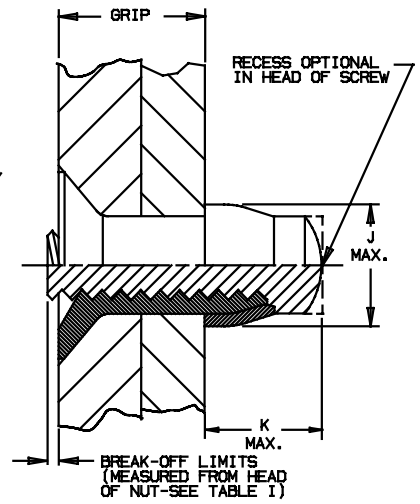
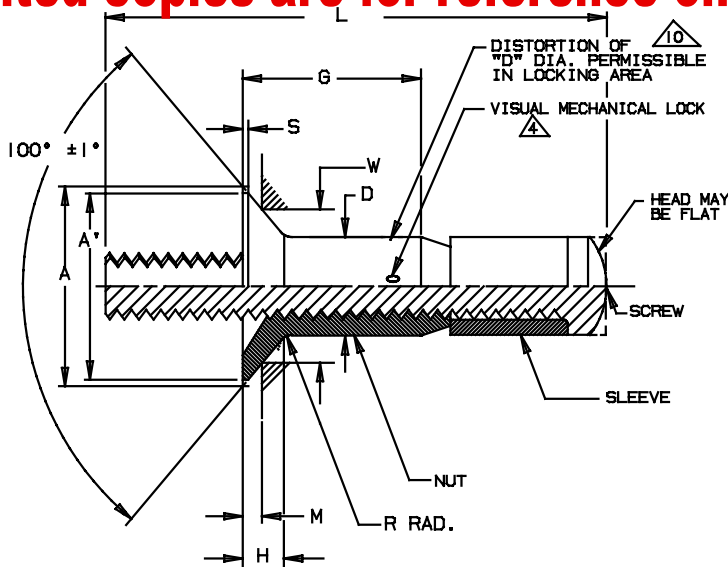
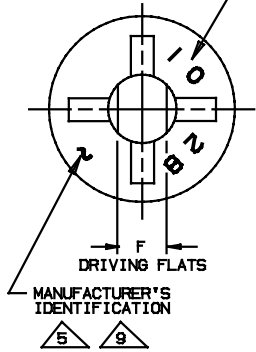


Printed copies are for reference only.

FASTENER IDENTIFICATION  
 MARK "1028"  
 (ARRANGEMENT OPTIONAL)



TYPICAL INSTALLATION

TABLE I

PART NUMBER	NOM. DIA.	A THEO. DIA.	A' DIA. MIN.	D DIA.	F DRIVING FLATS	H REF.	J DIA. MAX.	K MAX.	M GAGE PROT.	R RAD.	S MAX.	W GAGE DIA.	BREAK-OFF LIMITS	PREVAILING TORQUE IN. LBS. MIN.	DOUBLE SHEAR STRENGTH LBS. MIN.	TENSILE STRENGTH LBS. MIN.
USE PLT150-6-(*)	.1980															
PLT 1028-6-(*)	.2290	.385 .378	.342	.2300 .2280	.104 .099	.063	.315	.338	.0250 .0190	.050 .045	.015	.3272 .3270	+0.015 -.073	1.5	6900	2100
PLT 1028-8-(*)	.2900	.507 .499	.463	.2910 .2890	.135 .130	.087	.401	.363	.0327 .0263	.060 .055	.015	.4320 .4318	+0.010 -.078	2.5	11900	3650
PLT 1028-10-(*)	.3415	.635 .626	.577	.3425 .3405	.152 .147	.118	.442	.434	.0390 .0320	.070 .060	.020	.5451 .5449	+0.010 -.083	3.5	17000	5200
PLT 1028-12-(*)	.4045	.762 .752	.696	.4055 .4035	.185 .180	.144	.531	.523	.0452 .0378	.070 .060	.023	.6582 .6580	+0.010 -.093	4.0	24500	7500

(\*) SEE TABLE II FOR SECOND DASH NUMBER AND APPROVED CALLOUT.

TABLE II

SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF.				SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF.			
		MIN.	MAX.	PLT1028						MIN.	MAX.	PLT1028			
				-6-(*)	-8-(*)	-10-(*)	-12-(*)					-6-(*)	-8-(*)	-10-(*)	-12-(*)
-	-	-	-	-	-	-	-	-17	1.094	1.032	1.094	1.767	1.785	2.002	2.074
-2	.156	.094	.156	.829	-	-	-	-18	1.156	1.095	1.156	1.829	1.847	2.064	2.136
-3	.219	.157	.219	.892	.910	-	-	-19	1.219	1.157	1.219	1.892	1.910	2.127	2.199
-4	.281	.220	.281	.954	.972	1.189	1.261	-20	1.281	1.220	1.281	1.954	1.972	2.189	2.261
-5	.344	.282	.344	1.017	1.035	1.252	1.324	-21	1.344	1.282	1.344	2.017	2.035	2.252	2.324
-6	.406	.345	.406	1.079	1.097	1.314	1.386	-22	1.406	1.345	1.406	2.079	2.097	2.314	2.386
-7	.469	.407	.469	1.142	1.160	1.377	1.449	-23	1.469	1.407	1.469	2.142	2.160	2.377	2.449
-8	.531	.470	.531	1.204	1.222	1.439	1.511	-24	1.531	1.470	1.531	2.204	2.222	2.439	2.511
-9	.594	.532	.594	1.267	1.285	1.502	1.574	-25	1.594	1.532	1.594	2.267	2.285	2.502	2.574
-10	.656	.595	.656	1.329	1.347	1.564	1.636	-26	1.656	1.595	1.656	2.329	2.347	2.564	2.636
-11	.719	.657	.719	1.392	1.410	1.627	1.699	-27	1.719	1.657	1.719	2.392	2.410	2.627	2.699
-12	.781	.720	.781	1.454	1.472	1.689	1.761	-28	1.781	1.720	1.781	2.454	2.472	2.689	2.761
-13	.844	.782	.844	1.517	1.535	1.752	1.824	-29	1.844	1.782	1.844	2.517	2.535	2.752	2.824
-14	.906	.845	.906	1.579	1.597	1.814	1.886	-30	1.906	1.845	1.906	2.579	2.597	2.814	2.886
-15	.969	.907	.969	1.642	1.660	1.877	1.949	-31	1.969	1.907	1.969	2.642	2.660	2.877	2.949
-16	1.031	.970	1.031	1.704	1.722	1.939	2.011	-32	2.031	1.970	2.031	2.704	2.722	2.939	3.011

▲ "G" TOLERANCES: FOR -5 & -6 SIZES +.030/-0.010; FOR -8 & -10 SIZES +.040/-0.010; FOR -12 SIZE +.050/-0.010.

U.S. PATENT NO. 3643544, OTHER PATENTS PENDING.

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TITLE  
**VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE HIGH STRENGTH, 5 % CHROME STEEL H-11 100° FLUSH HEAD, SELF LOCKING 1/32" OVERSIZE**

**MONOGRAM**

CODE IDENT. NO.  
**98524**

**STANDARD**

**PLT 1028**

**SHEET 1 OF 2**

APPROVED DATE  
 31 JANUARY 1973

REV. LETTER AND DATE  
 ECN #0142  
 05-19-1999



PROCUREMENT SPEC. : ESCBB-10 EXCEPT AS SPECIFIED HEREIN.

MATERIAL : NUT & SCREW : 5 % CHROME STEEL (H-11) PER AMS6487.  
 SLEEVE : INCONEL X-750 PER AMS5667 OR AMS5582; OR A-286 PER AMS5731, AMS5732 OR AMS5737.

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

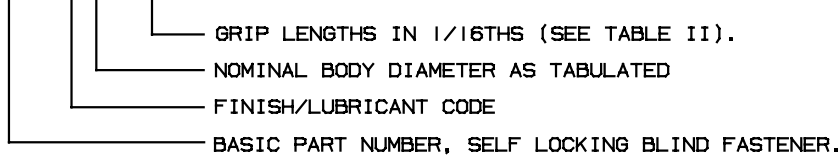
FINISH: "-" NUT & SCREW : CADMIUM PLATE PER NAS672 (.0003 MIN THICKNESS) EXCEPT THERMAL INDICATOR MAY BE OMITTED. SUPPLEMENTARY CHROMATE TREATMENT PER QQ-P-416 AFTER BAKE.  
 9 SLEEVE : PASSIVATE PER MIL-S-5002 (QQ-P-35) AND CADMIUM PLATE PER QQ-P-416, TYPE I, CLASS 3.

"L" NUT : ALUMINUM COAT PER NAS4006.  
 SLEEVE : PASSIVATE PER QQ-P-35 (MIL-S-5002) AND ALUMINUM COAT PER NAS4006.  
 SCREW : CADMIUM PLATE PER NAS672 (.0003 MIN THICKNESS) EXCEPT THERMAL INDICATOR MAY BE OMITTED. SUPPLEMENTARY CHROMATE TREATMENT PER QQ-P-416 AFTER BAKE.

LUBRICANT : LUBRICANTS LISTED BELOW MAY BE APPLIED TO ANY OR ALL COMPONENTS IF REQUIRED FOR PERFORMANCE :  
 9 DRY FILM LUBE PER MIL-L-46010 TYPE I OR EVERLUBE 812 PER MIL-L-81329, PARAFFIN WAX, CETYL ALCOHOL PER MIL-L-87132 AND/OR WWM CARBO-WAX.

PART CODE & EXAMPLE :

PLT1028 L 8 - 8



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 .005 T.I.R. (EXCEPT OVER INDENTS).
- 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. MANUFACTURER'S IDENTIFICATION:  
 LETTER "N" DESIGNATES MONOGRAM AEROSPACE FASTENERS.  
 LETTERS "VS" DESIGNATE VOI-SHAN.
- 6.) HEAD MARKINGS ON NUT DEPRESSED .010 MAX. LOCATION OPTIONAL.
7. HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBER.  
 EXAMPLE: PLT 1028-6-4.5 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. STANDARD GRIP LENGTHS ARE SHOWN IN TABLE II, 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 SHOWN IN TABLE I DO NOT APPLY.
9. STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.
10. 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.
11. 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", "V", "W" AND HEAD ANGLE DIMENSIONS.
12. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.

**Fairchild**  
 CODE IDENT. NO.  
**92215**

**MONOGRAM**  
 CODE IDENT. NO.  
**98524**

U.S. PATENT NO. 3643544, OTHER PATENTS PENDING.

APPROVED DATE  
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**STANDARD**  
**PLT 1028**  
**SHEET 2 OF 2**

REV. LETTER AND DATE  
 (K) ECN #0142  
 05-19-1989