



CUSTODIAN: ENGINEERING STANDARD COMMITTEE FOR BLIND BOLTS
 3423 SOUTH GARFIELD AVENUE
 LOS ANGELES, CALIFORNIA 90040

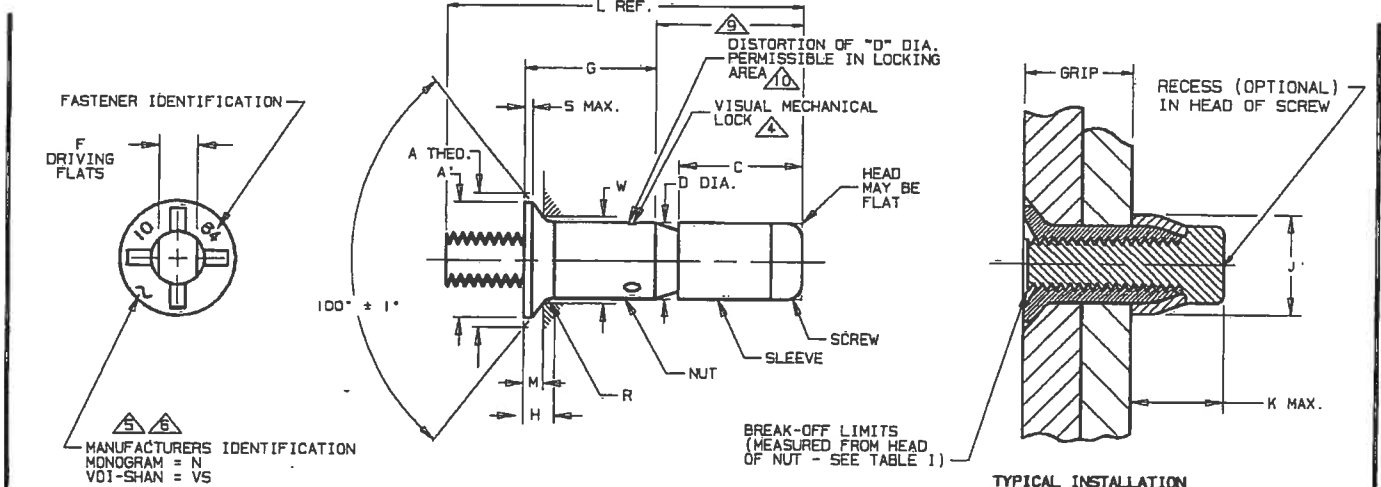


TABLE I

TYPICAL INSTALLATION

PART NUMBER	NOM. DIA.	A THEO. DIA.	A' DIA. MIN.	C MAX.	D DIA.	F DRIVING FLATS	H REF.	J DIA. MAX.	K MAX.	M GAGE PROT.	R RAD.	S MAX.	W GAGE DIA.	HOLE SIZE	BREAK-OFF LIMITS	PREVAILING TORQUE IN. LBS. MIN.	DOUBLE SHEAR STRENGTH LBS. MIN.	TENSILE STRENGTH LBS. MIN.
PLT1064SA-5-(*)	.179	.2612 .2564	.241	.315	.180 .178	.086 .081	.033	.244	.300	.0178 .0153	.030 .010	.012	.2195 .2193	.183 .180	+.088 -.000	1.0	3150	750
PLT1064SA-6-(*)	.214	.3018 .2966	.270	.350	.215 .213	.104 .099	.036	.300	.333	.0246 .0218	.030 .015	.015	.2440 .2438	.218 .215	+.088 -.000	1.5	4600	1250
PLT1064SA-8-(*)	.275	.3948 .3898	.363	.395	.276 .274	.135 .130	.040	.384	.366	.0271 .0242	.030 .015	.015	.3314 .3312	.279 .276	+.098 -.000	2.5	7900	1900
PLT1064SA-10-(*)	.326	.4739 .4689	.442	.470	.327 .325	.152 .147	.061	.427	.447	.0296 .0266	.040 .020	.015	.4047 .4045	.330 .327	+.103 -.000	3.5	11350	3250
PLT1064SA-12-(*)	.389	.5604 .5554	.529	.555	.390 .388	.185 .185	.071	.516	.527	.0321 .0290	.040 .020	.015	.4854 .4852	.393 .390	+.103 -.000	4.0	16450	5050

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

TABLE II

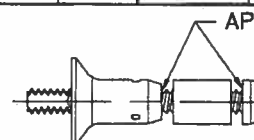
SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF.					SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF.				
		MIN.	MAX.	PLT1064SA							MIN.	MAX.	PLT1064SA				
				-5-(*)	-6-(*)	-8-(*)	-10-(*)	-12-(*)					-5-(*)	-6-(*)	-8-(*)	-10-(*)	-12-(*)
-	-	-	-	-	-	-	-	-	-17	1.094	1.032	1.094	NOT AVAILABLE	1.791	1.819	1.971	2.054
-2	.156	.094	.156	.733	.853	-	-	-	-18	1.156	1.095	1.156		1.853	1.881	2.033	2.117
-3	.219	.157	.219	.795	.916	.944	1.096	1.180	-19	1.219	1.157	1.219		1.916	1.944	2.096	2.179
-4	.281	.220	.281	.858	.978	1.006	1.158	1.242	-20	1.281	1.220	1.281	1.978	2.006	2.158	2.242	
-5	.344	.282	.344	.920	1.041	1.069	1.221	1.304	-21	1.344	1.282	1.344	2.041	2.069	2.221	2.304	
-6	.406	.345	.406	.983	1.103	1.131	1.283	1.367	-22	1.406	1.345	1.406	2.103	2.131	2.283	2.367	
-7	.469	.407	.469	1.045	1.166	1.194	1.346	1.429	-23	1.469	1.407	1.469	2.166	2.194	2.346	2.429	
-8	.531	.470	.531	1.108	1.228	1.256	1.408	1.492	-24	1.531	1.470	1.531	2.228	2.256	2.408	2.492	
-9	.594	.532	.594	1.170	1.291	1.319	1.471	1.554	-25	1.594	1.532	1.594	2.291	2.319	2.471	2.554	
-10	.656	.595	.656	1.233	1.353	1.381	1.533	1.617	-26	1.656	1.595	1.656	2.353	2.381	2.533	2.617	
-11	.719	.657	.719	1.295	1.416	1.444	1.596	1.679	-27	1.719	1.657	1.719	2.416	2.444	2.596	2.679	
-12	.781	.720	.781	1.358	1.478	1.506	1.658	1.742	-28	1.781	1.720	1.781	2.478	2.506	2.658	2.742	
-13	.844	.782	.844	1.420	1.541	1.569	1.721	1.804	-29	1.844	1.782	1.844	2.541	2.569	2.721	2.804	
-14	.906	.845	.906	1.483	1.603	1.631	1.783	1.867	-30	1.906	1.845	1.906	2.603	2.631	2.783	2.867	
-15	.969	.907	.969	1.545	1.666	1.694	1.846	1.929	-31	1.969	1.907	1.969	2.666	2.694	2.846	2.929	
-16	1.031	.970	1.031	1.608	1.728	1.756	1.908	1.992	-32	2.031	1.970	2.031	2.728	2.756	2.908	2.992	

*G TOLERANCES: FOR -5 & -6 SIZES +.030/- .010; FOR -8 & -10 SIZES +.040/- .010; FOR -12 SIZE +.050/- .010.

APPLY SEALANT HERE

Fairchild
 CODE IDENT. NO.
92215

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



MONOGRAM
 CODE IDENT. NO.
98524

APPROVED DATE
 06 AUGUST 1986

REV. LETTER AND DATE
 © 05-16-94

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TITLE
VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE TITANIUM, 75 KSI SHEAR 100° REDUCED FLUSH HEAD, SELF LOCKING 1/64 OVERSIZE FOR SEALANT APPLICATION

STANDARD
PLT1064SA
 SHEET 1 OF 2



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PROCUREMENT SPEC.: ESCBB-9, CLASS I, EXCEPT AS NOTED HEREIN. $\triangle 9$

MATERIAL: NUT & SCREW: 6AL-4V TITANIUM PER AMS492B OR AMS4967.
 SLEEVE: CORROSION RESISTANT STEEL.

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

$\triangle 1$ FINISH: NUT & SCREW: NONE, IF REQUIRED FOR FASTENER FUNCTION, THESE COMPONENTS MAY BE COATED WITH DRY FILM LUBE PER MIL-L-46010 OR EVERLUBE 812 PER MIL-L-81329.
 SLEEVE: PASSIVATE PER QQ-P-35 (MIL-S-5002) AND DRY FILM LUBE PER MIL-L-46010 OR EVERLUBE 812 PER MIL-L-81329.

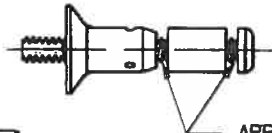
$\triangle 1$ LUBRICANT: NO ADDITIONAL LUBRICANTS ARE ALLOWED. (SEE FINISH). $\triangle 9$

PART CODE & EXAMPLE: PLT1064SA - B - B

GRIP LENGTHS IN 1/16THS (SEE TABLE II).
 NOMINAL BODY DIAMETER AS TABULATED
 BASIC PART NUMBER, SELF LOCKING BLIND FASTENER.
 FOR SEALANT APPLICATIONS.

- GENERAL NOTES:
- 1.) OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT BE GREATER THAN MAXIMUM "D" DIAMETER.
 - 2.) CONCENTRICITY OF NUT HEAD "A" DIAMETER TO "D" DIAMETER SHALL BE WITHIN .005 T.I.R. EXCEPT OVER INDENTS.
 - 3.) REMOVE ALL LOOSE OR HANGING BURRS.
 - $\triangle 4$) 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).
 - $\triangle 5$) MANUFACTURER'S IDENTIFICATION:
 LETTER "N" DESIGNATES MONOGRAM AEROSPACE FASTENERS.
 LETTERS "VS" DESIGNATE VOI-SHAN.
 - $\triangle 6$) HEAD MARKINGS ON NUT DEPRESSED .010 MAX. LOCATION OPTIONAL.
 - $\triangle 7$) HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBER.
 EXAMPLE: PLT1064SA-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.
 - $\triangle 8$) 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.
 - $\triangle 9$) TEST SPECIMENS USED TO GENERATE THE "QUALITY CONFORMANCE INSPECTION" RESULTS MAY BE LUBRICATED OR SEALANT COATED.
 - $\triangle 10$) 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 "D" MAX. + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS.
 - $\triangle 11$) STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.
 - $\triangle 12$) 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.
 13. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.

THESE PARTS ARE SUPPLIED IN PARTIALLY DISASSEMBLED CONDITION TO ALLOW APPLICATION OF SEALANT ON THE EXPOSED SCREW THREADS.
 DO NOT USE WITHOUT SEALANT.



APPLY SEALANT PRI422 B-2 PER MIL-S-8802
 OR MIL-S-22473, GRADE A, RETAINING
 COMPOUND PER ST3M7B1 IN THIS AREA.

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

Fairchild
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 92215

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