

TYPICAL INSTALLATION

PART NUMBER	NOM DIA.	A DIA.	C MAX.	D DIA.	F DRIVING FLATS	H	J DIA. MAX.	K MAX.	N MIN.	R RAD.	S	T REF.	HOLE SIZE	BREAK-OFF LIMITS	PREVAILING TORQUE IN. LBS. MIN.	DOUBLE SHEAR STRENGTH LBS. MIN.	TENSILE STRENGTH LBS. MIN.
PLT130-05-()	.1635	.283 .277	.268	.1645 .1625	.086 .081	.074 .067	.244	.246	.307	.030 .010	.054 .044	.049	.168 .165	+.088 +.000	0.75	1920	750
PLT130-06-()	.1980	.346 .332	.303	.1990 .1970	.104 .099	.079 .072	.300	.281	.372	.030 .015	.059 .049	.061	.202 .199	+.098 +.010	1.00	3100	950
PLT130-08-()	.2590	.472 .458	.354	.2600 .2580	.135 .130		.384	.325	.511			.088	.263 .250		1.50	5300	1500

SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF.		
		MIN.	MAX.	PLT130		
				-05-()	-06-()	-08-()
-	-	-	-	-	-	-
-02	.156	.094	.156	.795	.936	.960
-03	.219	.157	.219	.858	.999	1.023
-04	.281	.220	.281	.920	1.061	1.085
-05	.344	.282	.344	.983	1.124	1.148
-06	.406	.345	.406	1.045	1.186	1.210
-07	.469	.407	.469	1.108	1.249	1.273
-08	.531	.470	.531	1.170	1.311	1.335
-09	.594	.532	.594	1.233	1.374	1.396
-10	.656	.595	.656	1.295	1.436	1.460
-11	.719	.657	.719	1.358	1.499	1.523
-12	.781	.720	.781	1.420	1.561	1.585
-13	.844	.782	.844	1.483	1.624	1.648
-14	.906	.845	.906	1.545	1.686	1.710
-15	.969	.907	.969	1.608	1.749	1.773
-16	1.031	.970	1.031	1.670	1.811	1.835

SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF.		
		MIN.	MAX.	PLT130		
				-05-()	-06-()	-08-()
-17	1.094	1.032	1.094		1.874	1.898
-18	1.156	1.095	1.156		1.936	1.960
-19	1.219	1.157	1.219		1.999	2.023
-20	1.281	1.220	1.281		2.061	2.085
-21	1.344	1.282	1.344		2.124	2.148
-22	1.406	1.345	1.406		2.186	2.210
-23	1.469	1.407	1.469		2.249	2.273
-24	1.531	1.470	1.531	NOT AVAILABLE IN -05 DIAMETER	2.311	2.335
-25	1.594	1.532	1.594		2.374	2.398
-26	1.656	1.595	1.656		2.436	2.460
-27	1.719	1.657	1.719		2.499	2.523
-28	1.781	1.720	1.781		2.561	2.585
-29	1.844	1.782	1.844		2.624	2.648
-30	1.906	1.845	1.906		2.686	2.710
-31	1.969	1.907	1.969		2.749	2.773
-32	2.031	1.970	2.031		2.811	2.835

▲ "G" TOLERANCE: FOR -05 AND -06 SIZES +.030/-010; FOR -08 SIZE +.040/-010.



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

TITLE:

VISU-LOK, FASTENER, BLIND
INTERNALLY THREADED, EXTERNAL SLEEVE
LIGHTWEIGHT
MILLABLE HEAD, SELF LOCKING

DRAWING NO:

PLT130-()-()

DRAWN BY:

G.MARTINEZ

DRAWN DATE:

07-15-13

APPROVED BY:

CHECKED DATE:

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Alcoa
CAGE CODE:
5M902

MONOGRAM
CAGE CODE:
98524

ECN NO:
14-0658
ECN DATE:
11/01/14

REV:
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SHEET 1 OF 2



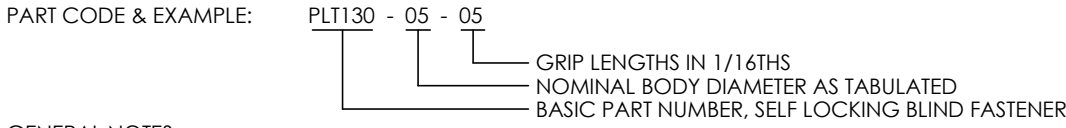
PROCUREMENT SPEC: ESCBB-2 CLASS 3, EXCEPT AS SPECIFIED HEREIN.

MATERIAL: NUT: ALUMINUM ALLOY 7075 PER AMS-QQ-A-225/9.
 SCREW: ALLOY STEEL PER AMS6382, AMS6349, AMS6322 OR AMS-S-6758.
 SLEEVE: CORROSION RESISTANT STEEL: 303 OR 304 PER AMS-QQ-S-763, AMS 5639 OR AMS 5641.

HEAT TREAT: NUT & SCREW: HEAT TREAT MACHINED PARTS PER AMS-H-6088, AND HEAT TREAT HEADED OR FORGED PARTS PER AMS2770.
 SCREW: HEAT TREAT PER AMS2759, APPROXIMATELY 180,000 TO 200,000 PSI TENSILE (HRC 39-43).
 SLEEVE: AS REQUIRED FOR PERFORMANCE.

FINISH: NUT: ANODIZE PER MIL-A-8625, TYPE II, (CLEAR).
 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.



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. THE PRODUCT DESCRIBED BY THIS DRAWING IS "EQUIVALENT TO" AND "INTERCHANGEABLE WITH" THE MANUFACTURER'S PRODUCT LISTED BELOW EXCEPT FOR THE HEAD IDENTIFICATION MARKINGS, COLOR, AND SELF-LOCKING FEATURE. EXISTING STOCK MAY BE REWORKED TO INCORPORATE THE LOCK. WHEN THESE REWORKED FASTENERS ARE SUPPLIED, THE HEAD IDENTIFICATION MAY BE AS SHOWN BELOW:
 MONOGRAM...: SSHFA164-SSHFA260 SERIES (MARKING: "L" OR "SL"; NUT COLOR: VIOLET).
 VOI-SHAN...: BDRF SERIES (MARKING: "VS", "D", AND "SL"; NUT COLOR: GRAY).
5. MANUFACTURER'S IDENTIFICATION: (OPTIONAL)
 LETTER "N" DESIGNATES MONOGRAM AEROSPACE FASTENERS.
 LETTERS "VS" DESIGNATE VOI-SHAN.
6. CONCENTRICITY OF NUT HEAD CONICAL SURFACE TO "D" DIAMETER SHALL BE WITHIN .005" T.I.R., EXCEPT OVER INDENTATIONS.
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: PLT130-06-4.5 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.
9. 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" MAX + .002". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS.
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. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.

 3423 SOUTH GARFIELD AVENUE COMMERCE, CALIFORNIA 90040 (323) 722-4760 FAX (323) 727-1029	TITLE:	VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE LIGHTWEIGHT MILLABLE HEAD, SELF LOCKING		DRAWING NO:	PLT130-()-()	
		DRAWN BY: G.MARTINEZ APPROVED BY:	DRAWN DATE: 07-15-13 CHECKED DATE:			
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