE PER AS5272 TYPE 1 OR EVERLUBE 812 PER MIL-PRF-81329 AND/OR CETYL ALCOHOL PER AS87132, AS REQUIRED FOR PERFORMANCE.
SLEEVE: PASSIVATE PER AMS2700. DRY FILM LUBE PER AS5272 TYPE I OR EVERLUBE 812 PER MIL-PRF-81329, WWM CARBO-WAX, PARAFFIN WAX, AND/OR CETYL ALCOHOL PER AS87132, AS REQUIRED FOR PERFORMANCE.
SCREW: DRY FILM LUBE PER AS5272 TYPE 1 OR EVERLUBE 812 PER MIL-PRF-81329, WWM CARBO-WAX, PARAFFIN WAX, AND/OR CETYL ALCOHOL PER AS87132. 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. 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.
 - 4. 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). SHANK DIAMETER IN AREA OF LOCKING INDENTS SHALL NOT EXCEED THE MAXIMUM "D" DIAMETER PLUS .001.
 - 5. MANUFACTURER'S IDENTIFICATION: LETTER "N" DESIGNATES MONOGRAM/AEROSPACE FASTENERS. LETTERS "VS" DESIGNATE VOI-SHAN.
 - 6. HEAD MARKINGS ON NUT DEPRESSED .010" MAX.
 - 7. HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.
- EXAMPLE: PLT1105-06-4.5 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". THE BASIC "G" DIMENSION WILL BE NOMINAL GRIP +.031" AND THE OVERALL SCREW LENGTH "L" DIMENSION MAY VARY AT MANUFACTURER'S OPTION.
- 8. THESE PARTS HAVE A CLOSE TOLERANCE (.0005 INCH) GROUND SHANK AND ARE INTENDED FOR UP TO .0035 INCH DIAMETRAL INTERFERENCE FIT APPLICATIONS.
 - 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 MAXIMUM "D" + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS.
 - 10. OUTSIDE DIAMETER OF NUT TO CONFORM TO "D" DIAMETER EXCLUDING LUBRICATION.
 - 11. GRIP "G" IS MEASURED TO THE THEORETICAL INTERSECTION ON THE NUT NOSE ANGLE AND "D" NUT SHANK OUTER DIAMETER.



TITLE: VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE TITANIUM 100° FLUSH TENSION HEAD, SELF LOCKING 75 KSI SHEAR, GROUND SHANK

DRAWING NO: PLT1105()-()-()

DRAWN BY: B. GEE DRAWN DATE: 02/17/14

APPROVED BY: CHECKED DATE:

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Alcoa CAGE CODE: 5M902

MONOGRAM CAGE CODE: 98524

DCN NO: 14-0759 DCN DATE: 11/13/14

REV: F SHEET 2 OF 2