



PART NUMBER	NOM DIA.	A THEO DIA.	A' DIA. MIN.	C MAX.	D DIA.	E DIA. MAX.	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
PLT124-05-(-)	.1640	.332 .325	.296	.285	.1645 .1635	.1625	.086 .081	.069	.244	.257	.0276 .0238	.030 .010	.012	.2671 .2667	.1680 .1650	+082 -006	1.0	3150	900
PLT124-06-(-)	.2021	.385 .378	.342	.320	.2026 .2016	.1980	.104 .099	.077	.300	.288	.0299 .0259	.030 .015	.015	.3147 .3143	.2060 .2030	+072 -016	1.5	4600	1400
PLT124-08-(-)	.2645	.507 .499	.463	.355	.2651 .2641	.2590	.135 .130	.102	.384	.325	.0353 .0307	.030 .015	.015	.4245 .4241	.2685 .2655	+072 -026	2.5	7900	2100
PLT124-10-(-)	.3115	.635 .626	.577	.440	.3120 .3110	.3095	.152 .147	.134	.427	.396	.0409 .0357	.040 .020	.020	.5389 .5385	.3150 .3120	+072 -031	3.5	11350	3600
PLT124-12-(-)	.3740	.762 .752	.696	.525	.3745 .3735	.3725	.185 .180	.160	.516	.473	.0466 .0407	.040 .020	.023	.6532 .6528	.3780 .3750	+072 -031	4.0	16450	5600

SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF.				
		MIN	MAX	PLT124				
				-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	PLT124				
				-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/-0.10.

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
GROUND SHANK

DRAWING NO:
PLT124-(-)(-)

DRAWN BY: G.MARTINEZ DRAWN DATE: 07-11-13

APPROVED BY: CHECKED DATE:

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Alcoa
CAGE CODE:
5M902

MONOGRAM
CAGE CODE:
98524

ECN NO:
14-0656
ECN DATE:
11/01/14

REV:
D
SHEET 1 OF 2



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.

7. 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: PLT124 - 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. LOCATION OPTIONAL.
7. STANDARD FINISHES AND LUBES ARE SHOWN ABOVE. REFER TO ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBES, IF REQUIRED.
8. HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.
 EXAMPLE: PLT121-06-4.5 INDICATES A NOMINAL GRIP LENGTH OF 4.5 SIXTEENTHS = 0.281.
 THE GRIP RANGE FOR THESE HALF-GRIP SIZES WILL BE NOMINAL GRIP +.031/-0.030.
 THE BASIC "G" DIMENSION WILL BE NOMINAL GRIP +.031 AND THE OVERALL SCREW LENGTH "L" DIMENSION MAY VARY AT MANUFACTURER'S OPTION.
9. GROUND SHANK VISU-LOKS SHOULD NOT BE USED, EXCEPT WITH CONSIDERABLE CAUTION. IN APPLICATIONS WHICH EXCEED APPROXIMATELY .0005" INTERFERENCE FIT. GROUND SHANK VISU-LOKS WILL PERFORM SATISFACTORILY WHEN INSTALLED IN THE TABULATED HOLE SIZES.
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.

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DRAWN BY: G.MARTINEZ	DRAWN DATE: 07-11-13
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		ECN DATE: 11/01/14	SHEET 2 OF 2