**FASTENER IDENTIFICATION**

MANUFACTURER'S IDENTIFICATION: MONOGRAM = N
ALCOA = VS

**SPECIAL LUBE/FINISH IDENTIFICATION** (SEE ESCB84)

**TITLE:** VISU-LOK, FASTENER, BLIND
INTERNALLY THREADED, EXTERNAL SLEEVE
ALLOY STEEL, SELF LOCKING
100° FLUSH SHEAR HEAD
GROUND SHANK, 1/32" OVERSIZE

**DRAWING NO.:** PLT1094-( )-( )

**DRAWN BY:** B. GEE
**DRAWN DATE:** 12/11/13

**CHECKED DATE:** 12/8/14

**SHEET:** 1 OF 2

**REV.:** J

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### Table 1

<table>
<thead>
<tr>
<th>PART NUMBER</th>
<th>A' THEO. DIA.</th>
<th>A' DIA. MIN.</th>
<th>C MAX.</th>
<th>D MAX.</th>
<th>DIA.</th>
<th>E MAX.</th>
<th>FLATS</th>
<th>H REF.</th>
<th>J MAX.</th>
<th>K MAX.</th>
<th>E REF.</th>
<th>R RAD.</th>
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<tbody>
<tr>
<td>PLT1094-06-1</td>
<td>.343</td>
<td>.336</td>
<td>.311</td>
<td>.308</td>
<td>.305</td>
<td>.302</td>
<td>.300</td>
<td>.298</td>
<td>.296</td>
<td>.294</td>
<td>.292</td>
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<tr>
<td>PLT1094-08-1</td>
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<td>.333</td>
<td>.309</td>
<td>.305</td>
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<td>.327</td>
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### Table 2

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<thead>
<tr>
<th>PART NUMBER</th>
<th>S MAX.</th>
<th>V GAGE PROT.</th>
<th>W GAGE DIA.</th>
<th>BREAK-OFF LIMITS</th>
<th>MINIMUM AVAILABLE GRIP LENGTH</th>
<th>HOLE SIZE</th>
<th>PREVAILING TORQUE MIN.</th>
<th>DOUBLE SHEAR STRENGTH MIN.</th>
<th>TENSILE STRENGTH MIN.</th>
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<tbody>
<tr>
<td>PLT1094-06-1</td>
<td>.015</td>
<td>.625</td>
<td>.371</td>
<td>+.088</td>
<td>+2.24</td>
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**REV.:** J

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**Alcoa CAGE CODE:** 5M902

**MONOGRAM CAGE CODE:** 98524

**PROJECT NO.:** 14-0848

**APPROVED BY:** B. GEE
**APPROVED DATE:** 12/11/13

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**A:** NOTICE:

**TYPICAL INSTALLATION:**

**BREAK-OFF LIMITS MEASURED FROM HEAD OF NUT**

**FLATS**

**VISUAL MECHANICAL LOCK**

**DISTORTION OF "D" DIA. PERMISSIBLE IN LOCKING AREA**

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**”G” TOLERANCES:** FOR -06 SIZES +.030/-010 (+.762/-0.254mm), FOR -08 & -10 SIZES +.040/-010 (+1.016/-0.254mm), FOR -12 SIZES +.050/-010 (+1.270/-0.254mm).
LOCKING FEATURE CONSISTS OF THREE (3) INDENTATIONS LOCATED 120° APART ON THE
HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.
14-0848
HEAD MARKINGS ON NUT DEPRESSED .010" (0,254 mm) MAXIMUM.

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NOTICE:

PROPRIETARY AND CONFIDENTIAL:

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WITHOUT THE WRITTEN CONSENT OF MONOGRAM AEROSPACE FASTENERS, THIS DOCUMENT AND THE INFORMATION CONTAINED HEREIN UNDER NO CIRCUMSTANCES WILL

VARY AT MANUFACTURER'S OPTION.

THE GRIP RANGE FOR THESE HALF-GRIP SIZES WILL BE NOMINAL GRIP +.031"/- .030".

1. CONCENTRICITY OF NUT HEAD CONICAL SURFACE TO "D" DIAMETER SHALL BE WITHIN 0.005"
(0,13 mm) T.I.R. (EXCEPT OVER INDENTS)

2. REMOVE ALL LOOSE OR HANGING BURRS.

3. GROUND SHANK VISU-LOKS SHOULD NOT BE USED, EXCEPT WITH CONSIDERABLE CAUTION,
IN APPLICATIONS WHICH EXCEED .0005 INTERFERENCE FIT. GROUND SHANK VISU-LOKS WILL
PERFORM SATISFATORILY WHEN INSTALLED IN THE TABULATED HOLE SIZES.

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).

MANUFACTURER'S IDENTIFICATION:
LETTER "N" DESIGNATES MONOGRAM AEROSPACE FASTENERS,
LETTERS "VS" DESIGNATE ALCOA.

HEAD MARKINGS ON NUT DEPRESSED .010" (.254 mm) MAXIMUM.

HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.
EXAMPLE: PLT1094-06.45 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 -.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.

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.

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". FORCING THE BREAKOFF SHALL NOT EXCEED FIVE (5)
POUNDS (22,23 NEWTONS).

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.

DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.