**MONOGRAM AEROSPACE FASTENERS**

**DRAWING NO:** PLT1017(-)(-)(-)

**TITLE:** VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE HIGH TEMPERATURE (A-286 ALLOY) PROTRUDING HEAD, SELF LOCKING HIGH SHEAR STRENGTH

**DRAWN BY:** B. GEE
**DRAWN DATE:** 09/27/13
**APPROVED BY:**
**CHECKED DATE:**

**MANUFACTURER'S IDENTIFICATION MONOGRAM = "N" VOS-SHAM = "VS"

**INDICATES SELF-LOCKING F DRIVING FLATS**

**DISTORTION OF 'D' AXIS PERMISSIBLE IN LOCKING AREA**

**ALLOY IDENTIFICATION "T" INDICATES HIGH STRENGTH A-286 ALLOY**

**ALLOY IDENTIFICATION**

**HIGH SHEAR STRENGTH**

**HIGH TEMPERATURE (A-286 ALLOY)**

**TYPICAL INSTALLATION**

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### Table: PLT1017

| SECOND DASH NUMBER | G | GRIP RANGE | PLT1017 | | SECOND DASH NUMBER | G | GRIP RANGE | PLT1017 |
|---------------------|---|------------|---------| |---------------------|---|------------|---------|
| 2.5 4170 2100 .354 |   |            |         | |                     |   |           |         |
| 11 .152 .260 +.103 |   |            |         | |                     |   |           |         |
|  .088 +.000 1.0 1625 820 |   |            |         | |                     |   |           |         |
| 4.0 8220 5600 .268 .312 .030 |   |            |         | |                     |   |           |         |
| 3.5 4170 2100 .354 |   |            |         | |                     |   |           |         |
| 11 .152 .260 +.103 |   |            |         | |                     |   |           |         |
| 4.0 8220 5600 .268 .312 .030 |   |            |         | |                     |   |           |         |

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**NOT AVAILABLE IN -05 DIAMETER**

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**"G" TOLERANCE: FOR -05 AND -06 SIZES +.030/-,.010; FOR -08 & -10 SIZES +.040/-,.010; FOR -12 SIZE +.050/-,.010.**
PROCUREMENT SPEC: ESCBB-2 CLASS 2, EXCEPT AS SPECIFIED HEREIN.

MATERIAL:
NUT, SCREW & SLEEVE: CORROSION AND HEAT RESISTANT STEEL, TYPE A-286 PER AMS5731, AMS5732 OR AMS5737.

HEAT TREAT:
NUT & SCREW: SOLUTION HEAT TREATED AND AGED TO A CORE HARDENNESS 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:
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:
PLT1017()-( )-( )

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:
1. OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT EXCEED MAXIMUM "D" DIAMETER.
2. REMOVE ALL LOOSE OR HANGING BURRS.
4. THE PREVAILING TORQUE SHALL CONFORM TO THE VALUES AS TABULATED, WHEN TESTED IN ACCORDANCE WITH SPECIFICATION ESCBB-2. HOWEVER, PREVAILING TORQUES FOR THE PLT1017-05-01 AND PLT1017-06-01 SHALL BE RECORDED THRU A ROTATION OF ONLY 360° OF THE NUT.
5. MANUFACTURER'S IDENTIFICATION:
LETTER "N" DESIGNATES MONOGRAM AEROSPACE FASTENERS.
LETTERS "VS" DESIGNATE VOI-SHAN.
6. HEAD MARKINGS ON NUT DEPRESSED .010" MAX, LOCATION OPTIONAL.
7. STANDARD FINISHES AND LUBES ARE SHOWN ABOVE. REFER TO ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBES, IF REQUIRED.
8. HEAD OF NUT TO BE COLORED YELLOW.
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. HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.

EXAMPLE: PLT1017-06-4.5 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.
11. 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.