

PART NUMBER	NOM DIA.		A THEO DIA.		A' DIA. MIN.		C MAX.		D DIA.		F DRIVING FLATS		H REF.		J DIA. MAX.		K MAX.		L REF.		R RAD.	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
PLT1028-06(-)	.2290	5,817	.385 .378	9,78 9,60	.342	8,69	.360	9,14	.2300 .2280	5,84 5,79	.104 .099	2,64 2,52	.063	1,70	.315	8,00	.333	8,46	.673	17,1	.050 .045	1,27 1,14
PLT1028-08(-)	.2900	7,866	.507 .499	12,88 12,67	.463	11,76	.404	10,26	.2910 .2890	7,39 7,34	.135 .130	3,43 3,30	.087	2,21	.401	10,19	.366	9,30	.691	17,5	.060 .055	1,52 1,40
PLT1028-10(-)	.3415	8,674	.635 .626	16,13 15,90	.577	14,66	.493	12,52	.3425 .3405	8,70 8,65	.152 .147	3,86 3,73	.118	3,00	.442	11,23	.447	11,35	.908	23,1	.070 .060	1,78 1,52
PLT1028-12(-)	.4045	10,273	.762 .752	19,35 19,10	.696	17,68	.583	14,80	.4055 .4035	10,30 10,25	.185 .180	4,70 4,57	.144	3,66	.531	13,49	.527	13,39	.980	24,9	.070 .060	1,78 1,52

PART NUMBER	S MAX.		V GAGE PROT.		W GAGE DIA.		BREAK-OFF LIMITS		MINIMUM AVAILABLE GRIP LENGTH	HOLE SIZE		PREVAILING TORQUE MIN.		DOUBLE SHEAR STRENGTH MIN.		TENSILE STRENGTH MIN.	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm		INCH	mm	IN-LBS	Nm	LBS.	N	LBS.	N
PLT1028-06(-)	.015	0,38	.0250 .0190	0,635 0,483	.3272 0,311	8,311 8,306	+0,15 -0,73	+0,38 -1,85	-02	.233 .230	5,92 5,84	1.5	0,170	6900	30700	2100	9340
PLT1028-08(-)	.015	0,38	.0327 .0263	0,830 0,668	.4320 0,4318	10,973 10,968	+0,10 -0,78	+0,25 -1,98	-03	.294 .291	7,47 7,39	2.5	0,282	11800	52500	3650	16240
PLT1028-10(-)	.020	0,51	.0390 .0320	0,991 0,813	.5451 0,5449	13,845 13,840	+0,10 -0,83	+0,25 -2,11	-04	.346 .343	8,79 8,71	3.5	0,400	17000	75620	5200	23130
PLT1028-12(-)	.023	0,58	.0452 .0378	1,148 0,960	.6582 0,6580	16,718 16,713	+0,10 -0,93	+0,25 -2,36	-04	.409 .406	10,39 10,32	4.0	0,452	24500	109000	7500	33360

▲ "G" TOLERANCE: FOR -06 SIZES +.030/-010; FOR -08 & -10 SIZES +.040/-010; FOR -12 SIZES +.050/-010.



PROCUREMENT SPEC: ESCBB-10 / MIL-F-81177, TYPE II, EXCEPT AS SPECIFIED HEREIN.

MATERIAL:

NUT & SCREW: 5% CHROME STEEL (H-11) PER AMS6487.

SLEEVE: INCONEL X-750 PER AMS5667 OR AMS5582; OR A-286 PER AMS5731, AMS5732 OR AMS5737.

HEAT TREAT:

NUT & SCREW: ROCKWELL "C" 48-53.

SLEEVE: AS REQUIRED FOR PERFORMANCE.

FINISH: $\triangle 10$

"L" NUT & SCREW: CADMIUM PLATE PER NAS672 (.0003 MIN. THICKNESS) EXCEPT THERMAL INDICATOR MAY BE OMITTED. SUPPLEMENTARY CHROMATE TREATMENT PER AMS-QQ-P-416 AFTER BAKE.

SLEEVE: PASSIVATE PER AMS2700. CADMIUM PLATE PER AMS-QQ-P-416, TYPE 1, CLASS 3.

"L" NUT: ALUMINUM COAT PER NAS4006.

SLEEVE: PASSIVATE PER AMS2700 AND ALUMINUM COAT PER NAS4006.

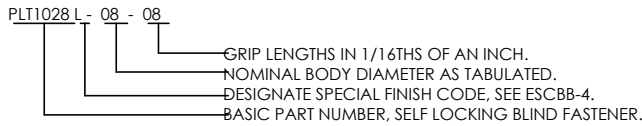
SCREW: CADMIUM PLATE PER NAS672 (.0003 MIN. THICKNESS) EXCEPT THERMAL INDICATOR MAY BE OMITTED. SUPPLEMENTARY CHROMATE TREATMENT PER AMS-QQ-P-416 AFTER BAKE.

LUBRICANT: LUBRICANTS LISTED BELOW MAY BE APPLIED TO ANY OR ALL COMPONENTS IF REQUIRED FOR PERFORMANCE:



DRY FILM LUBE PER AS5272 TYPE 1 OR EVERLUBE 812 PER MIL-PRF-81329, PARAFFIN WAX, CETYL ALCOHOL PER AS87132. AND/OR WWM CARBO-WAX.

PART CODE & EXAMPLE:



GENERAL NOTES:

- $\triangle 1$ OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NO BE GREATER THAN MAXIMUM "D" DIAMETER.
2. CONCENTRICITY OF NUT HEAD CONICAL SURFACE TO "D" DIAMETER SHALL BE WITHIN 0.005" (0.13 mm) T.I.R., EXCEPT OVER INDENTATIONS.
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" (1.02 mm) 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 ALCOA.
6. HEAD MARKINGS ON NUT DESPRESSED .010" MAXIMUM.
- $\triangle 7$ HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.
EXAMPLE: PLT1028-06-4.5 INDICATES A NOMINAL GRIP LENGTH OF 4.5 SIXTEENTHS (.281 = 7.14mm).
THE GRIP RANGE FOR THESE HALF-GRIP SIZES WILL BE NOMINAL GRIP +.031/- .030 (+0.79/-0.79mm).
THE BASIC "G" DIMENSION WILL BE NOMINAL GRIP +.031 (+0.79) AND THE OVERALL SCREW LENGTH "L" DIMENSION MAY VARY AT MANUFACTURER'S OPTION.
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 AND PREVAILING TORQUES DO NOT APPLY.
- $\triangle 9$ 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" MAX + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS (22.23 NEWTONS).
- $\triangle 10$ STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.
11. 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.
12. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.

SECOND DASH NUMBER	G GRIP		GRIP RANGE			
	INCH	mm	INCH	mm	INCH	mm
-01	.093	2,36	.032	0,81	.093	2,36
-02	.156	3,96	.094	2,39	.156	3,96
-03	.219	5,56	.157	3,99	.219	5,56
-04	.281	7,14	.220	5,59	.281	7,14
-05	.344	8,74	.282	7,16	.344	8,74
-06	.406	10,31	.345	8,76	.406	10,31
-07	.469	11,91	.407	10,34	.469	11,91
-08	.531	13,49	.470	11,94	.531	13,49
-09	.595	15,11	.532	13,51	.595	15,11
-10	.656	16,66	.595	15,11	.656	16,66
-11	.719	18,26	.657	16,69	.719	18,26
-12	.781	19,84	.720	18,29	.781	19,84
-13	.844	21,44	.782	19,86	.844	21,44
-14	.906	23,01	.845	21,46	.906	23,01
-15	.969	24,61	.907	23,04	.969	24,61
-16	1.031	26,19	.970	24,64	1.031	26,19
-17	1.094	27,79	1.032	26,21	1.094	27,79
-18	1.156	29,36	1.095	27,81	1.156	29,36
-19	1.219	30,96	1.157	29,39	1.219	30,97
-20	1.281	32,54	1.220	30,99	1.281	32,54
-21	1.344	34,14	1.282	32,56	1.344	34,14
-22	1.406	35,71	1.345	34,16	1.406	35,71
-23	1.469	37,31	1.407	35,74	1.469	37,31
-24	1.531	38,89	1.470	37,34	1.531	38,89
-25	1.594	40,49	1.532	38,91	1.594	40,49
-26	1.656	42,06	1.595	40,51	1.656	42,06
-27	1.719	43,66	1.657	42,09	1.719	43,66
-28	1.781	45,24	1.720	43,69	1.781	45,24
-29	1.844	46,84	1.782	45,26	1.844	46,84
-30	1.906	48,41	1.845	46,86	1.906	48,41
-31	1.969	50,01	1.907	48,44	1.969	50,01
-32	2.031	51,59	1.970	50,04	2.031	51,59

3423 SOUTH GARFIELD AVENUE
COMMERCE, CALIFORNIA 90040
(323) 722-4760 FAX (323) 727-1029

TITLE: VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE HIGH STRENGTH, 5% CHROME STEEL (H-11) 100° FLUSH HEAD, SELF LOCKING

1/32" O/S TO PLT150; 1/64" O/S TO PLT151

DRAWING NO: PLT1028()-()-()	
DRAWN BY: B. GEE	DRAWN DATE: 10/01/13
APPROVED BY:	CHECKED DATE:

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Alcoa CAGE CODE: 5M902	MONOGRAM CAGE CODE: 98524	DCN NO: 14-0712 DCN DATE: 11/08/14	REV: P SHEET 2 OF 2
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