



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.
PLT274-05-()	.1640	.250 .244	.285	.1645 .1635	.086 .081	.096	.244	.257	.272	.020 .010	.1680 .1650	+0.088 +0.000	1.0	3150	900
PLT274-06-()	.2021	.312 .305	.320	.2026 .2016	.104 .099	.113	.300	.288	.340	.025 .015	.2060 .2030	+0.098 +0.010	1.5	4600	1400
PLT274-08-()	.2646	.375 .367	.355	.2651 .2641	.135 .130	.135	.384	.320	.409	.030 .015	.2685 .2655	+0.135 +0.047	2.5	7900	2100
PLT274-10-()	.3115	.437 .429	.440	.3120 .3110	.152 .147	.160	.427	.396	.479	.030 .015	.3150 .3120	+0.146 +0.043	3.5	11350	3600
PLT274-12-()	.3740	.500 .491	.525	.3745 .3735	.185 .180	.190	.516	.473	.548	.030 .015	.3780 .3750	+0.152 +0.049	4.0	16450	5600

SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF. PLT274				
		MIN.	MAX.	-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	GRIP RANGE		L REF. PLT274				
		MIN.	MAX.	-05-()	-06-()	-08-()	-10-()	-12-()
-17	1.094	1.032	1.094	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	

NOT AVAILABLE IN -05 DIAMETER

▲ "G" TOLERANCE: FOR -05 AND -06 SIZES +.030/-0.010; FOR -08 & -10 SIZES +.040/-0.010; FOR -12 SIZE +.050/-0.010.



PROCUREMENT SPEC: ESCBB-9, CLASS 4. EXCEPT AS NOTED 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: "L" NUT & SCREW: NONE  
SLEEVE: PASSIVATE PER AMS2700.

"6" "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.

"6" DRY FILM LUBE PER AS5272 OR MIL-PRF-81329, WWM CARBO-WAX, PARAFFIN WAX AND/OR CETYL ALCOHOL PER AS87132.

PART CODE & EXAMPLE: PLT274 ( ) 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. 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. LOCATION OPTIONAL.
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: PLT274-06-4.5 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.
8. 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.
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" + .001". 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.

**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, 75 KSI SHEAR PROTRUDING HEX HEAD, SELF LOCKING GROUND SHANK

DRAWING NO: <b>PLT274( )-( )-( )</b>	
DRAWN BY: G.MARTINEZ	DRAWN DATE: 07-25-13
APPROVED BY:	CHECKED DATE:

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SHEET 2 OF 2