**Title:** VISU-LOK, FASTENER, BLIND INTERIALLY THREADED, EXTERNAL SLEEVE TITANIUM, 75 KSI SHEAR 100° REDUCED FLUSH HEAD, SELF-LOCKING GROUND SHANK

**Manufacturer:** MONOGRAM AEROSPACE FASTENERS

**Drawing No.:** PLT1058GS

**Sheet:** 1 of 2

**Type:** FASTENER, BLIND INTERIALLY THREADED, EXTERNAL SLEEVE TITANIUM, 75 KSI SHEAR 100° REDUCED FLUSH HEAD, SELF-LOCKING GROUND SHANK

**Material:** TITANIUM, 75 KSI SHEAR

**Dimensions:**

1. **Grip Range:**
   - Not Available in -05 Diameter
   - -06 (.020 - .030)
   - -08 (.026 - .040)
   - -10 (.032 - .060)
   - -12 (.040 - .070)

2. **Gage Prot.:**
   - -05 (.005 - .010)
   - -06 (.006 - .012)
   - -08 (.008 - .016)
   - -10 (.010 - .020)
   - -12 (.012 - .024)

3. **Tensile Strength:**
   - 100° Reduced Flush Head
   - 58500 LBS. MIN

4. **Recommended Torque:**
   - 100° Reduced Flush Head
   - 3150 LBS. MIN

5. **Distortion of "D" Diameter Permissible in Locking Area:**
   - 2X Grip

6. **Identifications:**
   - **G** Tolerances: For -05 & -06 Sizes +.030"/-010"; For -08 & -10 Sizes +.040"/-010"; For -12 Sizes +.050/-010"

7. **Locking Mechanism:**
   - Visual Mechanical Lock

**Part Number:** PLT1058GS

**Dash:**

- -05
- -06
- -08
- -10
- -12

**Dimensions:**

- **Grub Screw:**
  - MIN: .038
  - MAX: .075

- **Head of Nut:**
  - MIN: .086
  - MAX: .125

- **TYPICAL INSTALLATION:**
  - Break-Off Limits Measured from Head of Nut

**Notes:**

- **Grub Screw Gage Prot.:**
  - MIN: .038
  - MAX: .075

- **Head of Nut Gage Prot.:**
  - MIN: .086
  - MAX: .125

- **Recommended Torque:**
  - 3150 LBS. MIN

**Other Information:**

- **Distortion of "D" Diameter Permissible in Locking Area:**
  - 2X Grip

**Additional Information:**

- **Distortion of "D" Diameter Permissible in Locking Area:**
  - 2X Grip

**Approval:**

- Approved: G.MARTINEZ

- Date: 08-16-13

**Sheet:** 1 of 2

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PROCUREMENT SPEC: ESCBB-9, CLASS 3, EXCEPT AS SPECIFIED HEREIN.

MATERIAL: NUT & SCREW: 6AL-4V TITANIUM PER AMS4928 OR AMS4967.
SLEEVE: CORROSION RESISTANT STEEL.

HEAT TREAT: NUT & SCREW: HEAT TREAT PER AMS-H-81200 MAX. HYDROGEN 125 PPM.
SLEEVE: AS REQUIRED FOR PERFORMANCE.

FINISH: NUT, SCREW: NONE.
SLEEVE: PASSIVATE PER AMS2700.

LUBRICANT: LUBRICANTS LISTED BELOW MAY BE APPLIED TO ANY OR ALL COMPONENTS IF REQUIRED FOR PERFORMANCE.
UNLESS OTHERWISE SPECIFIED BY FINISH CODE. DRY FILM LUBE PER AS5272, TYPE I, OR EVERLUBE 812 PER MIL-PRF-81329, CETYL ALCOHOL PER AS87132 OR PARAFFIN WAX.

PART CODE & EXAMPLE:
PLT1058GS ( )-05-05

GENERAL NOTES:
1. OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT EXCEED MAXIMUM "E" 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.
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. HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.
   EXAMPLE: PLT1058GS-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".
   THE BASIC "G" DIMENSION WILL BE NOMINAL GRIP +.031" AND THE OVERALL SCREW LENGTH "L" DIMENSION MAY VARY AT MANUFACTURER'S OPTION.
8. THESE PART NUMBERS HAVE A CLOSE TOLERANCE (.0005") GROUND SHANK AND ARE INTENDED FOR UP TO .0035" DIAMETRAL INTERFERENCE FIT APPLICATIONS. CONTACT MONOGRAM AEROSPACE FASTENER ENGINEER OR SALES REPRESENTATION IF EXPERIENCE FASTENER HEAD DISINTEGRATION DURING INTERFERENCE FIT INSTALLATION. GROUND SHANK VISU-LOKS WILL PERFORM SATISFACTORILY IN THE TABULATED HOLE SIZES.
9. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.
10. 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.
11. STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.
12. 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.
13. 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.