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

(L)

6 DISTORTION OF "D" DIA. PERMISSIBLE IN LOCKING AREA

4 VISUAL MECHANICAL LOCK

A

N

F DRIVING FLATS

H

G

D

C

ØE 2X

INDENTED HEX OPTIONAL

R RAD.

SLEEVE

SCREW

NUT

GRIP

J DIA MAX

K MAX

BREAKOFF LIMITS (MEASURED FROM SKIN SURFACE)

FASTENER IDENTIFICATION
HEAD MARKING DEPRESSED .010 INCH MAX.
(POSITION OPTIONAL)

TYPICAL INSTALLATION

PART NUMBER	A HEX FLATS	C MAX.	D 11 BARE	D 11 ALUMINUM COATED	E DIA. MAX.	F DRIVING FLATS	H MAX.	J DIA. MAX.	K MAX.	N MIN.	R RAD.	10 BREAK-OFF LIMITS	10 PREVAILING TORQUE IN. LBS. MIN.	DOUBLE SHEAR STRENGTH LBS. MIN.	TENSILE STRENGTH LBS. MIN.
PLT1087-05-( )	.250 .244	.285	.1680 .1675	.1680 .1670	.1645	.086 .081	.096	.244	.257	.272	.020 .010	+.088 +.000	1.0	3150	900
PLT1087-06-( )	.312 .305	.320	.2025 .2020	.2025 .2015	.1990	.104 .099	.113	.300	.288	.340	.025 .015	+.098 +.010	1.5	4600	1400
PLT1087-08-( )	.375 .367	.355	.2635 .2630	.2635 .2625	.2600	.135 .130	.135	.384	.320	.409	.025 .015	+.135 +.047	2.5	7900	2100
PLT1087-10-( )	.437 .429	.440	.3150 .3145	.3150 .3140	.3115	.152 .147	.160	.427	.396	.479	.030 .015	+.146 +.043	3.5	11350	3600
PLT1087-12-( )	.500 .491	.525	.3780 .3775	.3780 .3770	.3745	.185 .180	.190	.516	.473	.548	.030 .015	+.152 +.049	4.0	16450	5600

SECOND DASH NUMBER	G GRIP ▲	7 10 GRIP RANGE MIN	7 10 GRIP RANGE MAX	L REF. PLT1087 -05-( )	-06-( )	-08-( )	-10-( )	-12-( )
-01	.093	.031	.093	.733	.874	-	-	-
-02	.156	.094	.156	.795	.936	1.006	1.158	-
-03	.219	.157	.219	.858	.999	1.069	1.221	1.367
-04	.281	.220	.281	.920	1.061	1.131	1.283	1.429
-05	.344	.282	.344	.983	1.124	1.194	1.346	1.492
-06	.406	.345	.406	1.045	1.186	1.256	1.408	1.554
-07	.469	.407	.469	1.108	1.249	1.319	1.471	1.617
-08	.531	.470	.531	1.170	1.311	1.381	1.533	1.679
-09	.594	.532	.594	1.233	1.374	1.444	1.596	1.742
-10	.656	.595	.656	1.295	1.436	1.506	1.658	1.804
-11	.719	.657	.719	1.358	1.499	1.569	1.721	1.867
-12	.781	.720	.781	1.420	1.561	1.631	1.783	1.929
-13	.844	.782	.844	1.483	1.624	1.694	1.846	1.992
-14	.906	.845	.906	1.545	1.686	1.756	1.908	2.054
-15	.969	.907	.969	1.608	1.749	1.819	1.971	2.117
-16	1.031	.970	1.031	1.670	1.811	1.881	2.033	2.179

SECOND DASH NUMBER	G GRIP ▲	7 10 GRIP RANGE MIN	7 10 GRIP RANGE MAX	L REF. PLT1087 -05-( )	-06-( )	-08-( )	-10-( )	-12-( )
-17	1.094	1.032	1.094	NOT AVAILABLE IN -05 DIAMETER	1.874	1.944	2.096	2.242
-18	1.156	1.095	1.156		1.936	2.006	2.158	2.304
-19	1.219	1.157	1.219		1.999	2.069	2.221	2.367
-20	1.281	1.220	1.281		2.061	2.131	2.283	2.429
-21	1.344	1.282	1.344		2.124	2.194	2.346	2.492
-22	1.406	1.345	1.406		2.186	2.256	2.408	2.554
-23	1.469	1.407	1.469		2.249	2.319	2.471	2.617
-24	1.531	1.470	1.531		2.311	2.381	2.533	2.679
-25	1.594	1.532	1.594		2.374	2.444	2.596	2.742
-26	1.656	1.595	1.656		2.436	2.506	2.658	2.804
-27	1.719	1.657	1.719		2.499	2.569	2.721	2.867
-28	1.781	1.720	1.781		2.561	2.631	2.783	2.929
-29	1.844	1.782	1.844		2.624	2.694	2.846	2.992
-30	1.906	1.845	1.906		2.686	2.756	2.908	3.054
-31	1.969	1.907	1.969		2.749	2.819	2.971	3.117
-32	2.031	1.970	2.031		2.811	2.881	3.033	3.179

▲ "G" TOLERANCE: FOR -05 AND -06 SIZES +.030/-.010; FOR -08 & -10 SIZES +.040/-.010; FOR -12 SIZES +.050/-.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 TITANIUM HEXAGONAL PROTRUDING HEAD, SELF LOCKING 75 KSI SHEAR, GROUND SHANK

DRAWING NO: PLT1087( )-( )-( )

DRAWN BY: B. GEE
DRAWN DATE: 01/08/14
APPROVED BY:
CHECKED DATE:

Alcoa CAGE CODE: 5M902
MONOGRAM CAGE CODE: 98524
ECN NO: 14-0743
ECN DATE: 11/11/14
REV: N
SHEET 1 OF 2

PROCUREMENT SPEC: ESCBB-9, EXCEPT AS SPECIFIED HEREIN.

MATERIAL:

    NUT, & SCREW: 6AL-4V TITANIUM PER AMS4928 OR AMS4967.
    SLEEVE: 303 OR 304 CORROSION RESISTANT STEEL PER AMS5639 OR AMS5641 OR A-286 PER AMS5731, AMS5732 OR AMS5737.

HEAT TREAT:

    NUT & SCREW: HEAT TREAT PER AMS-H-81200. MAX HYDROGEN 125 PPM.
    SLEEVE: AS REQUIRED FOR PERFORMANCE.
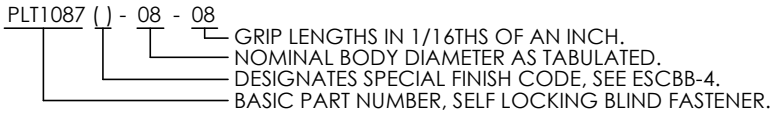
FINISH /9\ :

    " -" NUT & SCREW: NONE. (SEE ESCBB-4 FOR SPECIAL LUBRICANTS AND FINISHES).
    SLEEVE: PASSIVATE PER AMS2700.

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

LUBRICANT /9\ :

    NUT: DRY FILM LUBRICANT PER AS5272 TYPE I OR EVERLUBE 812 PER MIL-PRF-81329. CETYL ALCOHOL PER AS87132, OPTIONAL.
    SCREW &   DRY FILM LUBE PER AS5272 TYPE I OR EVERLUBE 812 PER MIL-PRF-81329, PARAFFIN WAX AND/OR CETYL
    SLEEVE: ALCOHOL PER AS87132 MAY BE APPLIED AS REQUIRED FOR PERFORMANCE.

PART CODE & EXAMPLE:

    PLT1087 ( ) - 08 - 08
              └── GRIP LENGTHS IN 1/16THS OF AN INCH.
           └── 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 BE GREATER THAN MAXIMUM "E" DIAMETER.

2.   CONCENTRICITY OF "A" HEX FLATS TO "D" DIAMETER SHALL BE WITHIN 0.005" 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.   DIMENSIONS IN INCHES AND APPLY AFTER FINISH BUT PRIOR TO LUBE UNLESSS OTHERWISE SPECIFIED.

/6.\   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 "D" MAX + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS. HEAD MARKINGS ON NUT DESPRESSED .010" MAXIMUM.

/7.\   HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.

    EXAMPLE: PLT1087-06-4.5 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".
              EXCEPT: THE GRIP RANGE FOR -1.5 GRIP SHALL BE MAX GRIP = 0.125", MIN GRIP = 0.078".
              THE BASIC "G" DIMENSION WILL BE NOMINAL GRIP +.031" AND THE OVERALL SCREW LENGTH "L" DIMENSION MAY VARY AT MANUFACTURER'S OPTION.

/8.\   THESE PARTS HAVE A CLOSE TOLERANCE (.0005 INCHES) GROUND SHANK AND ARE INTENDED FOR UP TO .0035 INCH DIFFERENTIAL INTERFERENCE FIT APPLICATIONS.

/9.\   STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.

/10.\   STANDARD GRIP LENGTHS ARE SHOWN AS TABULATED, SHORTER OR LONGER GRIPS THAN THOSE LISTED MAY BE AVAILABLE AS SPECIALS. ON GRIP LENGTHS SHORTER THAN THOSE LISTED, THE BREAKOFF AND PREVAILING TORQUES DO NOT APPLY.

11.   MAXIMUM "D" DIAMETER MAY BE INCREASED BY .0002" TO ALLOW FOR ALUMINUM COATING APPLICATION.

MAF ® **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 HEXAGONAL PROTRUDING HEAD, SELF LOCKING 75 KSI SHEAR, GROUND SHANK	DRAWING NO: **PLT1087( )-( )-( )**

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