

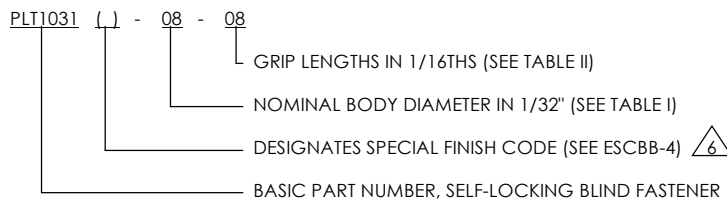
TABLE I

PART NUMBER	ϕ NOM		ϕA		ϕB		(C)		ϕD		F WRENCH FLATS		H		ϕJ MAX		K MAX		R. R		R. S MIN		Z	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
PLT1031-05-()	.1635	4.153	.448	11.38	.286	7.26	.267	6.78	.1645	4.178	.086	2.18	.046	1.17	.244	6.20	.246	6.25	.030	0.76	.005	0.13	.010	0.25
PLT1031-06-()	.1980	5.029	.448	11.38	.333	8.46	.302	7.67	.1990	5.055	.104	2.64	.053	1.35	.300	7.62	.281	7.14	.030	0.76	.005	0.13	.010	0.25
PLT1031-08-()	.2590	6.579	.510	12.95	.430	10.92	.342	8.69	.2600	6.604	.135	3.43	.068	1.73	.384	9.75	.325	8.26	.030	0.76	.005	0.13	.010	0.25

TABLE I (CONTINUED)

PART NUMBER	BREAK-OFF LIMITS		MINIMUM AVAILABLE GRIP LENGTH (TABLE II)	HOLE SIZE		PREVAILING TORQUE MIN		DOUBLE SHEAR STRENGTH MIN		TENSILE STRENGTH MIN	
	INCH	mm		INCH	mm	IN-LBS	Nm	LBS	N	LBS	N
PLT1031-05-()	+0.088	+2.23	-02	.168	4.27	1.0	0.113	3150	14010	900	4000
	+0.000	+0.00		.165	4.19						
PLT1031-06-()	+0.098	+2.49	-02	.202	5.13	1.5	0.169	4600	20460	1400	6230
	+0.010	+0.25		.199	5.05						
PLT1031-08-()	+0.135	+3.43	-03	.263	6.68	2.5	0.282	7900	35140	2100	9340
	+0.047	+1.19		.260	6.60						

EXAMPLE PART NUMBER:



TITLE:

VISU-LOK®, FASTENER, BLIND,
 LOW PROFILE PROTRUDING HEAD,
 NOMINAL DIAMETER, SELF-LOCKING,
 TITANIUM ALLOY, 75 KSI SHEAR STRENGTH

DRAWING NO:

PLT1031 () - () - ()

DRAWN BY:

A PEREZ

DRAWN DATE:

03/19/2014

APPROVED BY:

CHECKED DATE:



APPLICABLE SPECIFICATIONS:
PROCUREMENT SPECIFICATION: ESCBB-9, EXCEPT AS NOTED HEREIN.

7 9 11

MATERIAL:
NUT AND SCREW: 6AL-6V-2Sn TITANIUM ALLOY PER AMS-T-9047 OR
SLEEVE: 6AL-4V TITANIUM ALLOY PER AMS4928 OR AMS4967.
CRES.

HEAT TREAT:
NUT AND SCREW: HEAT TREAT PER AMS-H-81200.
SLEEVE: AS REQUIRED FOR PERFORMANCE.

6 **FINISH:**
NO CODE ():

NUT AND SCREW: NONE.
SLEEVE: PASSIVATE PER AMS2700.

"L" CODE:

NUT: ALUMINUM COAT PER NAS4006.
SCREW: NONE.
SLEEVE: PASSIVATE PER AMS2700 AND ALUMINUM COAT
PER NAS4006.

6 **LUBRICATION:**

SOLID DRY FILM LUBRICANT PER THE CHEMICAL
REQUIREMENTS OF AS5272 TYPE I OR EVERLUBE 812
PER MIL-PRF-81329, PARAFFIN WAX AND/OR CETYL
ALCOHOL PER AS87132 MAY BE APPLIED TO ANY
OR ALL COMPONENTS AS REQUIRED FOR
PERFORMANCE. (SEE ESCBB-4 FOR SPECIAL
LUBRICANTS AND FINISHES).

2ND DASH NO.	GRIP RANGE				(L)					
	MIN		MAX		-05		-06		-08	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
-02	.094	2.39	.156	3.96	.733	18.62	.853	21.67	-	-
-03	.157	3.99	.219	5.56	.795	20.19	.916	23.27	.944	23.98
-04	.220	5.59	.281	7.14	.858	21.79	.978	24.84	1.006	25.55
-05	.282	7.16	.344	8.74	.920	23.37	1.041	26.44	1.069	27.15
-06	.345	8.76	.406	10.31	.983	24.97	1.103	28.02	1.131	28.73
-07	.407	10.34	.469	11.91	1.045	26.54	1.166	29.62	1.194	30.33
-08	.470	11.94	.531	13.49	1.108	28.14	1.228	31.19	1.256	31.90
-09	.532	13.51	.594	15.09	1.170	29.72	1.291	32.79	1.319	33.50
-10	.595	15.11	.656	16.66	1.233	31.32	1.353	34.37	1.381	35.08
-11	.657	16.69	.719	18.26	1.295	32.89	1.416	35.97	1.444	36.68
-12	.720	18.29	.781	19.84	1.358	34.49	1.478	37.54	1.506	38.25
-13	.782	19.86	.844	21.44	1.420	36.07	1.541	39.14	1.569	39.85
-14	.845	21.46	.906	23.01	1.483	37.67	1.603	40.72	1.631	41.43
-15	.907	23.04	.969	24.61	1.545	39.24	1.666	42.32	1.694	43.03
-16	.970	24.64	1.031	26.19	1.608	40.84	1.728	43.89	1.756	44.60
-17	1.032	26.21	1.094	27.79			1.791	45.49	1.819	46.20
-18	1.095	27.81	1.156	29.36			1.853	47.07	1.881	47.78
-19	1.157	29.39	1.219	30.96			1.916	48.67	1.944	49.38
-20	1.220	30.99	1.281	32.54			1.978	50.24	2.006	50.95
-21	1.282	32.56	1.344	34.14			2.041	51.84	2.069	52.55
-22	1.345	34.16	1.406	35.71			2.103	53.42	2.131	54.13
-23	1.407	35.74	1.469	37.31			2.166	55.02	2.194	55.73
-24	1.470	37.34	1.531	38.89			2.228	56.59	2.256	57.30
-25	1.532	38.91	1.594	40.49			2.291	58.19	2.319	58.90
-26	1.595	40.51	1.656	42.06			2.353	59.77	2.381	60.48
-27	1.657	42.09	1.719	43.66			2.416	61.37	2.444	62.08
-28	1.720	43.69	1.781	45.24			2.478	62.94	2.506	63.65
-29	1.782	45.26	1.844	46.84			2.541	64.54	2.569	65.25
-30	1.845	46.86	1.906	48.41			2.603	66.12	2.631	66.83
-31	1.907	48.44	1.969	50.01			2.666	67.72	2.694	68.43
-32	1.970	50.04	2.031	51.59			2.728	69.29	2.756	70.00

- GENERAL NOTES:**
1. OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT BE GREATER THAN MAXIMUM " ØD".
 2. RUNOUT OF NUT HEAD " ØA" TO " ØD" SHALL BE WITHIN .005 T.I.R. [0,13 mm], EXCEPT OVER INDENTS.
 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" [1,02 mm] ABOVE THE INTERSECTION OF THE NUT NOSE ANGLE AND O.D. (MEAN GRIP OF FASTENER).
 5. HEAD MARKINGS ON NUT DEPRESSED .010 INCH [0,254 mm] MAXIMUM. POSITION OPTIONAL.
 6. STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.
 7. HALF GRIP SIZES MAY BE ORDERED BY ADDING ".5" TO THE GRIP DASH NUMBER. EXAMPLE: PLT1031-06-4.5 INDICATES A NOMINAL GRIP LENGTH OF 4.5 SIXTEENTHS = .281" [7,14 mm]. THE GRIP RANGE FOR THESE HALF GRIP SIZES WILL BE NOMINAL GRIP +.031/-0.030 [+0,79/-0,76 mm]. 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. DISTORTION OF " ØD" PERMISSIBLE IN LOCKING AREA. DISTORTION OF " ØD" SHALL NOT PREVENT INSERTION OF THE FASTENER INTO A RING GAUGE OF LENGTH EQUAL TO ONE DIAMETER AND DIAMETER EQUAL TO MAXIMUM " ØD" + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS [22.23 N].
 9. STANDARD GRIP LENGTHS ARE SHOWN IN TABLE II. SHORTER OR LONGER GRIPS, OTHER THAN THOSE LISTED, MAY BE AVAILABLE AS SPECIALS. ON GRIP LENGTHS SHORTER THAN THOSE LISTED, THE BREAK-OFF LIMITS AND PREVAILING TORQUE VALUES SHOWN IN TABLE I DO NOT APPLY.
 10. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.
 11. "GRIP MAX" TOLERANCES: FOR -05 AND -06 SIZES: +.030/-0.10 [+0,762 mm/-0,254 mm].
FOR -08 SIZE: +.040/-0.10 [+1,016 mm/-0,254 mm].



TITLE:
VISU-LOK®, FASTENER, BLIND,
LOW PROFILE PROTRUDING HEAD,
NOMINAL DIAMETER, SELF-LOCKING,
TITANIUM ALLOY, 75 KSI SHEAR STRENGTH

DRAWING NO:
PLT1031()-()-()
DRAWN BY: A PEREZ
DRAWN DATE: 03/19/2014
APPROVED BY:
CHECKED DATE:

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SHEET 2 OF 2