



PART NUMBER	NOM DIA.	THEO DIA.	A' DIA. MIN.	C MAX.	D DIA.	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
PLT120-05-(-)	.1635	.332 .325	.296	.268	.1645 .1625	.086 .081	.069	.244	.246	.0276 .0238	.030 .010	.012	.2671 .2667	.168 .165	+0.082 -.006	1.0	3150	900
PLT120-06-(-)	.1980	.385 .378	.342	.303	.1990 .1970	.104 .099	.077	.300	.281	.0299 .0259	.030 .015	.015	.3147 .3143	.202 .199	+0.072 -.016	1.5	4600	1400
PLT120-08-(-)	.2590	.507 .499	.463	.354	.2600 .2580	.135 .130	.102	.384	.325	.0353 .0307	.030 .015	.015	.4245 .4241	.263 .260	+0.072 -.026	2.5	7900	2100
PLT120-10-(-)	.3105	.635 .626	.577	.423	.3115 .3095	.152 .147	.134	.427	.390	.0409 .0357	.040 .020	.020	.5389 .5385	.315 .312	+0.072 -.031	3.5	11350	3600
PLT120-12-(-)	.3735	.762 .752	.696	.510	.3745 .3725	.185 .180	.160	.516	.470	.0466 .0407	.040 .020	.023	.6532 .6528	.378 .375	+0.072 -.031	4.0	16450	5600

SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF.				
		MIN	MAX	PLT120				
				-05-(-)	-06-(-)	-08-(-)	-10-(-)	-12-(-)
-	-	-	-	-	-	-	-	-
-02	.156	.094	.156	.795	.916	-	-	-
-03	.219	.157	.219	.858	.978	1.006	1.158	-
-04	.281	.220	.281	.920	1.041	1.069	1.221	1.304
-05	.344	.282	.344	.983	1.103	1.131	1.283	1.367
-06	.406	.345	.406	1.045	1.166	1.194	1.346	1.429
-07	.469	.407	.469	1.108	1.228	1.256	1.408	1.492
-08	.531	.470	.531	1.170	1.291	1.319	1.471	1.554
-09	.594	.532	.594	1.233	1.353	1.381	1.533	1.617
-10	.656	.595	.656	1.295	1.416	1.444	1.596	1.679
-11	.719	.657	.719	1.358	1.478	1.506	1.658	1.742
-12	.781	.720	.781	1.420	1.541	1.569	1.721	1.804
-13	.844	.782	.844	1.483	1.603	1.631	1.783	1.867
-14	.906	.845	.906	1.545	1.666	1.694	1.846	1.929
-15	.969	.907	.969	1.608	1.728	1.756	1.908	1.992
-16	1.031	.970	1.031	1.670	1.791	1.819	1.971	2.054

SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF.				
		MIN	MAX	PLT120				
				-05-(-)	-06-(-)	-08-(-)	-10-(-)	-12-(-)
-17	1.094	1.032	1.094	1.853	1.881	2.033	2.117	
-18	1.156	1.095	1.156	1.916	1.944	2.096	2.179	
-19	1.219	1.157	1.219	1.978	2.006	2.158	2.242	
-20	1.281	1.220	1.281	2.041	2.069	2.221	2.304	
-21	1.344	1.282	1.344	2.103	2.131	2.283	2.367	
-22	1.406	1.345	1.406	2.166	2.194	2.346	2.429	
-23	1.469	1.407	1.469	2.228	2.256	2.408	2.492	
-24	1.531	1.470	1.531	2.291	2.319	2.471	2.554	
-25	1.594	1.532	1.594	2.353	2.381	2.533	2.617	
-26	1.656	1.595	1.656	2.416	2.444	2.596	2.679	
-27	1.719	1.657	1.719	2.478	2.506	2.658	2.742	
-28	1.781	1.720	1.781	2.541	2.569	2.721	2.804	
-29	1.844	1.782	1.844	2.603	2.631	2.783	2.867	
-30	1.906	1.845	1.906	2.666	2.694	2.846	2.929	
-31	1.969	1.907	1.969	2.728	2.756	2.908	2.992	
-32	2.031	1.970	2.031	2.791	2.819	2.971	3.054	

▲ "G" TOLERANCE: FOR -05 AND -06 SIZES +.030/-0.10; FOR -08 & -10 SIZES +.040/-0.10; FOR -12 SIZES +.060/- .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
HIGH TEMPERATURE (A286 ALLOY)
100° FLUSH HEAD, SELF LOCKING

DRAWING NO: PLT120-(-)(-)	
DRAWN BY: G.MARTINEZ	DRAWN DATE: 07-11-13
APPROVED BY:	CHECKED DATE:
MONOGRAM CAGE CODE: 98524	ECN NO: 14-0654
Alcoa CAGE CODE: 5M902	REV: N
ECN DATE: 11/01/14	SHEET 1 OF 2

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 ASSUMES 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.



PROCUREMENT SPEC: ESCBB-2 CLASS 2.

MATERIAL: NUT, SCREW, & SLEEVE: CORROSION RESISTANT STEEL, TYPE A286 PER AMS5731, AMS5732 OR AMS5737.

HEAT TREAT: NUT & SCREW: SOLUTION HEAT TREATED AND AGED TO HARDNESS OF HRC 30 TO HRC 45. ALL CORE HARDNESS READINGS ARE TAKEN ON MOUNTED SPECIMEN, USING A BRALE PENETRATOR A 30 Kg LOAD (ROCKWELL 30N).

SLEEVE: SOLUTION TREATED.

FINISH: NUT, SCREW, & SLEEVE: PASSIVATE PER AMS2700.

LUBRICANT: LUBRICANTS LISTED BELOW MAY BE APPLIED TO ANY OR ALL COMPONENTS IF REQUIRED FOR PERFORMANCE.

NUT, SCREW, & SLEEVE: DRY FILM LUBE PER AS5272 TYPE I OR MIL-PRF-81329, WWM CARBO-WAX, PARAFFIN WAX AND OR CETYL ALCOHOL PER AS87132.

PART CODE & EXAMPLE: PLT120 - 05 - 05

GRIP LENGTHS IN 1/16THS
NOMINAL BODY DIAMETER AS TABULATED
BASIC PART NUMBER, SELF LOCKING BLIND FASTENER

GENERAL NOTES:

1. OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT EXCEED MAXIMUM "D" 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.
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).
5. MANUFACTURER'S IDENTIFICATION:
LETTER "N" DESIGNATES MONOGRAM AEROSPACE FASTENERS.
LETTERS "VS" DESIGNATE VOI-SHAN.
6. HEAD MARKINGS ON NUT DEPRESSED .010 MAX.
7. THE PRODUCT DESCRIBED BY THIS DRAWING IS "EQUIVALENT TO" AND "INTERCHANGEABLE WITH" THE MANUFACTURER'S PRODUCT LISTED BELOW EXCEPT FOR COLOR IDENTIFICATION. HEAD MARKING AND SELF-LOCKING FEATURE. EXSISTING STOCK MAY BE REWORKED TO COLOR AND HEAD MARKING MAY BE AS SHOWN BELOW.
MONOGRAM...: FL164ALS-FL375ALS SERIES (MARKING: "N" AND "O" OVERSTAMPED "L" OR "SL").
VOI-SHAN...: VA 402 SERIES (MARKING: "VS", "O", AND "SL").
8. STANDARD FINISHES AND LUBES ARE SHOWN ABOVE. REFER TO ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBES, IF REQUIRED.
9. HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.
EXAMPLE: PLT120-06-4.5 INDICATES A NOMINAL GRIP LENGTH OF 4.5 SIXTEENTHS = 0.281.
THE GRIP RANGE FOR THESE HALF-GRIPS 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.
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 MAXIMUM "D" + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS.
11. 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.
12. 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.
13. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.



TITLE: VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE HIGH TEMPERATURE (A286 ALLOY) 100° FLUSH HEAD, SELF LOCKING

DRAWING NO: PLT120-()-()	
DRAWN BY: G.MARTINEZ	DRAWN DATE: 07-11-13
APPROVED BY:	CHECKED DATE:

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.

Alcoa CAGE CODE: 5M902	MONOGRAM CAGE CODE: 98524	ECN NO: 14-0654	REV: N
		ECN DATE: 11/01/14	SHEET 2 OF 2