**Title:** VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE TITANIUM, 75 KSI SHEAR 100° FLUSH HEAD, SELF LOCKING GROUND SHANK

<table>
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<tr>
<th>SECOND DASH NUMBER</th>
<th>G</th>
<th>GRIP RANGE</th>
<th>L REF.</th>
<th>PLT174</th>
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**Legend:**

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

**TYPICAL INSTALLATION**

**DRAWING NO:** PLT174(-)(-)(-)

**DRAWN BY:** G.MARTINEZ

**DRAWN DATE:** 08-12-13

**APPROVED BY:**

**CHECKED DATE:**

**MONOGRAM AEROSPACE FASTENERS**

a TriMas company

3423 SOUTH GARFIELD AVENUE
COMMERCIAL, CALIFORNIA 90040
(323) 722-4760     FAX (323) 727-1029

**REV:**

**SHEET 1 OF 2**

**ECN NO:** 14-0665

**ECN DATE:** 08-12-13
PROCUREMENT SPEC: ESCBB-9, CLASS 4, 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: " - " NUT & SCREW: NONE.
SLEEVE: PASSIVATE PER AMS2700.

"L" NUT: ALUMINUM COAT (.0002-.0007 THICK) PER NAS4006.
SLEEVE: PASSIVATE PER AMS2700 ALUMINUM COAT (.0002-0007 THICK) 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 OR MIL-PRF-81329, WWM CARBO-WAX, PARAFFIN WAX, AND/OR CETYL ALCOHOL PER AS587132.

PART CODE & EXAMPLE: PLT174( ) - 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:

1. OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT EXCEED MAXIMUM "D" DIAMETER.

2. CONCENTRICITY OF NUT HEAD "A" DIAMETER TO "D" DIAMETER SHALL BE WITHIN .005" T.I.R., EXCEPT OVER INDENTATIONS.

3. REMOVE ALL LOOSE OR HANGING BURRS.


4. MANUFACTURER'S IDENTIFICATION:
LETTER "N" DESIGNATES MONOGRAM AEROSPACE FASTENERS.
LETTERS "VS" DESIGNATE VOI-SHAN.

5. 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.

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

EXAMPLE: PLT174-06-4.5 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.

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.

7. 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.

8. 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.

9. 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.

10. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.