



PART NUMBER	NOM DIA.	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.
PLT1006-05-(-)	.179	.332 .325	.296	.293	.180 .178	.086 .081	.063	.244	.272	.0276 .0238	.030 .010	.012	.2671 .2667	.183 .180	+0.020 -0.068	1.0	2700	820
PLT1006-06-(-)	.214	.385 .378	.342	.328	.215 .213	.104 .099	.070	.300	.312	.0299 .0259	.030 .015	.015	.3147 .3143	.218 .215	+0.015 -0.078	1.5	4530	1400
PLT1006-08-(-)	.275	.507 .499	.463	.379	.276 .274	.135 .130	.096	.384	.351	.0353 .0307	.030 .015	.015	.4245 .4241	.279 .276	+0.010 -0.088	2.5	7200	2100
PLT1006-10-(-)	.326	.635 .626	.577	.448	.327 .325	.152 .147	.128	.427	.426	.0409 .0357	.040 .020	.020	.5389 .5385	.330 .327	+0.010 -0.093	3.5	10350	3600
PLT1006-12-(-)	.389	.762 .752	.696	.535	.390 .388	.185 .180	.154	.516	.495	.0466 .0407	.040 .020	.023	.6532 .6528	.393 .390	+0.010 -0.093	4.0	15750	5600

SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF.				
		MIN	MAX	PLT1006				
				-05-(-)	-06-(-)	-08-(-)	-10-(-)	-12-(-)
-	-	-	-	-	-	-	-	-
-02	.156	.094	.156	.733	.853	-	-	-
-03	.219	.157	.219	.795	.916	.944	-	-
-04	.281	.220	.281	.858	.978	1.006	1.158	1.242
-05	.344	.282	.344	.920	1.041	1.069	1.221	1.304
-06	.406	.345	.406	.983	1.103	1.131	1.283	1.367
-07	.469	.407	.469	1.045	1.166	1.194	1.346	1.429
-08	.531	.470	.531	1.108	1.228	1.256	1.408	1.492
-09	.594	.532	.594	1.170	1.291	1.319	1.471	1.554
-10	.656	.595	.656	1.233	1.353	1.381	1.533	1.617
-11	.719	.657	.719	1.295	1.416	1.444	1.596	1.679
-12	.781	.720	.781	1.358	1.478	1.506	1.658	1.742
-13	.844	.782	.844	1.420	1.541	1.569	1.721	1.804
-14	.906	.845	.906	1.483	1.603	1.631	1.783	1.867
-15	.969	.907	.969	1.545	1.666	1.694	1.846	1.929
-16	1.031	.970	1.031	1.608	1.728	1.756	1.908	1.992

SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF.				
		MIN	MAX	PLT1006				
				-05-(-)	-06-(-)	-08-(-)	-10-(-)	-12-(-)
-17	1.094	1.032	1.094	1.791	1.819	1.971	2.054	
-18	1.156	1.095	1.156	1.853	1.881	2.033	2.117	
-19	1.219	1.157	1.219	1.916	1.944	2.096	2.179	
-20	1.281	1.220	1.281	1.978	2.006	2.158	2.242	
-21	1.344	1.282	1.344	2.041	2.069	2.221	2.304	
-22	1.406	1.345	1.406	2.103	2.131	2.283	2.367	
-23	1.469	1.407	1.469	2.166	2.194	2.346	2.429	
-24	1.531	1.470	1.531	2.228	2.256	2.408	2.492	
-25	1.594	1.532	1.594	2.291	2.319	2.471	2.554	
-26	1.656	1.595	1.656	2.353	2.381	2.533	2.617	
-27	1.719	1.657	1.719	2.416	2.444	2.596	2.679	
-28	1.781	1.720	1.781	2.478	2.506	2.658	2.742	
-29	1.844	1.782	1.844	2.541	2.569	2.721	2.804	
-30	1.906	1.845	1.906	2.603	2.631	2.783	2.867	
-31	1.969	1.907	1.969	2.666	2.694	2.846	2.929	
-32	2.031	1.970	2.031	2.728	2.756	2.908	2.992	

▲ "G" TOLERANCE: FOR -05 AND -06 SIZES +.030/-0.010; FOR -08 & -10 SIZES +.040/-0.010; FOR -12 SIZES +.050/-0.010.



TITLE:
VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE HIGH TEMPERATURE (A286 ALLOY) 100° FLUSH HEAD, SELF LOCKING REDUCED BREAKOFF, 1/64" OVERSIZE

DRAWING NO:
PLT1006-(-)(-)

DRAWN BY: **G.MARTINEZ** DRAWN DATE: **07-26-13**

APPROVED BY: CHECKED DATE:

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 CAGE CODE:
5M902

MONOGRAM
 CAGE CODE:
98524

ECN NO:
14-0697
 ECN DATE:
11/06/14

REV:
J
SHEET 1 OF 2



PROCUREMENT SPEC: ESCBB-2 CLASS II. EXCEPT AS SPECIFIED HEREIN.

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

HEAT TREAT: NUT & SCREW: SOLUTION HEAT TREATED AND AGED TO A CORE HARDNESS OF HRC 30-45. ALL CORE HARDNESS READINGS ARE TAKEN ON MOUNTED SPECIMEN, USING A BRALE PENETRATOR AND 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.
8 DRY FILM LUBE PER AS5272 TYPE I OR MIL-PRF-81329, WWM CARBO-WAX, PARAFFIN WAX AND OR CETYL ALCOHOL PER AS87132.

PART CODE & EXAMPLE: PLT1006 - 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.
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).
5. MANUFACTURER'S IDENTIFICATION: LETTER "N" DESIGNATES MONOGRAM AEROSPACE FASTENERS. LETTERS "VS" DESIGNATE VOI-SHAN.
6. HEAD MARKINGS ON NUT DEPRESSED .010" MAX.
7. THE PRODUCT DESCRIBED BY THIS DRAWING IS "EQUIVALENT TO" AND "INTERCHANGEABLE WITH" THE MANUFACTURER'S PRODUCT LISTED BELOW EXCEPT THE HEAD IDENTIFICATION MARKINGS AND SELF-LOCKING FEATURE. EXISTING STOCK MAY BE REWORKED TO INCORPORATE THE LOCK. WHEN THESE REWORKED FASTENERS ARE SUPPLIED, THE HEAD IDENTIFICATION MAY BE AS SHOWN BELOW:
MONOGRAM....: F164A-F375A SERIES (MARKING: "N" AND "O" OVERSTAMPED "L" OR "SL").
VOI-SHAN....: BCAFL SERIES (MARKING: "VS", "O", AND "L" OR "SL").
8. STANDARD FINISHES AND LUBES ARE SHOWN ABOVE. REFER TO ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBES, IF REQUIRED.
9. HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.
EXAMPLE: PLT1006-06-4.5 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.
10. 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.
11. 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" MAX + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS.
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.



TITLE: VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE HIGH TEMPERATURE (A286 ALLOY) 100° FLUSH HEAD, SELF LOCKING REDUCED BREAKOFF, 1/64" OVERSIZE

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 SHEET 2 OF 2