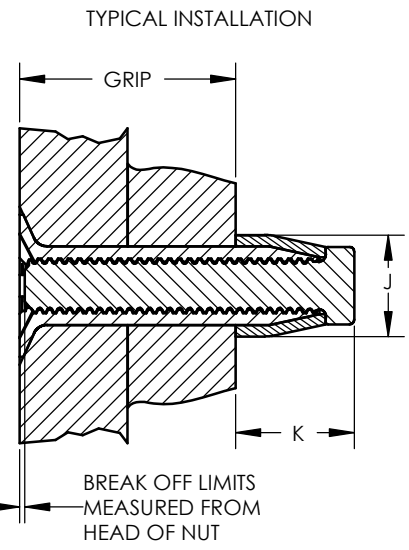
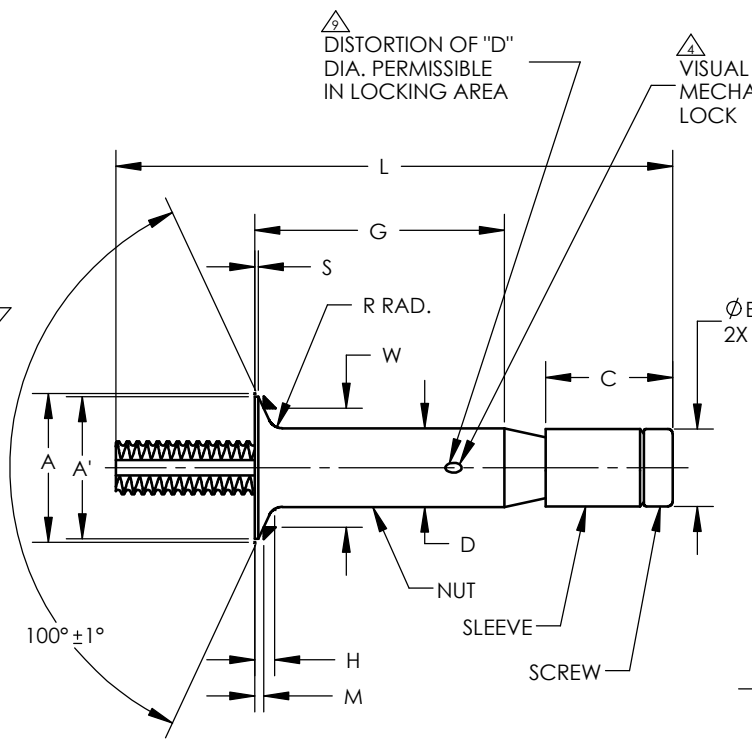
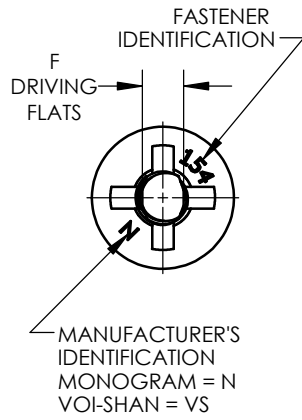




△ DISTORTION OF "D" DIA. PERMISSIBLE IN LOCKING AREA

△ VISUAL MECHANICAL LOCK



PART NUMBER	NOM DIA.		△ A THEO DIA.		△ A' DIA. MIN.		C MAX.		D DIA.		E DIA. MAX.		F DRIVING FLATS		△ H REF.		J DIA. MAX.		K MAX.	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
PLT154-05(-)	.1640	4.166	.332 .325	8.44 8.25	.296	7.52	.285	7.24	.1645 .1635	4.179 4.152	.1615	4.10	.086 .081	2.19 2.05	.069	1.75	.244	6.20	.257	6.53
PLT154-06(-)	.2021	5.133	.385 .378	9.78 9.60	.342	8.69	.320	8.13	.2026 .2016	5.146 5.120	.1995	5.07	.104 .099	2.65 2.51	.077	1.96	.300	7.62	.288	7.31
PLT154-08(-)	.2646	6.721	.507 .499	12.88 12.67	.463	11.76	.355	9.02	.2651 .2641	6.734 6.708	.2621	6.66	.135 .130	3.43 3.30	.102	2.59	.384	9.75	.320	8.13
PLT154-10(-)	.3115	7.912	.635 .626	16.13 15.90	.577	14.66	.440	11.18	.3120 .3110	7.925 7.899	.3090	7.85	.152 .147	3.87 3.73	.134	3.40	.427	10.85	.396	10.06
PLT154-12(-)	.3740	9.500	.762 .752	19.36 19.10	.696	17.68	.525	13.34	.3745 .3735	9.513 9.486	.3715	9.44	.185 .180	4.70 4.57	.160	4.06	.516	13.11	.473	12.01
PLT154-14(-)	.4365	11.087	.890 .878	22.61 22.30	.815	20.70	.545	13.85	.4370 .4360	11.100 11.074	.4340	11.02	.255 .250	6.48 6.35	.190	4.83	.580	14.74	.518	13.16
PLT154-16(-)	.4990	12.675	1.017 1.002	25.84 25.45	.929	23.59	.645	16.39	.4995 .4985	12.688 12.661	.4965	12.61	.215	5.46	.215	5.46	.655	16.64	.613	15.58

PART NUMBER	M GAGE PROT.		R RAD.		S MAX.		W GAGE DIA.		△ H HOLE SIZE		BREAK-OFF LIMITS		△ PREVAILING TORQUE MIN.		DOUBLE SHEAR STRENGTH MIN.		TENSILE STRENGTH MIN.	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	IN-LBS	Nm	LBS.	N	LBS.	N
PLT154-05(-)	.0276 .0239	0.701 0.607	.040 .035	1.02 0.88	.012	0.30	.2671 .2669	6.785 6.779	.1680 .1650	4.27 4.19	+0.20 -0.68	+0.51 -1.73	1.0	0.11	4680	20818	1350	6005
PLT154-06(-)	.0250 .0190	0.635 0.482	.050 .045	1.27 1.14	.015	0.38	.3272 .3270	8.311 8.305	.2060 .2030	5.23 5.15	+0.15 -0.73	+0.38 -1.85	1.5	0.16	6900	30693	2100	9341
PLT154-08(-)	.0327 .0263	0.831 0.668	.060 .055	1.53 1.39	.020	0.51	.4320 .4318	10.973 10.967	.2685 .2655	6.82 6.74	+0.10 -0.78	+0.25 -1.98	2.5	0.28	11800	52489	3650	16236
PLT154-10(-)	.0390 .0320	0.991 0.812	.070 1.78	1.52	.020	0.51	.5451 .5449	13.846 13.840	.3150 .3120	8.00 7.92	+0.10 -0.83	+0.25 -2.11	3.5	0.39	17000	75620	5200	23130
PLT154-12(-)	.0452 .0378	1.148 0.960	.060	1.52	.023	0.58	.6582 .6580	16.719 16.713	.3780 .3750	9.60 9.52	+0.10 -0.93	+0.25 -2.36	4.0	0.45	24500	108981	7500	33361
PLT154-14(-)	.0477 .0412	1.212 1.046	.080 .070	2.03 1.78	.026	0.67	.7784 .7782	19.771 19.766	.4400 .4370	11.18 11.10	+0.10 -1.00	+0.25 -2.54	7.0	0.79	33500	149015	10150	45149
PLT154-16(-)	.0542 .0462	1.377 1.173	.090 .080	2.29 2.03	.030	0.77	.8902 .8900	22.611 22.606	.5030 .5000	12.78 12.70	+0.10 -1.10	+0.26 -2.79	10.0	1.13	43800	194832	13500	60051

PART CODE & EXAMPLE:
 PLT154 L 05 - 05
 L GRIP LENGTHS IN 1/16THS OF AN INCH (1.59 mm)
 05 NOMINAL BODY DIAMETER IN 1/32NDS OF AN INCH (0.79 mm)
 - 05 DESIGNATES SPECIAL FINISH CODE, SEE ESCBB-4
 BASIC CODE, SELF-LOCKING BLIND FASTENER

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 5% CHROME STEEL (H-11) HIGH STRENGTH, FLUSH HEAD, SELF-LOCKING GROUND SHANK

DRAWING NO:
PLT154(-)(-)(-)
 DRAWN BY: G.MARTINEZ
 DRAWN DATE: 07-12-13
 APPROVED BY:
 CHECKED DATE:

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Alcoa CAGE CODE: 5M902
 MONOGRAM CAGE CODE: 98524
 ECN NO: 14-0662
 ECN DATE: 11/02/14
 REV: AC
 SHEET 1 OF 2



PROCUREMENT SPEC: ESCBB-10.

MATERIAL:

NUT, & SCREW: 5% CHROME STEEL (H-11) PER AMS6487.
SLEEVE: INCONEL X-750 PER AMS5667 OR AMS5582; OR A286 PER AMS5731, AMS5732 OR AMS5737.

HEAT TREAT:

NUT & SCREW: ROCKWELL "C" 48-53.
SLEEVE: AS REQUIRED FOR PERFORMANCE.

FINISH: Δ 6

(-) NUT & SCREW: CADMIUM PLATE PER NAS672 (.0003" MIN THICKNESS) EXCEPT THERMAL INDICATOR MAY BE OMITTED. SUPPLEMENTARY CHROMATE TREATMENT PER AMS-QQ-P-416 AFTER BAKE. COLOR NUT RED.

SLEEVE: CADMIUM PLATE PER AMS-QQ-P-416, TYPE I OR TYPE II, CLASS 2 OR CLASS 3.

(L) NUT & SLEEVE: ALUMINUM COAT PER NAS4006.

SCREW: CADMIUM PLATE PER NAS672 (.0003" MIN THICKNESS) EXCEPT THERMAL INDICATOR MAY BE OMITTED. SUPPLEMENTARY CHROMATE TREATMENT PER AMS-QQ-P-416 AFTER BAKE.

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 AS87132.

Table with columns: SECOND DASH NUMBER, GRIP, GRIP RANGE (MIN, MAX), and L REF. (PLT154) with sub-columns for diameters -05(-) to -16(-). Rows list dash numbers from -02 to -32.

GENERAL NOTES:

- 1. OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT BE GREATER THAN MAXIMUM "D" DIAMETER.
2. CONCENTRICITY OF NUT HEAD CONICAL SURFACE TO "D" DIAMETER SHALL BE WITHIN 0.005" (0.13 mm) I.T.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" (1.02 mm) ABOVE THE INTERSECTION OF THE NUT NOSE ANGLE AND O.D. (MEAN GRIP OF FASTENER). HEAD MARKING ON NUT DESPRESSED .010" (0.26 mm) MAXIMUM. LOCATION OPTIONAL.
5. 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.
6. STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.
7. HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.
EXAMPLE: PLT154-06-4.5 INDICATES A NOMINAL GRIP LENGTH OF 4.5 SIXTEENTHS (.281" = 7.14 mm). THE GRIP RANGE FOR THESE HALF-GRIP SIZES WILL BE NOMINAL GRIP +.031"/-.030" (+0.79/-0.79 mm). THE BASIC "G" DIMENSION WILL BE NOMINAL GRIP +.031 (+0.79) AND THE OVERALL SCREW LENGTH "L" DIMENSION MAY VARY AT MANUFACTURER'S OPTION.
8. GROUND SHANK VISU-LOK BLIND FASTENERS SHOULD NOT BE USED EXCEPT WITH CONSIDERABLE CAUTION IN APPLICATIONS WHICH EXCEED APPROXIMATELY .0005" INTERFERENCE FIT. GROUND SHANK VISU-LOK BLIND FASTENERS WILL PERFORM SATISFACTORILY WHEN INSTALLED IN THE TABULATED HOLE SIZES.
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 + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS (22.23 NEWTONS).
10. 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", "M", "W" AND HEAD ANGLE DIMENSIONS.
11. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.
12. "G" TOLERANCES: FOR -05 & -06 SIZES +.030"/-.010" (+0.762/-0.254 mm), FOR -08 & -10 SIZES +.040"/-.010" (+1.016/-0.254 mm), FOR -12 SIZES +.050"/-.010" (+1.270/-0.254 mm).
13. HEAD MARKING ON NUT DEPRESSED .010" (0.26 mm) MAXIMUM.

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REV: AC SHEET 2 OF 2