



PART NUMBER	NOM DIA.	A 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
PLT171-05(-)	.179	.332 .325	.296	.315	.1800 .1780	.086 .081	.063	.244	.300	.0276 .0238	.030 .010	.012	.2671 .2667	.183 .180	+020 -068	1.0	3150	900
PLT171-06(-)	.214	.385 .378	.342	.350	.2150 .2130	.104 .099	.070	.300	.333	.0299 .0259	.030 .015	.015	.3147 .3143	.218 .215	+015 -073	1.5	4600	1400
PLT171-08(-)	.275	.507 .499	.463	.385	.2760 .2740	.135 .130	.096	.384	.366	.0353 .0307	.030 .015	.015	.4245 .4241	.279 .276	+010 -078	2.5	7900	2100
PLT171-10(-)	.326	.635 .626	.577	.470	.3270 .3250	.152 .147	.128	.427	.447	.0409 .0357	.040 .020	.020	.5389 .5385	.330 .327	+010 -083	3.5	11350	3600
PLT171-12(-)	.389	.762 .752	.696	.555	.3900 .3980	.185 .180	.154	.516	.527	.0466 .0407	.040 .020	.023	.6532 .6528	.393 .390	+010 -093	4.0	16450	5600

SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF.				
		MIN	MAX	PLT171				
				-05(-)	-06(-)	-08(-)	-10(-)	-12(-)
-	-	-	-	-	-	-	-	-
-02	.156	.094	.156	.733	.853	-	-	-
-03	.219	.157	.219	.795	.916	.944	-	-
-04	.281	.220	.281	.858	.978	1.006	1.158	1.242
-05	.344	.282	.344	.920	1.041	1.069	1.221	1.304
-06	.406	.345	.406	.983	1.103	1.131	1.283	1.367
-07	.469	.407	.469	1.045	1.166	1.194	1.346	1.429
-08	.531	.470	.531	1.108	1.228	1.256	1.408	1.492
-09	.594	.532	.594	1.170	1.291	1.319	1.471	1.554
-10	.656	.595	.656	1.233	1.353	1.381	1.533	1.617
-11	.719	.657	.719	1.295	1.416	1.444	1.596	1.679
-12	.781	.720	.781	1.358	1.478	1.506	1.658	1.742
-13	.844	.782	.844	1.420	1.541	1.569	1.721	1.804
-14	.906	.845	.906	1.483	1.603	1.631	1.783	1.867
-15	.969	.907	.969	1.545	1.666	1.694	1.846	1.929
-16	1.031	.970	1.031	1.608	1.728	1.756	1.908	1.992

SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF.				
		MIN	MAX	PLT171				
				-05(-)	-06(-)	-08(-)	-10(-)	-12(-)
-17	1.094	1.032	1.094	1.791	1.819	1.971	2.054	
-18	1.156	1.095	1.156	1.853	1.881	2.033	2.117	
-19	1.219	1.157	1.219	1.916	1.944	2.096	2.179	
-20	1.281	1.220	1.281	1.978	2.006	2.158	2.242	
-21	1.344	1.282	1.344	2.041	2.069	2.221	2.304	
-22	1.406	1.345	1.406	2.103	2.131	2.283	2.367	
-23	1.469	1.407	1.469	2.166	2.194	2.346	2.429	
-24	1.531	1.470	1.531	2.228	2.256	2.408	2.492	
-25	1.594	1.532	1.594	2.291	2.319	2.471	2.554	
-26	1.656	1.595	1.656	2.353	2.381	2.533	2.617	
-27	1.719	1.657	1.719	2.416	2.444	2.596	2.679	
-28	1.781	1.720	1.781	2.478	2.506	2.658	2.742	
-29	1.844	1.782	1.844	2.541	2.569	2.721	2.804	
-30	1.906	1.845	1.906	2.603	2.631	2.783	2.867	
-31	1.969	1.907	1.969	2.666	2.694	2.846	2.929	
-32	2.031	1.970	2.031	2.728	2.756	2.908	2.992	

▲ "G" TOLERANCE: FOR -05 AND -06 SIZES +.030"/-.010"; FOR -08 & -10 SIZES +.040"/-.010"; FOR -12 SIZES +.050"/-.010".



TITLE:
VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE TITANIUM 100° FLUSH HEAD, SELF LOCKING 1/64" OVERSIZE

DRAWING NO: PLT171(-)(-)(-)	
DRAWN BY: G.MARTINEZ	DRAWN DATE: 07-15-13
APPROVED BY:	CHECKED DATE:
Alcoa CAGE CODE: 5M902	MONOGRAM CAGE CODE: 98524
ECN NO: 14-0664	REV: G
ECN DATE: 11/02/14	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 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.



PROCUREMENT SPEC: ESCBB-9, CLASS 2.

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: " - " NUT & SCREW: NONE.
 SLEEVE: PASSIVATE PER AMS2700.
 " L " NUT: ALUMINUM COAT PER NAS4006.
 SLEEVE: PASSIVATE PER AMS2700 AND ALUMINUM COAT PER NAS4006.
 SCREW: NONE.

LUBRICANT: LUBRICANTS LISTED BELOW MAY BE APPLIED TO ANY OR ALL COMPONENTS IF REQUIRED FOR PERFORMANCE.
 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: PLT171 () - 05 - 05

GRIP LENGTHS IN 1/16THS
 NOMINAL BODY DIAMETER AS TABULATED
 DESIGNATES SPECIAL FINISH CODE, SEE ESCBB-4
 BASIC PART NUMBER, SELF LOCKING BLIND FASTENER

- GENERAL NOTES:
- OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT EXCEED MAXIMUM "D" DIAMETER.
 - CONCENTRICITY OF NUT HEAD "A" DIAMETER TO "D" DIAMETER SHALL BE WITHIN .005" T.I.R., EXCEPT OVER INDENTATIONS.
 - REMOVE ALL LOOSE OR HANGING BURRS.
 - 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).
 - MANUFACTURER'S IDENTIFICATION:
 LETTER "N" DESIGNATES MONOGRAM AEROSPACE FASTENERS.
 LETTERS "VS" DESIGNATE VOI-SHAN.
 - HEAD MARKINGS ON NUT DEPRESSED .010" MAX. LOCATION OPTIONAL.
 - STANDARD FINISHES AND LUBES ARE SHOWN ABOVE. REFER TO ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBES, IF REQUIRED.
 - HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.
 EXAMPLE: PLT171-06-4.5 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.
 - 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.
 - 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.
 - 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.

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
 100° FLUSH HEAD, SELF LOCKING 1/64" OVERSIZE

DRAWING NO: PLT171()-()-()	
DRAWN BY: G.MARTINEZ	DRAWN DATE: 07-15-13
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: 14-0664 ECN DATE: 11/02/14	REV: G SHEET 2 OF 2
-------------------------------------	--	---	----------------------------------