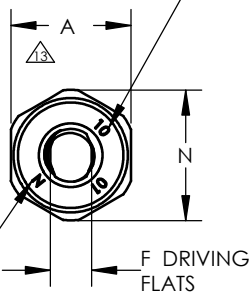
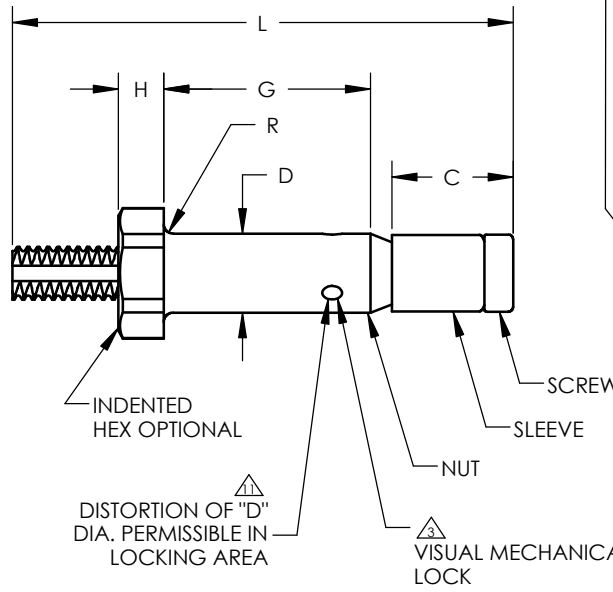


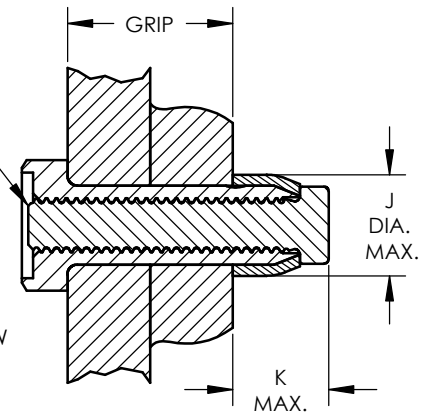
FASTENER IDENTIFICATION MARK "1001" (ARRANGEMENT OPTIONAL)



MANUFACTURER'S IDENTIFICATION MONOGRAM = "N" VOI-SHAN = "VS"



BREAKOFF LIMITS (MEASURED FROM SKIN SURFACE)



TYPICAL INSTALLATION

PART NUMBER	NOM. DIA.	A	C MAX.	D DIA.	F DRIVING FLATS	H MAX.	J DIA. MAX.	K MAX.	N MIN.	R RAD.	HOLE SIZE	BREAK-OFF LIMITS	PREVAILING TORQUE IN. LBS. MIN.	DOUBLE SHEAR STRENGTH LBS. MIN.	TENSILE STRENGTH LBS. MIN.
PLT1001-05-(-)	.1635	.250 .244	.268	.1645 .1625	.086 .081	.096 .086	.244	.246	.272	.020 .010	.168 .165	+088 +000	1.0	3760	970
PLT1001-06-(-)	.1980	.312 .305	.303	.1990 .1970	.104 .099	.113 .103	.300	.281	.340	.025 .015	.202 .199	+098 +010	1.5	5240	1400
PLT1001-08-(-)	.2590	.375 .367	.354	.2600 .2580	.135 .130	.135 .125	.384	.325	.409	.025 .015	.263 .260	+135 +047	2.5	9300	2100
PLT1001-10-(-)	.3105	.437 .429	.423	.3115 .3095	.152 .147	.160 .150	.427	.390	.479	.030 .015	.315 .312	+146 +043	3.5	14600	3600
PLT1001-12-(-)	.3735	.500 .491	.510	.3745 .3725	.185 .180	.190 .180	.516	.470	.548	.030 .015	.378 .375	+152 +049	4.0	21000	5650

SECOND DASH NUMBER	G GRIP ▲	GRIP RANGE		L REF.				
		MIN.	MAX.	PLT1001				
				-05-(-)	-06-(-)	-08-(-)	-10-(-)	-12-(-)
-01	.094	.032	.094	.733	.874	-	-	-
-02	.156	.095	.156	.795	.936	1.006	1.158	-
-03	.219	.157	.219	.858	.999	1.069	1.221	1.304
-04	.281	.220	.281	.920	1.061	1.131	1.283	1.367
-05	.344	.282	.344	.983	1.124	1.194	1.346	1.429
-06	.406	.345	.406	1.045	1.186	1.256	1.408	1.492
-07	.469	.407	.469	1.108	1.249	1.319	1.471	1.554
-08	.531	.470	.531	1.170	1.311	1.381	1.533	1.617
-09	.594	.532	.594	1.233	1.374	1.444	1.596	1.679
-10	.656	.595	.656	1.295	1.436	1.506	1.658	1.742
-11	.719	.657	.719	1.358	1.499	1.569	1.721	1.804
-12	.781	.720	.781	1.420	1.561	1.631	1.783	1.867
-13	.844	.782	.844	1.483	1.624	1.694	1.846	1.929
-14	.906	.845	.906	1.545	1.686	1.756	1.908	1.992
-15	.969	.907	.969	1.608	1.749	1.819	1.971	2.054
-16	1.031	.970	1.031	1.670	1.811	1.881	2.033	2.117

SECOND DASH NUMBER	G GRIP ▲	GRIP RANGE		L REF.				
		MIN.	MAX.	PLT1001				
				-05-(-)	-06-(-)	-08-(-)	-10-(-)	-12-(-)
-17	1.094	1.032	1.094	1.874	1.944	2.096	2.179	
-18	1.156	1.095	1.156	1.936	2.006	2.158	2.242	
-19	1.219	1.157	1.219	1.999	2.069	2.221	2.304	
-20	1.281	1.220	1.281	2.061	2.131	2.283	2.367	
-21	1.344	1.282	1.344	2.124	2.194	2.346	2.429	
-22	1.406	1.345	1.406	2.186	2.256	2.408	2.492	
-23	1.469	1.407	1.469	2.249	2.319	2.471	2.554	
-24	1.531	1.470	1.531	2.311	2.381	2.533	2.617	
-25	1.594	1.532	1.594	2.374	2.444	2.596	2.679	
-26	1.656	1.595	1.656	2.436	2.506	2.658	2.742	
-27	1.719	1.657	1.719	2.499	2.569	2.721	2.804	
-28	1.781	1.720	1.781	2.561	2.631	2.783	2.867	
-29	1.844	1.782	1.844	2.624	2.694	2.846	2.929	
-30	1.906	1.845	1.906	2.686	2.756	2.908	2.992	
-31	1.969	1.907	1.969	2.749	2.819	2.971	3.054	
-32	2.031	1.970	2.031	2.811	2.881	3.033	3.117	

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



PROCUREMENT SPEC: ESCBB-2 CLASS I, EXCEPT AS SPECIFIED HEREIN.

MATERIAL: NUT & SCREW: ALLOY STEEL: 4130 PER AMS-S-6758 OR 8740 PER AMS6322; 4340 PER AMS-S-5000, AMS6415 OR AMS6484 OR 4330M PER AMS6407.  
SLEEVE: CORROSION RESISTANT STEEL: 303 OR 304 PER AMS-QQ-S-763, AMS5639 OR AMS5641.

HEAT TREAT: NUT & SCREW: HEAT TREAT PER AMS2759 TO HRC 39-46 AND TO VICKERS DPH390-465.  
SLEEVE: AS REQUIRED FOR PERFORMANCE.

FINISH: NUT & SCREW: CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2. CADMIUM PLATE PER NAS672 IS PERMISSIBLE PROVIDED IT IS FOLLOWED BY A DICHROMATE POST TREATMENT PER AMS-QQ-P-416.  
SLEEVE: PASSIVATE PER AMS2700. CADMIUM PLATE PER AMS-QQ-P-416, TYPE I, CLASS 3.

LUBRICANT: LUBRICANTS LISTED BELOW MAY BE APPLIED TO ANY OR ALL COMPONENTS IF REQUIRED FOR PERFORMANCE.  
NUT: WWM CARBO-WAX, PARAFFIN WAX AND/OR CETYL ALCOHOL PER AS87132.  
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: PLT1001 - 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. REMOVE ALL LOOSE OR HANGING BURRS.
3. 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).
4. MANUFACTURER'S IDENTIFICATION: LETTER "N" DESIGNATES MONOGRAM AEROSPACE FASTENERS. LETTERS "VS" DESIGNATE VOI-SHAN.
5. HEAD MARKINGS ON NUT DEPRESSED .010" MAX.
6. THE PRODUCT DESCRIBED BY THIS DRAWING IS "EQUIVALENT TO" AND "INTERCHANGEABLE WITH" THE MANUFACTURER'S PRODUCT LISTED BELOW EXCEPT THE HEAD MARKING AND SELF-LOCKING FEATURE.  
MONOGRAM...: WP164A-WP375 SERIES.  
VOI-SHAN...: BAAH SERIES.
7. STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.
8. HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.  
  
EXAMPLE: PLT1001-06-4.5 INDICATES A NOMINAL GRIP LENGTH OF 4.5 SIXTEENTHS = .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.
9. THE PREVAILING TORQUE SHALL CONFORM TO THE VALUES AS TABULATED, WHEN TESTED IN ACCORDANCE WITH SPECIFICATION ESCBB-2. HOWEVER, PREVAILING TORQUES FOR THE PLT1001-05-01 AND PLT1001-06-01 SHALL BE RECORDED THRU A ROTATION OF ONLY 360° OF THE NUT.
10. 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.
11. 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.
12. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.
13. "A" HEX HEAD TO "D" WITHIN .008" T.I.R., AND SCREW HEAD O.D. TO "D" WITHIN .008" T.I.R.



TITLE: VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE ALLOY STEEL PROTRUDING HEX HEAD, SELF LOCKING HIGH STRENGTH

DRAWING NO: <b>PLT1001-( )-( )</b>	
DRAWN BY: G.MARTINEZ	DRAWN DATE: 07-26-13
APPROVED BY:	CHECKED DATE:

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MONOGRAM  
CAGE CODE:  
98524

ECN NO:  
14-0695  
ECN DATE:  
11/06/14

REV:  
H  
SHEET 2 OF 2