

PART NUMBER	NOM DIA.	A THEO DIA.	A' DIA. MIN.	C MAX.	D DIA.	F DRIVING FLATS	H REF.	J DIA. MAX.	K MAX.	R RAD.	S MAX.	V GAGE PROT.	W GAGE DIA.	BREAK-OFF LIMITS	PREVAILING TORQUE IN. LBS. MIN.	SHEAR STRENGTH LBS. MIN.	TENSILE STRENGTH LBS. MIN.
PLT1057-05-(-)	.1635	.2612 .2564	.241	.285	.1645 .1625	.086 .081	.040	.244	.257	.030 .010	.010	.0265 .0237	.1992 .1990	+0.088 -.000	1.0	2700	750
PLT1057-06-(-)	.1980	.3016 .2966	.270	.320	.1990 .1970	.104 .099	.047	.300	.288	.030 .015	.015	.0246 .0218	.2440 .2448	+0.088 -.000	1.5	4530	1250
PLT1057-08-(-)	.2590	.3948 .3898	.363	.355	.2600 .2580	.135 .130	.061	.384	.320	.030 .015	.015	.0271 .0242	.3314 .3312	+0.098 -.000	2.5	7200	1900
PLT1057-10-(-)	.3105	.4739 .4689	.442	.440	.3115 .3095	.152 .147	.068	.427	.396	.040 .020	.015	.0296 .0266	.4047 .4045	+0.103 -.000	3.5	10350	3250
PLT1057-12-(-)	.3735	.5604 .5554	.529	.525	.3745 .3725	.185 .180	.078	.516	.473	.040 .020	.015	.0321 .0290	.4854 .4852	+0.103 -.000	4.0	16450	5050

SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF.				
		MIN	MAX	PLT1057				
				-05-(-)	-06-(-)	-08-(-)	-10-(-)	-12-(-)
-	-	-	-	-	-	-	-	-
-02	.156	.094	.156	.733	.853	-	-	-
-03	.219	.157	.219	.795	.916	.944	1.096	1.180
-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	PLT1057				
				-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 REDUCED FLUSH HEAD, SELF LOCKING A-286 CRES - 1200 °F HIGH BREAK-OFF

DRAWING NO:

PLT1057(-)(-)(-)

DRAWN BY:

B. GEE

DRAWN DATE:

10/05/13

APPROVED BY:

CHECKED DATE:

PROPRIETARY AND CONFIDENTIAL:

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5M902

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CAGE CODE:

98524

DCN NO:

14-0717

DCN DATE:

11/09/14

REV:

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SHEET 1 OF 2



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: HRC 30-45.  
SLEEVE: AS REQUIRED FOR PERFORMANCE.

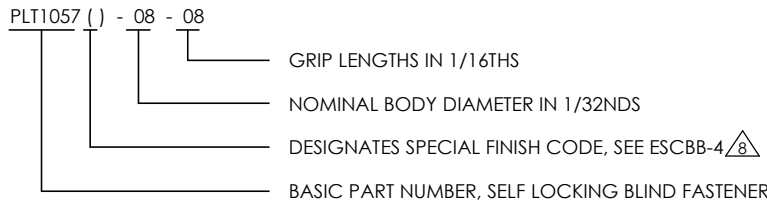
FINISH:

NUT, SCREW & SLEEVE: PASSIVATE PER AMS2700

LUBRICANT:

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 FOR PERFORMANCE.

PART CODE & EXAMPLE:



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 INDENTS).
3. REMOVE ALL LOOSE OR HANGING BURRS.
4.  $\triangle$  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.  $\triangle$  MANUFACTURER'S IDENTIFICATION:  
LETTER "N" DESIGNATES MONOGRAM AEROSPACE FASTENERS.  
LETTERS "VS" DESIGNATE FAIRCHILD.
6. HEAD MARKINGS ON NUT DEPRESSED .010" MAX.
7.  $\triangle$  HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.

EXAMPLE: PLT1057-06-4.5 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.

8.  $\triangle$  LUBRICANT CODE INDICATES SPECIAL LUBRICATION AS SPECIFIED IN ESCBB-4.

NO CODE INDICATES STANDARD LUBRICANTS SPECIFIED IN "LUBRICANT" CALLOUT ABOVE.

"B" CODE - ONLY LUBRICANT USED SHALL BE EVERLUBE 812 PER MIL-PRF-81329, GRAPHITE FREE, APPLIED TO ANY OR ALL COMPONENTS AS REQUIRED.

9.  $\triangle$  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.



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

TITLE:

VISU-LOK, FASTENER, BLIND  
INTERNALLY THREADED, EXTERNAL SLEEVE  
REDUCED FLUSH HEAD, SELF LOCKING  
A-286 CRES - 1200°F  
HIGH BREAK-OFF

DRAWING NO:

PLT1057 ( ) - ( ) - ( )

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SHEET 2 OF 2