**Title:** VISU-LOK, FASTENER, BLIND 
**Internally Threaded, External Sleeve Aluminum Nut Promoting Domed Head, Self-Locking 1/64" Oversize

**Drawing No.:** PLT1007-(-)(-)

**Manufacturer's Identification:** MONOGRAM = N
VOI-SHAN = VS

**Dimensions:**

- **Max. Grip:** +0.10" (+0,254 mm) Ref.
- **Distortion of "D" Dia. Permissible In Locking Area

**Typical Installation**

<table>
<thead>
<tr>
<th>PART NUMBER</th>
<th>NOM.</th>
<th>A</th>
<th>B RADIUS</th>
<th>C</th>
<th>D</th>
<th>F DRIVING FLATS</th>
<th>H</th>
<th>J</th>
<th>K</th>
</tr>
</thead>
<tbody>
<tr>
<td>PLT1007-06-( )</td>
<td>.214</td>
<td>.544</td>
<td>.346</td>
<td>.879</td>
<td>.186</td>
<td>.473</td>
<td>.328</td>
<td>.833</td>
<td>.215</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>PART NUMBER</th>
<th>M</th>
<th>R RAD.</th>
<th>T FLAT REF.</th>
<th>HOLE SIZE</th>
<th>BREAK-OFF LIMITS</th>
<th>PREVAILING TORQUE MIN.</th>
<th>DOUBLE SHEAR STRENGTH MIN.</th>
<th>TENSILE STRENGTH MIN.</th>
</tr>
</thead>
<tbody>
<tr>
<td>PLT1007-06-( )</td>
<td>.030</td>
<td>.076</td>
<td>.025</td>
<td>.015</td>
<td>.64</td>
<td>.38</td>
<td>.156</td>
<td>.396</td>
</tr>
</tbody>
</table>

**Second Dash Number:**

- **G GRIP:** MIN. MAX. MIN. MAX. -.06(-)
  - **GRIP RANGE:** MIN. MAX. MIN. MAX. .06(-)
  - **L REF.:** INCH mm INCH mm INCH mm INCH mm INCH mm
  - **-02:** .156 | 3.96 | .094 | 2.36 | .156 | 3.96 | .936 | 23.77
  - **-03:** .219 | 5.56 | .157 | 3.99 | .219 | 5.56 | .999 | 25.37
  - **-04:** .281 | 7.14 | .220 | 5.59 | .281 | 7.14 | 1.061 | 26.95
  - **-05:** .344 | 8.74 | .282 | 7.16 | .344 | 8.74 | 1.124 | 28.55
  - **-06:** .406 | 10.31 | .345 | 8.76 | .406 | 10.31 | 1.86 | 30.12
  - **-07:** .469 | 11.91 | .407 | 10.34 | .469 | 11.91 | 1.249 | 31.72
  - **-08:** .531 | 13.49 | .470 | 11.94 | .531 | 13.49 | 1.311 | 33.30
  - **-09:** .594 | 15.09 | .532 | 13.51 | .594 | 15.09 | 1.374 | 34.90
  - **-10:** .656 | 16.66 | .595 | 15.11 | .656 | 16.66 | 1.436 | 36.47
  - **-11:** .719 | 18.26 | .657 | 16.69 | .719 | 18.26 | 1.499 | 38.07
  - **-12:** .781 | 19.84 | .720 | 18.29 | .781 | 19.84 | 1.561 | 39.65

**G" Tolerance:** -0.06 SIZES +.030"/.010" (+0.762/-0.254)
PROCUREMENT SPEC: ESCBB-2 CLASS 3, EXCEPT AS SPECIFIED HEREIN.

MATERIAL:
- SCREW: ALLOY STEEL 4130 PER AMS-S-6758, 4140 PER AMS6382 OR AMS6349 OR 8740 PER AMS6322.
- SLEEVE: CORROSION RESISTANT STEEL: 303 OR 304 PER AMS-QQ-S-763, AMS5639 OR AMS5641.

HEAT TREAT:
- NUT: NONE.
- SCREW: HEAT TREAT PER AMS2759, APPROXIMATELY 180,000 TO 200,000 PSI TENSILE (HRC 39-43).
- AS REQUIRED FOR PERFORMANCE.

FINISH:
- NUT: ANODIZE PER MIL-A-8625, TYPE II, CLEAR.
- SCREW: HEAT TREAT PER AMS2759, APPROXIMATELY 180,000 TO 200,000 PSI TENSILE (HRC 39-43).
- SLEEVE: PASSIVATE PER AMS2700. CADMIUM PLATE PER AMS-QQ-P-416, TYPE I, CLASS 3.

LUBRICANT:
- NUT: WWM CARBO-WAX, CETYL ALCOHOL PER AS87132, AND/OR PARAFFIN WAX.
- SCREW & SLEEVE: DRY FILM LUBE PER AS5272 OR MIL-PRF-81329, WWM CARBO-WAX, PARAFFIN WAX, AND OR CETYL ALCOHOL PER AS87132.

PART CODE & EXAMPLE: PLT1007 - 06 - 06

GRIP LENGTHS IN 1/16THS
NOMINAL BODY DIAMETER AS TABULATED
BASIC PART NUMBER, 1/64" OVERSIZE, SELF-LOCKING BLIND FASTENER

GENERAL NOTES:
1. TAPERED END OF NUT SHALL NOT FALL WITHIN MAXIMUM GRIP.
2. REMOVE ALL LOOSE OR HANGING BURRS.
3. OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT EXCEED MAXIMUM "D" DIAMETER.
4. BEARING SURFACE OF HEAD OF NUT SHALL BE AT RIGHT ANGLE TO THE SHANK WITHIN 1/2".
5. TEMPERATURE LIMITATION: 250°F MAX.


STANDARD FINISHES AND LUBES ARE SHOWN ABOVE. REFER TO ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBES, IF REQUIRED.

MANUFACTURER'S IDENTIFICATION: (OPTIONAL)
LETTER "N" DESIGNATES MONOGRAM AEROSPACE FASTENERS.
LETTERS "VS" DESIGNATE VOI-SHAN.

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 + .002", FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS (22.23 NEWTONS).

HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.

EXAMPLE: PLT1007-06-4.5 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" (±0.79/-0.79mm).
THE BASIC "G" DIMENSION WILL BE MAXIMUM GRIP + .031" (±0.79) AND THE OVERALL SCREW LENGTH "L" DIMENSION MAY VARY AT MANUFACTURER'S OPTION.

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.

12. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.
13. HEAD MARKINGS DEPRESSED .010" (0.254 mm MAX.), POSITION OPTIONAL.