

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.		L REF.		R RAD.	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
PLT1102-06(-)	.385 .378	9.78 9.60	.342	8.69	.364	9.25	.2295 .2290	5.83 5.82	.2260	5.74	.104 .099	2.64 2.51	.063	1.60	.315	8.00	.333	8.46	.697	17.7	.030 .015	0.76 0.38
PLT1102-08(-)	.507 .499	12.88 12.67	.463	11.76	.398	10.11	.2905 .2900	7.38 7.37	.2870	7.29	.135 .130	3.43 3.30	.087	2.21	.401	10.19	.366	9.30	.725	18.4	.030 .015	0.76 0.38
PLT1102-10(-)	.635 .626	16.13 15.90	.577	14.66	.482	12.24	.3420 .3415	8.69 8.67	.3385	8.60	.152 .147	3.86 3.73	.118	3.00	.442	11.23	.447	11.35	.877	22.3	.040 .020	1.02 0.51
PLT1102-12(-)	.762 .752	19.35 19.10	.696	17.68	.567	14.40	.4050 .4045	10.29 10.27	.4015	10.20	.185 .180	4.70 4.57	.144	3.66	.531	13.49	.527	13.39	.961	24.4	.040 .020	1.02 0.51

PART NUMBER	S MAX.		V GAGE PROT.		W GAGE DIA.		BREAK-OFF LIMITS		MINIMUM AVAILABLE GRIP LENGTH	HOLE SIZE		PREVAILING TORQUE MIN.		DOUBLE SHEAR STRENGTH MIN.		TENSILE STRENGTH MIN.	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm		INCH	mm	IN-LBS	Nm	LBS.	N	LBS.	N
PLT1102-06(-)	.015	0.38	.0299 .0259	0.759 0.658	.3147 .3143	7.993 7.983	+0.15 -0.73	+0.38 -1.85	-02	.233 .230	5.92 5.84	1.5	0.170	4600	20460	1400	6230
PLT1102-08(-)	.015	0.38	.0353 .0307	0.897 0.780	.4245 .4241	10.782 10.772	+0.10 -0.78	+0.25 -1.98	-03	.294 .291	7.47 7.39	2.5	0.282	7900	35140	2100	9340
PLT1102-10(-)	.020	0.51	.0409 .0357	1.039 0.907	.5389 .5385	13.688 13.678	+0.10 -0.83	+0.25 -2.11	-04	.346 .343	8.79 8.71	3.5	0.400	11350	50480	3600	16010
PLT1102-12(-)	.023	0.58	.0466 .0407	1.184 1.034	.6532 .6528	16.591 16.581	+0.10 -0.93	+0.25 -2.36	-04	.409 .406	10.39 10.32	4.0	0.452	16450	73170	5600	24910

▲ "G" TOLERANCE: FOR -06 SIZES +.030/-0.010; FOR -08 & -10 SIZES +.040/-0.010; FOR -12 SIZES +.050/-0.010.

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, SELF LOCKING, CLOSE TOLERANCE 100° FLUSH HEAD, GROUND SHANK
1/32" O/S TO PLT1100; 1/64" O/S TO PLT1101

DRAWING NO:
PLT1102(-)(-)(-)
DRAWN BY:
B. GEE
DRAWN DATE:
12/17/13
APPROVED BY:
CHECKED DATE:

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DCN NO: 14-0758
DCN DATE: 11/13/14
REV: F
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.

SLEEVE: AS REQUIRED FOR PERFORMANCE.

FINISH:

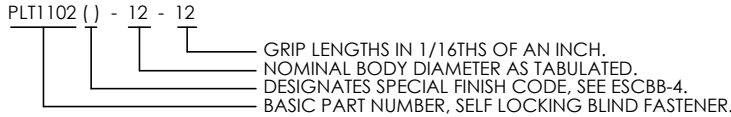
"L" NUT & SCREW: NONE.

SLEEVE: PASSIVATE PER AMS2700.

LUBRICANT:

SOLID DRY FILM LUBRICANT PER THE CHEMICAL REQUIREMENTS OF AS5272 TYPE I OR EVERLUBE 812 PER MIL-PRF-81329, PARAFFIN WAX OR CETYL ALCOHOL PER AS87132 MAY BE APPLIED TO ANY OR ALL COMPONENTS AS REQUIRED FOR PERFORMANCE (SEE ESCBB4 FOR SPECIAL LUBRICANTS AND FINISHES).

PART CODE & EXAMPLE:



GENERAL NOTES:

1. CONCENTRICITY OF NUT HEAD CONICAL SURFACE TO "D" DIAMETER SHALL BE WITHIN 0.005" (0.13 mm) T.I.R. (EXCEPT OVER INDENTATIONS).
2. REMOVE ALL LOOSE OR HANGING BURRS.
3. THESE PARTS HAVE A CLOSE TOLERANCE (.0005) GROUND SHANK AND ARE INTENDED FOR USE IN UP TO .0035 DIAMETRAL INTERFERENCE FIT APPLICATIONS.

4. 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).

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

6. HEAD MARKINGS ON NUT DESPRESSED .010" MAXIMUM.

7. HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.

EXAMPLE: PLT1102-06-4.5 INDICATES A NOMINAL GRIP LENGTH OF 4.5 SIXTEENTHS (.281 = 7.14mm).
THE GRIP RANGE FOR THESE HALF-GRIP SIZES WILL BE NOMINAL GRIP +.031/- .030 (+0.79/-0.79mm).
THE BASIC "G" DIMENSION WILL BE NOMINAL GRIP +.031 (+0.79) AND THE OVERALL SCREW LENGTH "L" DIMENSION MAY VARY AT MANUFACTURER'S OPTION.

8. STANDARD GRIP LENGTHS ARE SHOWN IN TABLE II, 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.

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 (22.23 NEWTONS).

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.

12. FOR ALUMINUM APPLICATION, SHANK, "D" MEASUREMENT MAY INCREASE .0002 INCH OVER THE MAXIMUM DIAMETER AND DECREASE .0005 INCH UNDER THE MINIMUM DIAMETER.

SECOND DASH NUMBER	G GRIP		GRIP RANGE			
			MIN		MAX	
	INCH	mm	INCH	mm	INCH	mm
-01	.093	2,36	.032	0,81	.093	2,36
-02	.156	3,96	.094	2,39	.156	3,96
-03	.219	5,56	.157	3,99	.219	5,56
-04	.281	7,14	.220	5,59	.281	7,14
-05	.344	8,74	.282	7,16	.344	8,74
-06	.406	10,31	.345	8,76	.406	10,31
-07	.469	11,91	.407	10,34	.469	11,91
-08	.531	13,49	.470	11,94	.531	13,49
-09	.595	15,11	.532	13,51	.595	15,11
-10	.656	16,66	.595	15,11	.656	16,66
-11	.719	18,26	.657	16,69	.719	18,26
-12	.781	19,84	.720	18,29	.781	19,84
-13	.844	21,44	.782	19,86	.844	21,44
-14	.906	23,01	.845	21,46	.906	23,01
-15	.969	24,61	.907	23,04	.969	24,61
-16	1,031	26,19	.970	24,64	1,031	26,19
-17	1,094	27,79	1,032	26,21	1,094	27,79
-18	1,156	29,36	1,095	27,81	1,156	29,36
-19	1,219	30,96	1,157	29,39	1,219	30,96
-20	1,281	32,54	1,220	30,99	1,281	32,54
-21	1,344	34,14	1,282	32,56	1,344	34,14
-22	1,406	35,71	1,345	34,16	1,406	35,71
-23	1,469	37,31	1,407	35,74	1,469	37,31
-24	1,531	38,89	1,470	37,34	1,531	38,89
-25	1,594	40,49	1,532	38,91	1,594	40,49
-26	1,656	42,06	1,595	40,51	1,656	42,06
-27	1,719	43,66	1,657	42,09	1,719	43,66
-28	1,781	45,24	1,720	43,69	1,781	45,24
-29	1,844	46,84	1,782	45,26	1,844	46,84
-30	1,906	48,41	1,845	46,86	1,906	48,41
-31	1,969	50,01	1,907	48,44	1,969	50,01
-32	2,031	51,59	1,970	50,04	2,031	51,59

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DRAWING NO: PLT1102()-()-()

DRAWN BY: B. GEE DRAWN DATE: 12/17/13

APPROVED BY: CHECKED DATE:

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SHEET 2 OF 2