**TITLE:** VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE TITANIUM, 75 KSI SHEAR 100° REDUCED FLUSH HEAD, SELF LOCKING 1/64" OVERSIZE

**MANUFACTURER'S IDENTIFICATION** MONOROM = N VOI-SHAN = VS

**DRAWN BY:** G.MARTINEZ  **DRAWN DATE:** 08-12-13

**APPROVED BY:** G.MARTINEZ  **CHECKED DATE:** 11/09/14

**MONOROM AEROSPACE FASTENERS**
3423 SOUTH GARFIELD AVENUE, COMMERCE, CALIFORNIA 90040
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| PART NUMBER | NOM. DIA. | THEO. DIA. | A | C | D | DIA. | F | G | H | J | K | M | N | O | P | Q | R | S | T | U | V | W | X | Y | Z |
| PLT1064-05-1 | 0.179 | 0.161 | 0.206 | 0.241 | 0.315 | 0.180 | 0.178 | 0.086 | 0.081 | 0.033 | 0.244 | 0.300 | 0.0178 | 0.030 | 0.010 | 0.2195 | 0.183 | 0.030 | 0.010 | 0.2193 | 0.180 | 0.030 | 0.010 | 0.2193 | 0.180 | 0.030 | 0.010 | 0.2193 | 0.180 | 0.030 | 0.010 |
| PLT1064-06-1 | 0.214 | 0.196 | 0.231 | 0.270 | 0.360 | 0.215 | 0.213 | 0.104 | 0.099 | 0.036 | 0.300 | 0.333 | 0.0246 | 0.030 | 0.015 | 0.2448 | 0.218 | 0.030 | 0.015 | 0.2438 | 0.215 | 0.030 | 0.015 | 0.2438 | 0.215 | 0.030 | 0.015 | 0.2438 | 0.215 | 0.030 | 0.015 | 0.2438 | 0.215 | 0.030 | 0.015 |
| PLT1064-08-1 | 0.275 | 0.258 | 0.293 | 0.368 | 0.385 | 0.276 | 0.274 | 0.135 | 0.130 | 0.049 | 0.384 | 0.366 | 0.0271 | 0.030 | 0.015 | 0.3318 | 0.279 | 0.030 | 0.015 | 0.3312 | 0.276 | 0.030 | 0.015 | 0.3312 | 0.276 | 0.030 | 0.015 | 0.3312 | 0.276 | 0.030 | 0.015 | 0.3312 | 0.276 | 0.030 | 0.015 |
| PLT1064-10-1 | 0.326 | 0.309 | 0.352 | 0.442 | 0.470 | 0.327 | 0.325 | 0.152 | 0.147 | 0.061 | 0.427 | 0.447 | 0.0294 | 0.040 | 0.020 | 0.4047 | 0.330 | 0.040 | 0.020 | 0.4045 | 0.327 | 0.040 | 0.020 | 0.4045 | 0.327 | 0.040 | 0.020 | 0.4045 | 0.327 | 0.040 | 0.020 | 0.4045 | 0.327 | 0.040 | 0.020 |
| PLT1064-12-1 | 0.389 | 0.372 | 0.454 | 0.554 | 0.529 | 0.390 | 0.388 | 0.185 | 0.180 | 0.071 | 0.516 | 0.527 | 0.0330 | 0.040 | 0.020 | 0.4853 | 0.393 | 0.040 | 0.020 | 0.4852 | 0.390 | 0.040 | 0.020 | 0.4852 | 0.390 | 0.040 | 0.020 | 0.4852 | 0.390 | 0.040 | 0.020 | 0.4852 | 0.390 | 0.040 | 0.020 |

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**REV:** G  **DRAWING NO:** PLT1064-05-1  **ECN DATE:** 08-12-13

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**TABLE:**

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<thead>
<tr>
<th>SIZE</th>
<th>DIA. PERMISSIBLE DISTORTION OF &quot;D&quot;</th>
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**DIAGRAM:**

- Visual Mechanical Lock
- Distortion of "D""PREFERRED IN LOCKING AREA
- Break-off Limits (Measured from Head of Nut)
- Typical Installation

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**NOTES:**

- "G" TOLERANCE: FOR -05 AND -06 SIZES +0.030/-.010; FOR -08 & -10 SIZES +0.040/-.010; FOR -12 SIZES +0.050/-.010.
PROCUREMENT SPEC: ESCBB-9 CLASS 1, 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.
DRY FILM LUBE PER ASS272 TYPE I OR MIL-PRF-81329, WWM CARBO-WAX, PARAFFIN WAX AND OR CETYL ALCOHOL PER AS87132.

PART CODE & EXAMPLE:
PLT1064 ( ) - 05 - 05
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. CONCENTRICITY OF NUT HEAD CONICAL SURFACE TO "D" DIAMETER SHALL BE WITHIN .005" T.I.R., EXCEPT OVER INDENTATIONS.
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.
7. STANDARD FINISHES AND LUBES ARE SHOWN ABOVE. REFER TO ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBES, IF REQUIRED.
8. HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.
EXAMPLE: PLT1064-06-4.5 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.
9. 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.
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" + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS.
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.