

3423 SOUTH GARFIELD AVENUE
LOS ANGELES, CALIFORNIA 90040



MONOGRAM
AEROSPACE
FASTENERS

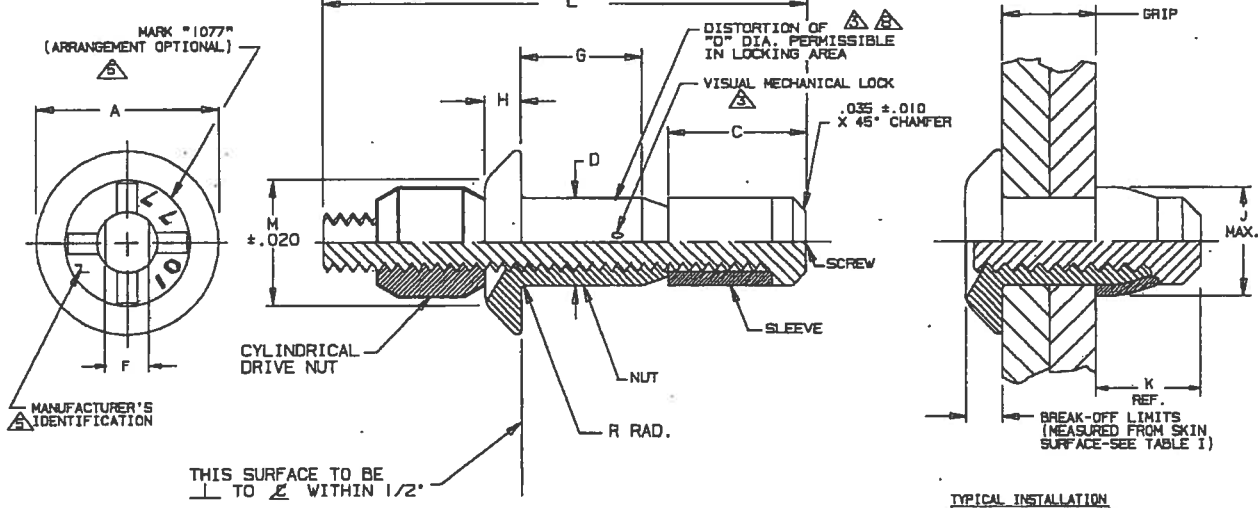


TABLE I

PART NUMBER	NOM. DIA.	A THEO. DIA.	C MAX.	D DIA.	F DRIVING FLATS	H	J DIA. MAX.	K REF.	H	R RAD.	RECOMMENDED HOLE SIZE	BREAK-OFF LIMITS	PREVAILING TORQUE IN. LBS. MIN.	DOUBLE SHEAR STRENGTH LBS. MIN.	TENSILE STRENGTH LBS. MIN.
PLT 1077-B-(*)B	.2580	.416 .396	.354	.2500 .2580	.135 .130	.063 .053	.384	.325	.380 .340	.025 .015	.264 .261	+.053 -.035	2.5	9000	2100

(*) SEE TABLE II FOR SECOND DASH NUMBER AND APPROVED CALLOUT.

TABLE II

SECOND DASH NUMBER	G GRIP +.040/- .010	GRIP RANGE		L REF.	
		MIN.	MAX.	PLT 1077-B-(*)B	
-	-	-	-	-	-
-3	.202	.162	.202	1.466	
-4	.244	.203	.244	1.506	
-5	.285	.245	.285	1.544	
-6	.320	.280	.320	1.582	
-7	.447	.407	.447	1.715	

U.S. PATENT NO. 3643544, OTHER PATENTS PENDING.

MONOGRAM
CODE IDENT. NO.
95524

APPROVED DATE
ECN #6139 11-14-89

REV. LETTER AND DATE
B 02-07-92

TITLE
VISU-LOK, FASTENER, BLIND
INTERNALLY THREADED, EXTERNAL SLEEVE
ALLOY STEEL
DOMED HEAD, SELF-LOCKING, CYLINDRICAL DRIVE NUT

STANDARD
PLT 1077-()-()B
SHEET 1 OF 2

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PROCUREMENT SPEC. : NAS 1675, CLASS I, EXCEPT HEAD STYLE, GRIP RANGE AND BREAK-OFF LIMITS.

MATERIAL : NUT & SCREW : ALLOY STEEL: 4130 PER MIL-S-675B, 4140 PER MIL-S-5626 or 8740 PER MIL-S-6049.
SLEEVE : CORROSION RESISTANT STEEL: 303 or 304 PER QQ-S-763, AMS 5639 or AMS 5641.
DRIVE NUT : MILD STEEL.

HEAT TREAT : NUT & SCREW : HEAT TREAT PER MIL-H-6875 TO Rc 39-43.

SLEEVE : AS REQUIRED FOR PERFORMANCE.

DRIVE NUT : AS REQUIRED FOR PERFORMANCE.

△ FINISH : NUT & SCREW : CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2. CADMIUM PLATE PER NAS 672 IS PERMISSIBLE PROVIDED IT IS FOLLOWED BY A DICHROMATE POST TREATMENT PER QQ-P-416.

SLEEVE : PASSIVATE PER MIL-S-5002. CADMIUM PLATE PER QQ-P-416, TYPE I, CLASS 3.

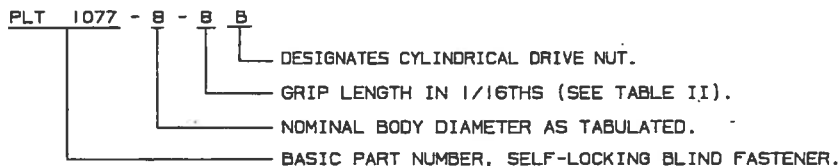
DRIVE NUT : CORROSION RESISTANT COATING, COLOR BLACK.

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

NUT : WWM CARBO-WAX, PARAFFIN WAX, AND/OR CETYL ALCOHOL PER MIL-L-87132.

SCREW & SLEEVE : DRY FILM LUBE PER MIL-L-46010 TYPE I OR EVERLUBE 812 PER MIL-L-81329, WWM-CARBO-WAX, PARAFFIN WAX, OR CETYL ALCOHOL PER MIL-L-87132.

PART CODE
& EXAMPLE :



GENERAL NOTES :

- 1.) OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT BE GREATER THAN MAXIMUM "D" DIAMETER.
- 2.) REMOVE ALL LOOSE OR HANGING BURRS.
- 3.) 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).
- 4.) THE PREVAILING TORQUE SHALL CONFORM TO THE VALUES AS TABULATED, WHEN TESTED IN ACCORDANCE WITH SPECIFICATION NAS 1675.
- 5.) MANUFACTURER'S IDENTIFICATION:
LETTER "N" DESIGNATES MONOGRAM/AEROSPACE FASTENERS.
PART MARKING: "1077".
- 6.) HEAD MARKINGS ON NUT DEPRESSED .010 MAX.
- 7.) STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESC8B-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.
- 8.) MUST ENTER A .2610 HOLE WITH FINGER PRESSURE.

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MONOGRAM
CODE IDENT. NO.
98524

STANDARD

PLT 1077-()-()B

SHEET 2 OF 2

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