### Manufacturing's Identification
Monogram = N
Voi-Shan = VS

### General Information
- **Material:** 98524
- **Head:** 100° Reduced flush head, self-locking ground Shank, 1/64" oversize
- **Nominal Diameter:** PLT1093-05-( ) - PLT1093-12-( )
- **THD Dia. Min.:** .214
- **DIA. Min.:** .214
- **C. Max.:** .214
- **D. Dia. Min.:** .214
- **E. Dia. Min.:** .179
- **FLATS 32°:** .233
- **FLATS 32°:** .233
- **2°:** .233
- **2°:** .233
- **2°:** .233
- **D. Dia. Max.:** .233
- **TH Ref.:** .384
- **J. Dia. Max.:** .384
- **K. Max.:** .384
- **M. Gage Prot.:** .384
- **R. Rad.:** .384
- **S. Max.:** .384
- **W. Gage Dia.:** .384
- **Break-off Limits Measured from Head of Nut:** .384
- **Prevaliding Torque In. Lbs. Min:** .384
- **Double Shear Strength Lbs. Min:** .384
- **Tensile Strength Lbs. Min:** .384
- **PLT1093-05-( )**
- **PLT1093-06-( )**
- **PLT1093-08-( )**
- **PLT1093-10-( )**
- **PLT1093-12-( )**

### Chart
<table>
<thead>
<tr>
<th>Diameter</th>
<th>MIN</th>
<th>MAX</th>
</tr>
</thead>
<tbody>
<tr>
<td>.02</td>
<td>.015</td>
<td>.030</td>
</tr>
<tr>
<td>.03</td>
<td>.015</td>
<td>.030</td>
</tr>
<tr>
<td>.034</td>
<td>.009</td>
<td>.039</td>
</tr>
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<td>.0324</td>
<td>.015</td>
<td>.040</td>
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<tr>
<td>.0312</td>
<td>.015</td>
<td>.040</td>
</tr>
<tr>
<td>.03016</td>
<td>.015</td>
<td>.040</td>
</tr>
<tr>
<td>.0290</td>
<td>.015</td>
<td>.040</td>
</tr>
</tbody>
</table>

### Notes
- **G** Tolerance: FOR -05 AND -06 SIZES +.030/-30; FOR -08 AND -10 SIZES +.040/.010; FOR -12 SIZES +.050/- .010.
- **Torque:**...
- **Visual Mechanical Lock:**...
- **Double Shear Strength Lbs. Min:**...
- **Tensile Strength Lbs. Min:**...

### Diagram
- **Visual:**...
- **Mechanical:**...
- **Lock:**...
- **Distortion of "D" Dia. Permissible in Locking Area:**...
- **Typical Installation:**...
PROCUREMENT SPEC: ESCBB-2, CLASS I EXCEPT AS SPECIFIED HEREIN

MATERIAL:
NUT & SCREW: ALLOY STEEL: 4130 PER AMS-S-6758, 4140 PER AMS6382 OR 8740 PER AMS6322.
SLEEVE: CORROSION RESISTANT STEEL: 303 OR 304 PER AMS-QQ-S-763, AMS5639 OR AMS5641.

HEAT TREAT:
NUT & SCREW: HEAT TREAT PER AMS2759 TO HRC 39-46.
SLEEVE: AS REQUIRED FOR PERFORMANCE.

FINISH:
NUT & SCREW: CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS I EXCEPT AS SPECIFIED HEREIN.
SLEEVE: PASSIVATE PER AMS2700. CADMIUM PLATE PER AMS-QQ-P-416, TYPE I, CLASS 3.

LUBRICANT: LUBRICANTS LISTED BELOW MAY BE APPLIED TO ANY OR ALL COMPONENTS IF REQUIRED FOR FASTENER PERFORMANCE:
NUT: WMM CARBO-WAX, PARAFFIN WAX, AND/OR CETYL ALCOHOL PER MIL-L-87132.
SCREW & SLEEVE: DRY FILM LUBE PER AS87132.

PART CODE & EXAMPLE:
PLT1093 - 08 - 08
GRIP LENGTHS IN 1/16THS.
NOMINAL BODY DIAMETER AS TABULATED.
BASIC PART NUMBER, 1/64" OVERSIZE SELF-LOCKING BLIND FASTENER.

GENERAL NOTES:
1. CONCENTRICITY OF NUT HEAD CONICAL SURFACE TO "D" DIAMETER SHALL BE WITHIN .005 T.I.R. (EXCEPT OVER INDENTS).
2. REMOVE ALL LOOSE OR HANGING BURRS.
4. MANUFACTURER'S IDENTIFICATION:
LETTER "N" DESIGNATES MONOGRAM/AEROSPACE FASTENERS.
LETTERS "VS" DESIGNATE VOI-SHAN.
PART MARKING: "1093"
5. HEAD MARKINGS ON NUT DEPRESSED .010 MAX. LOCATION OPTIONAL.
6. STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.
7. HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.
EXAMPLE: PLT1093-06-4.5 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. 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.
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" + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS.
10. 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.
11. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.

MONOGRAM AEROSPACE FASTENERS
3423 SOUTH GARFIELD AVENUE
COMMERCE, CALIFORNIA 90040
(323) 722-4763  FAX (323) 727-1029

Alcoa CAGE CODE: SM902
MONOGRAM CAGE CODE: 98524

Drawing No: PLT1093-( )-( )
Drawn by: B. GEE 12/10/13
Rev: H

Title: VISU-LOK, FASTENER, BLIND
INTERNALLY THREADED, EXTERNAL SLEEVE
ALLOY STEEL
100° REDUCED FLUSH HEAD, SELF-LOCKING
GROUND SHANK, 1/64" OVERSIZE

Drawing Date: 11/12/14
Sheet 2 of 2