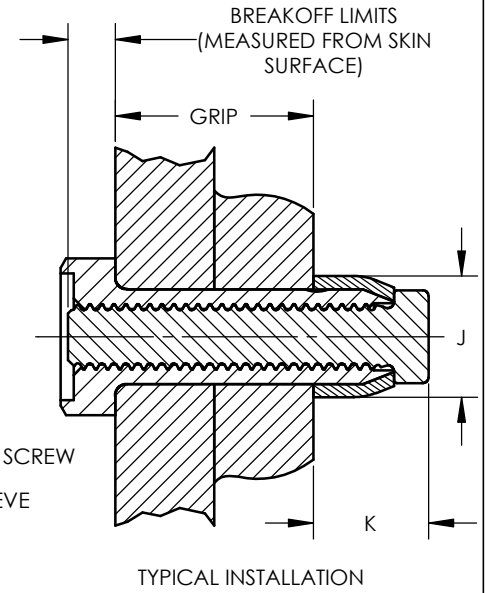
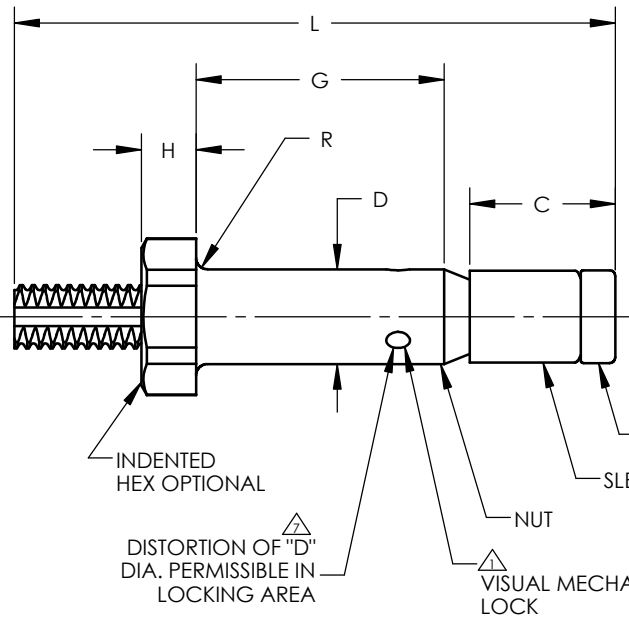
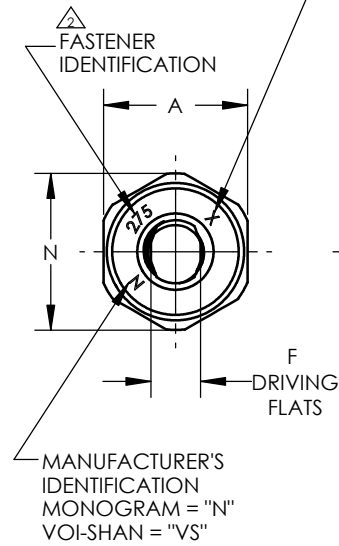


FINISH CODE LETTER "X"
ON "X" CODED PARTS ONLY



PART NUMBER	NOM. DIA.		A		C MAX.		D DIA.		F DRIVING FLATS		H MAX.		J DIA MAX.		K MAX.	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
PLT275-05(-)	.1635	4,153	.250 .244	6,35 6,20	.285	7,24	.1645 .1625	4,178 4,128	.086 .081	2,18 2,06	.096	2,44	.244	6,20	.257	6,53
PLT275-06(-)	.1890	4,800	.312 .305	7,92 7,75	.320	8,13	.1900 .1880	4,826 4,775	.104 .099	2,64 2,51	.113	2,87	.300	7,62	.288	7,31
PLT275-08(-)	.2480	6,299	.375 .367	9,52 9,32	.355	9,02	.2490 .2470	6,325 6,274	.135 .130	3,43 3,30	.135	3,43	.384	9,75	.320	8,13
PLT275-10(-)	.3105	7,887	.437 .429	11,10 10,90	.440	11,18	.3115 .3095	7,912 7,861	.152 .147	3,86 3,73	.160	4,06	.427	10,85	.396	10,06
PLT275-12(-)	.3735	9,487	.500 .491	12,70 12,47	.525	13,34	.3745 .3725	9,512 9,462	.185 .180	4,70 4,57	.190	4,83	.516	13,11	.473	12,01

PART NUMBER	N MIN.		R RAD.		HOLE SIZE		BREAK-OFF LIMITS		PREVAILING TORQUE MIN.		DOUBLE SHEAR STRENGTH MIN.		TENSILE STRENGTH MIN.	
	INCH	MM	INCH	mm	INCH	mm	INCH	mm	INCH-LBS	Nm	LBS	N	LBS	N
PLT275-05(-)	.272	6,91	.020 .010	0,51 0,25	.168 .165	4,27 4,19	+0,088 +0,000	+2,23 +0,00	1,0	0,113	3150	14010	900	4000
PLT275-06(-)	.340	8,64	.025 .015	0,63 0,38	.193 .190	4,90 4,82	+0,098 +0,010	+2,49 +0,25	1,5	0,170	4200	18680	1400	6230
PLT275-08(-)	.409	10,39			.252 .249	6,40 6,32	+1,135 +0,047	+3,43 +1,19	2,5	0,282	7200	32030	2100	9340
PLT275-10(-)	.479	12,17	.030 .015	0,76 0,38	.315 .312	8,00 7,92	+1,146 +0,043	+3,71 +1,09	3,5	0,400	11350	50480	3600	16010
PLT275-12(-)	.548	13,92			.378 .375	9,60 9,52	+1,152 +0,049	+3,86 +1,24	4,0	0,452	16450	73170	5600	24910

PART CODE & EXAMPLE:
PLT275 X - 05 - 05

- GRIP LENGTHS IN 1/16THS
- NOMINAL BODY DIAMETER AS TABULATED
- DESIGNATES SPECIAL FINISH CODE, SEE ESCB-4
- BASIC PART NUMBER, SELF LOCKING BLIND FASTENER

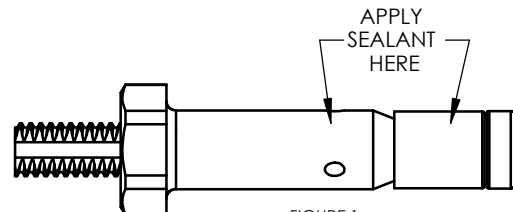


FIGURE 1.
(XSA) CODE



PROCUREMENT SPEC: ESCBB-9 CLASS II.



MATERIAL:

NUT & SCREW : 6AI-4V TITANIUM PER AMS4928 OR AMS4967.

SLEEVE: CORROSION RESISTANT STEEL.

HEAT TREAT:

NUT & SCREW: HEAT TREAT PER AMS-H-81200 TO 95 KSI FSU MIN. MAX. HYDROGEN 125 PPM.

SLEEVE: AS REQUIRED FOR PERFORMANCE.

FINISH:

"_" NUT & SCREW: NONE

SLEEVE: PASSIVATE PER AMS2700.

"X" NUT: I.V.D. ALUMINUM COAT PER MIL-DTL-83488, CLASS 3, TYPE II.

SCREW: KAL-GARD ANN-R0 #1012 OPTIONAL.

SLEEVE: PASSIVATE PER AMS2700 KAL-GARD ANN-R0 #1013 OPTIONAL.

LUBRICANT:

"_" NUT, SCREW & SLEEVE: DRY FILM & CETYL, OPTIONAL & AS REQUIRED.

"X" NUT: CARBO-WAX, PARAFFIN WAX, TIOLON A-20, TIOLON X-20, OR CETYL ALCOHOL AS REQUIRED FOR PERFORMANCE.

SCREW & SLEEVE: LUBRICANTS USED ON SLEEVES AND SCREWS MUST NOT CONTAIN SULFIDES OR GRAPHITE. EXAMPLE OF ACCEPTABLE LUBRICANTS ARE TIO-LON X-20 AND A-20, KAL-GARD FC-2, AND THOSE LUBES LISTED ABOVE FOR THE NUT COMPONENT.

"XSA" DRY FILM LUBE AS REQUIRED FOR PERFORMANCE.

SECOND DASH NUMBER	G GRIP		GRIP RANGE				L REF.											
			MIN.		MAX.		PLT275											
	IN	mm	IN	mm	IN	mm	-05(-)		-06(-)		-08(-)		-10(-)		-12(-)			
-01	.093	2.39	.031	0.79	.093	2.36	.733	18.62	.874	22.20	-	-	-	-	-	-	-	
-02	.156	3.96	.094	2.39	.156	3.96	.795	20.19	.936	23.77	1.006	25.557	1.158	29.413	-	-	-	
-03	.219	5.56	.157	3.99	.219	5.56	.858	21.80	.999	25.37	1.069	27.153	1.221	31.013	1.367	34.722	-	
-04	.281	7.14	.220	5.59	.281	7.14	.920	23.37	1.061	26.949	1.131	28.327	1.283	32.588	1.429	36.230	-	
-05	.344	8.74	.282	7.16	.344	8.74	.983	24.97	1.124	28.550	1.194	30.228	1.346	34.188	1.492	36.897	-	
-06	.406	10.31	.345	8.76	.406	10.31	1.045	26.543	1.186	30.124	1.256	31.902	1.408	35.763	1.554	39.472	-	
-07	.469	11.91	.407	10.34	.469	11.91	1.108	28.143	1.249	31.725	1.319	33.503	1.471	37.363	1.617	41.072	-	
-08	.531	13.49	.470	11.94	.531	13.49	1.170	29.718	1.311	33.300	1.381	35.077	1.533	38.938	1.679	42.647	-	
-09	.594	15.11	.532	13.51	.594	15.11	1.233	31.318	1.374	34.900	1.444	36.678	1.596	40.538	1.742	44.247	-	
-10	.656	16.66	.595	15.11	.656	16.66	1.295	32.893	1.436	36.474	1.506	38.252	1.658	42.113	1.804	45.622	-	
-11	.719	18.26	.657	16.69	.719	18.26	1.358	34.493	1.499	38.075	1.569	39.853	1.721	43.713	1.867	47.422	-	
-12	.781	19.84	.720	18.29	.781	19.84	1.420	36.068	1.561	39.650	1.631	41.427	1.783	45.288	1.929	48.997	-	
-13	.844	21.44	.782	19.86	.844	21.44	1.483	37.668	1.524	41.250	1.694	43.028	1.846	46.888	1.992	50.597	-	
-14	.906	23.01	.845	21.46	.906	23.01	1.545	39.243	1.686	42.824	1.756	44.602	1.908	48.463	2.054	52.172	-	
-15	.969	24.61	.907	23.04	.969	24.61	1.608	40.843	1.749	44.425	1.819	46.203	1.971	50.063	2.117	53.772	-	
-16	1.031	26.19	.970	24.64	1.031	26.19	1.670	42.418	1.811	46.000	1.881	47.777	2.033	51.638	2.179	55.347	-	
-17	1.094	27.79	1.032	26.21	1.094	27.79				1.874	47.600	1.944	49.378	2.096	53.238	2.242	56.947	-
-18	1.156	29.36	1.095	27.81	1.156	29.36				1.936	49.174	2.006	50.952	2.158	54.813	2.304	58.522	-
-19	1.219	30.96	1.157	29.39	1.219	30.96				1.999	50.775	2.069	52.553	2.221	56.413	2.367	60.122	-
-20	1.281	32.54	1.220	30.99	1.281	32.54				2.061	52.350	2.131	54.127	2.283	57.988	2.429	61.697	-
-21	1.344	34.14	1.282	32.56	1.344	34.14				2.124	53.950	2.194	55.728	2.346	59.588	2.492	63.297	-
-22	1.406	35.71	1.345	34.16	1.406	35.71				2.186	55.524	2.256	57.302	2.408	61.163	2.554	64.872	-
-23	1.469	37.31	1.407	35.74	1.469	37.31				2.249	57.125	2.319	58.903	2.471	62.763	2.617	66.472	-
-24	1.531	38.89	1.470	37.34	1.531	38.89				2.311	58.700	2.381	60.477	2.533	64.338	2.679	68.047	-
-25	1.594	40.49	1.532	38.91	1.594	40.49				2.374	60.300	2.444	62.078	2.596	65.938	2.742	69.647	-
-26	1.656	42.06	1.595	40.51	1.656	42.06				2.436	61.874	2.506	63.652	2.658	67.513	2.804	71.222	-
-27	1.719	43.66	1.657	42.09	1.719	43.66				2.499	63.475	2.569	65.253	2.721	69.113	2.867	72.822	-
-28	1.781	45.24	1.720	43.69	1.781	45.24				2.561	65.049	2.631	66.827	2.783	70.688	2.929	74.397	-
-29	1.844	46.84	1.782	45.26	1.844	46.84				2.624	66.650	2.694	68.428	2.846	72.288	2.992	75.997	-
-30	1.906	48.41	1.845	46.86	1.906	48.41				2.686	68.224	2.756	70.002	2.908	73.863	3.054	77.572	-
-31	1.969	50.01	1.907	48.44	1.969	50.01				2.749	69.825	2.819	71.603	2.971	75.463	3.117	79.172	-
-32	2.031	51.59	1.970	50.04	2.031	51.59				2.811	71.400	2.881	73.177	3.033	77.038	3.179	80.747	-

NOT AVAILABLE IN -05 DIAMETER

1. LOCKING FEATURE CONSISTS OF THREE (3) INDENTATIONS LOCATED 120° APART ON THE PERIPHERY OF THE NUT COMPONENT.
2. FASTENER IDENTIFICATION: "275" IN ONE QUADRANT OR "S275" IN TWO QUADRANTS. OPTIONAL HEAD MARKING FOR -05, -10 AND -12 SIZES "270" IN ONE QUADRANT OR "S270" IN TWO QUADRANTS.
3. HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.
- EXAMPLE: PLT275-06-4.5 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/-0.030 (+0.79/-0.76mm). THE BASIC "G" DIMENSION WILL BE NOMINAL GRIP +.031 (+0.79 mm) AND THE OVERALL SCREW LENGTH "L" DIMENSION MAY VARY AT THE MANUFACTURER'S OPTION.
4. 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.
5. "XSA" PARTS ARE PARTIALLY DISASSEMBLED TO PERMIT THE APPLICATION OF WET SEALANT AS SHOWN IN FIGURE 1. (XSA PARTS MUST HAVE SEALANT APPLIED FOR PROPER FUNCTION).
6. MAXIMUM RECOMMENDED TEMPERATURE 750°F.
7. 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 (22.23 NEWTONS).
8. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.
9. OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT BE GREATER THAN MAXIMUM "D" DIAMETER.
10. FASTENERS SHALL BE FREE OF ALL LOOSE OR HANGING BURRS.
11. "G" TOLERANCES: FOR -05 & -06 SIZES +.030/-0.010 (+0.77/-0.25 mm); FOR -08 & -10 SIZES +.040/-0.10 (+1.02/-0.25 mm); FOR -12 SIZES +.050/-0.010 (+1.27/-0.25 mm).

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

TITLE:

VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE TITANIUM PROTRUDING HEX HEAD, SELF-LOCKING 75 KSI SHEAR

DRAWING NO: PLT275(-)(-)(-)

DRAWN BY: G.MARTINEZ DRAWN DATE: 07-25-13

APPROVED BY: CHECKED DATE:

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ECN DATE: 11/06/14

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SHEET 2 OF 2