

TYPICAL INSTALLATION

PART NUMBER	A THEO DIA.	A' DIA. MIN.	C MAX.	D DIA.		E DIA. MAX.	F DRIVING FLATS	H REF.	J DIA. MAX.	K MAX.	M GAGE PROT.	R RAD.	S MAX.	W GAGE DIA.	HOLE SIZE	BREAK-OFF LIMITS	PREVAILING TORQUE IN. LBS. MIN	DOUBLE SHEAR STRENGTH LBS. MIN	TENSILE STRENGTH LBS. MIN
				BARE	ALUM. COATED														
PLT1080-05-( )	.2612 .2564	.241	.285	.1680 .1675	.1680 .1670	.1645	.086 .081	.038	.244	.257	.0265 .0237	.030 .010	.010	.1992 .1990	.1720 .1690	+088 -000	1.0	3150	750
PLT1080-06-( )	.3016 .2966	.270	.320	.2025 .2020	.2025 .2015	.1990	.104 .099	.041	.300	.288	.0246 .0218	.030 .015	.015	.2440 .2438	.2065 .2035	+088 -000	1.5	4600	1250
PLT1080-08-( )	.3948 .3898	.363	.355	.2635 .2630	.2635 .2625	.2600	.135 .130	.054	.384	.320	.0271 .0242	.030 .015	.015	.3314 .3312	.2675 .2645	+098 -000	2.5	7900	1900
PLT1080-10-( )	.4739 .4689	.442	.440	.3150 .3145	.3150 .3140	.3115	.152 .147	.066	.427	.396	.0296 .0266	.040 .020	.015	.4047 .4045	.3190 .3160	+103 -000	3.5	11350	3250
PLT1080-12-( )	.5604 .5554	.529	.525	.3780 .3775	.3780 .3770	.3745	.185 .180	.076	.516	.473	.0321 .0290	.040 .020	.015	.4854 .4852	.3820 .3790	+103 -000	4.0	16450	5050

SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF.				
		MIN	MAX	PLT1080				
				-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	PLT1080				
				-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"/-.010"; FOR -08 & -10 SIZES +.040"/-.010"; FOR -12 SIZES +.050"/-.010".



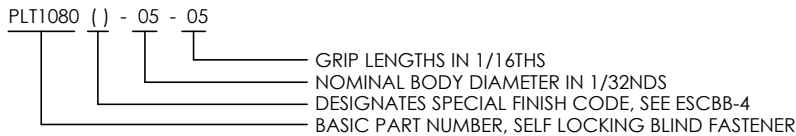
PROCUREMENT SPEC: ESCBB-9 CLASS 3.

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

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

FINISH & LUBRICANT:  $\triangle 13$  NUT: DRY FILM LUBE PER AS5272 TYPE I OR EVERLUBE 812 PER MIL-PRF-81329. CETYL ALCOHOL PER AS87132, OPTIONAL.  
 SLEEVE: PASSIVATE PER AMS2700. DRY FILM LUBE PER AS5272 TYPE I OR EVERLUBE 812 PER MIL-PRF-81329, WWM CARBO-WAX, PARAFFIN WAX, AND/OR CETYL ALCOHOL PER AS87132, AT MANUFACTURER'S OPTION.  
 SCREW: DRY FILM LUBE PER AS5272 TYPE I OR EVERLUBE 812 PER MIL-PRF-81329, WWM CARBO-WAX, PARAFFIN WAX, AND/OR CETYL ALCOHOL PER AS87132, AT MANUFACTURER'S OPTION.

PART CODE & EXAMPLE:



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 INDENTATIONS.
3. REMOVE ALL LOOSE OR HANGING BURRS.
- $\triangle 4$ . 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). SHANK DIAMETER IN AREA OF LOCKING INDENTS SHALL NOT EXCEED THE MAXIMUM "D" DIAMETER PLUS .001".
- $\triangle 5$ . MANUFACTURER'S IDENTIFICATION:  
 LETTER "N" DESIGNATES MONOGRAM AEROSPACE FASTENERS.  
 LETTERS "VS" DESIGNATE VOI-SHAN.
6. HEAD MARKINGS ON NUT DEPRESSED .010" MAX.
- $\triangle 7$ . HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.  
 EXAMPLE: PLT1080-06-4.5 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 PARTS HAVE A CLOSE TOLERANCE (.0005") GROUND SHANK AND ARE INTENDED FOR UP TO .0035" DIAMETRAL INTERFERENCE FIT APPLICATIONS.
- $\triangle 9$ . 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.
10. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.
- $\triangle 11$ . 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", "M", "W" AND HEAD ANGLE DIMENSIONS.
- $\triangle 12$ . 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.
- $\triangle 13$ . STANDARD FINISHES AND LUBES ARE SHOWN ABOVE. REFER TO ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBES, IF REQUIRED.
- $\triangle 14$ . MAXIMUM "D" DIAMETER MAY BE INCREASED BY .0002" TO ALLOW FOR ALUMINUM COATING APPLICATION.

**MONOGRAM AEROSPACE FASTENERS**  
 a TriMas company  
 3423 SOUTH GARFIELD AVENUE  
 COMMERCE, CALIFORNIA 90040  
 (323) 722-4760 FAX (323) 727-1029

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

DRAWING NO: <b>PLT1080( )-( )-( )</b>	
DRAWN BY: <b>G.MARTINEZ</b>	DRAWN DATE: <b>08-13-13</b>
APPROVED BY:	CHECKED DATE:
<b>Alcoa</b> CAGE CODE: <b>5M902</b>	<b>MONOGRAM</b> CAGE CODE: <b>98524</b>
ECN NO: <b>14-0735</b>	REV: <b>K</b>
ECN DATE: <b>11/10/14</b>	<b>SHEET 2 OF 2</b>

**PROPRIETARY AND CONFIDENTIAL:**  
 NOTICE: THIS DRAWING IS PART OF THE PROPRIETARY ARTICLE HEREIN DISCLOSED, OWNED BY MONOGRAM AEROSPACE FASTENERS. ANY PARTY BY ACCEPTING THIS DOCUMENT ASSUME CUSTODY THEREOF AND AGREES:  
 A: THE INFORMATION SET FORTH HEREIN IS GIVEN IN CONFIDENCE AND THIS DOCUMENT WILL NOT BE COPIED OR REPRODUCED IN WHOLE OR IN PART, NOR ITS CONTENTS REVEALED IN ANY MANNER TO ANY PERSON EXCEPT TO MEET THE PURPOSE FOR WHICH IT WAS DELIVERED.  
 B: WITHOUT THE WRITTEN CONSENT OF MONOGRAM AEROSPACE FASTENERS, THIS DOCUMENT AND THE INFORMATION CONTAINED HEREIN UNDER NO CIRCUMSTANCES WILL BE USED IN THE MANUFACTURE OR REPRODUCTION OF THE ARTICLE DISCLOSED, AND THE DELIVERY OF THIS DOCUMENT SHALL NOT CONSTITUTE ANY RIGHT OR LICENSE TO DO SO.