

TYPICAL INSTALLATION

PART NUMBER	A HEX FLATS	C MAX.	D DIA. 12		1 E DIA. MAX.	F DRIVING FLATS	H MAX.	J DIA. MAX.	K MAX.	N MIN.	R RAD.	9 BREAK-OFF LIMITS	9 PREVAILING TORQUE IN. LBS. MIN.	DOUBLE SHEAR STRENGTH LBS. MIN.	TENSILE STRENGTH LBS. MIN.
			BARE	ALUMINUM COATED											
PLT1088-05(-)	.250 .244	.315	.1835 .1830	.1835 .1825	.1800	.086 .081	.096	.244	.300	.272	.020 .010	+088 +000	1.0	3150	900
PLT1088-06(-)	.312 .305	.350	.2185 .2180	.2185 .2175	.2150	.104 .099	.113	.300	.333	.340	.025 .015	+098 +010	1.5	4600	1400
PLT1088-08(-)	.375 .367	.385	.2795 .2790	.2795 .2785	.2760	.135 .130	.135	.384	.366	.409	.025 .015	+135 +047	2.5	7900	2100
PLT1088-10(-)	.437 .429	.470	.3305 .3300	.3305 .3295	.3270	.152 .147	.160	.427	.447	.479	.030 .015	+146 +043	3.5	11350	3600
PLT1088-12(-)	.500 .491	.555	.3935 .3930	.3935 .3925	.3900	.185 .180	.190	.516	.527	.548	.030 .015	+152 +049	4.0	16450	5600

SECOND DASH NUMBER	G GRIP	6 9 GRIP RANGE		L REF. PLT1088				
		MIN	MAX	-05(-)	-06(-)	-08(-)	-10(-)	-12(-)
-01	.093	.031	.093	.733	.874	-	-	-
-02	.156	.094	.156	.795	.936	1.006	1.158	-
-03	.219	.157	.219	.858	.999	1.069	1.221	1.367
-04	.281	.220	.281	.920	1.061	1.131	1.283	1.429
-05	.344	.282	.344	.983	1.124	1.194	1.346	1.492
-06	.406	.345	.406	1.045	1.186	1.256	1.408	1.554
-07	.469	.407	.469	1.108	1.249	1.319	1.471	1.617
-08	.531	.470	.531	1.170	1.311	1.381	1.533	1.679
-09	.594	.532	.594	1.233	1.374	1.444	1.596	1.742
-10	.656	.595	.656	1.295	1.436	1.506	1.658	1.804
-11	.719	.657	.719	1.358	1.499	1.569	1.721	1.867
-12	.781	.720	.781	1.420	1.561	1.631	1.783	1.929
-13	.844	.782	.844	1.483	1.624	1.694	1.846	1.992
-14	.906	.845	.906	1.545	1.686	1.756	1.908	2.054
-15	.969	.907	.969	1.608	1.749	1.819	1.971	2.117
-16	1.031	.970	1.031	1.670	1.811	1.881	2.033	2.179

SECOND DASH NUMBER	G GRIP	6 9 GRIP RANGE		L REF. PLT1088				
		MIN	MAX	-05(-)	-06(-)	-08(-)	-10(-)	-12(-)
-17	1.094	1.032	1.094		1.874	1.944	2.096	2.242
-18	1.156	1.095	1.156		1.936	2.006	2.158	2.304
-19	1.219	1.157	1.219		1.999	2.069	2.221	2.367
-20	1.281	1.220	1.281		2.061	2.131	2.283	2.429
-21	1.344	1.282	1.344		2.124	2.194	2.346	2.492
-22	1.406	1.345	1.406		2.186	2.256	2.408	2.554
-23	1.469	1.407	1.469		2.249	2.319	2.471	2.617
-24	1.531	1.470	1.531		2.311	2.381	2.533	2.679
-25	1.594	1.532	1.594		2.374	2.444	2.596	2.742
-26	1.656	1.595	1.656		2.436	2.506	2.658	2.804
-27	1.719	1.657	1.719		2.499	2.569	2.721	2.867
-28	1.781	1.720	1.781		2.561	2.631	2.783	2.929
-29	1.844	1.782	1.844		2.624	2.694	2.846	2.992
-30	1.906	1.845	1.906		2.686	2.756	2.908	3.054
-31	1.969	1.907	1.969		2.749	2.819	2.971	3.117
-32	2.031	1.970	2.031		2.811	2.881	3.033	3.179

▲ "G" TOLERANCE: FOR -05 AND -06 SIZES +.030/-010; FOR -08 & -10 SIZES +.040/-010; FOR -12 SIZES +.050/-010.

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, 75 KSI SHEAR PROTRUDING HEX HEAD, SELF LOCKING GROUND SHANK, 1/64" OVERSIZE

DRAWING NO:

PLT1088(-)(-)(-)

DRAWN BY: B. GEE

DRAWN DATE: 01/09/14

APPROVED BY:

CHECKED DATE:

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ECN NO: 14-0744

ECN DATE: 11/11/14

REV: L

SHEET 1 OF 2



PROCUREMENT SPEC: ESCBB-9, CLASS 2, 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. MAX.
SLEEVE: AS REQUIRED FOR PERFORMANCE.

FINISH:

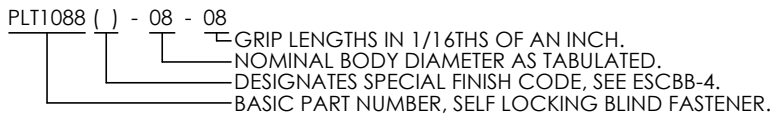
" - " NUT & SCREW: NONE. (SEE ESCBB-4 FOR SPECIAL LUBRICANTS AND FINISHES).
SLEEVE: PASSIVATE PER AMS2700.

" L " NUT: ALUMINUM COAT PER NAS4006.
SLEEVE: PASSIVATE PER AMS2700 AND ALUMINUM COAT PER NAS4006.
SCREW: NONE.

LUBRICANT:

NUT: DRY FILM LUBRICANT PER AS5272 TYPE I OR EVERLUBE 812 PER MIL-PRF-81329. CETYL ALCOHOL PER AS87132, OPTIONAL.
SCREW & SLEEVE: DRY FILM LUBE PER AS5272 TYPE I OR EVERLUBE 812 PER MIL-PRF-81329, PARAFFIN WAX AND/OR CETYL ALCOHOL PER AS87132 MAY BE APPLIED AS REQUIRED FOR PERFORMANCE.

PART CODE & EXAMPLE:



GENERAL NOTES:

- 1. OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT BE GREATER THAN MAXIMUM "E" 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" (1.02 mm) ABOVE THE INTERSECTION OF THE NUT NOSE ANGLE AND O.D. (MEAN GRIP OF FASTENER).
4. MANUFACTURER'S IDENTIFICATION: LETTER "N" DESIGNATES MONOGRAM AEROSPACE FASTENERS. LETTERS "VS" DESIGNATE VOI-SHAN.
5. HEAD MARKINGS ON NUT DESPRESSED .010" MAXIMUM. LOCATION OPTIONAL.
6. HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.
EXAMPLE: PLT1088-06-4.5 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.
7. THESE PARTS HAVE A CLOSE TOLERANCE (.0005 INCHES) GROUND SHANK AND ARE INTENDED FOR UP TO .0035 INCH DIFFERENTIAL INTERFERENCE FIT APPLICATIONS.
8. STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.
9. STANDARD GRIP LENGTHS ARE SHOWN AS TABULATED, SHORTER OR LONGER GRIPS THAN THOSE LISTED MAY BE AVAILABLE AS SPECIALS. ON GRIP LENGTHS SHORTER THAN THOSE LISTED, THE BREAKOFF AND PREVAILING TORQUES 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 "D" MAX + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS (22.23 NEWTONS). HEAD MARKINGS ON NUT DESPRESSED .010" MAXIMUM.
11. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.
12. MAXIMUM "D" DIAMETER MAY BE INCREASED BY .002 TO ALLOW FOR ALUMINUM COATING APPLICATION.



TITLE: VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE TITANIUM, 75 KSI SHEAR PROTRUDING HEX HEAD, SELF LOCKING GROUND SHANK, 1/64" OVERSIZE

Table with drawing information: DRAWING NO: PLT1088( )-( )-( ), DRAWN BY: B. GEE, DRAWN DATE: 01/09/14, APPROVED BY, CHECKED DATE.

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