

Printed copies are for reference only.

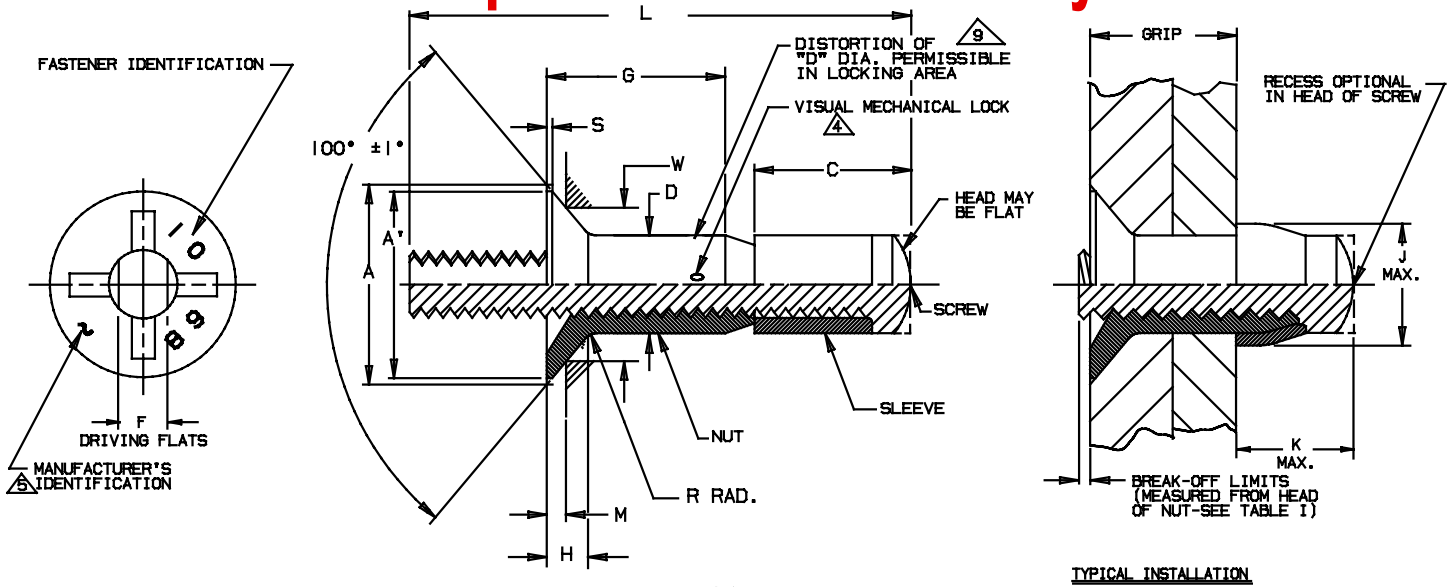


TABLE I

TYPICAL INSTALLATION

PART NUMBER	NOM. DIA.	A THEO. DIA. Δ	A' DIA. MIN. Δ	C MAX.	D DIA.	F DRIVING FLATS	H Δ REF.	J DIA. MAX.	K MAX.	M GAGE PROT.	R RAD.	S MAX.	W GAGE DIA.	BREAK-OFF LIMITS Δ	PREVAILING TORQUE IN. LBS. MIN. Δ	DOUBLE SHEAR STRENGTH LBS. MIN.	TENSILE STRENGTH LBS. MIN.
PLT 1068-6-(*)	.2290	.385 .378	.342	.364	.2300 .2280	.104 .099	.064	.315	.333	.0299 .0259	.030 .015	.015	.3147 .3143	+ .015 - .073	1.5	4600	1400
PLT 1068-8-(*)	.2900	.507 .499	.463	.398	.2910 .2890	.135 .130	.089	.401	.366	.0353 .0307	.030 .015	.015	.4245 .4241	+ .010 - .078	2.5	7900	2100
PLT 1068-10-(*)	.3415	.635 .626	.577	.482	.3425 .3405	.152 .147	.121	.442	.447	.0409 .0357	.040 .020	.020	.5389 .5385	+ .010 - .083	3.5	11350	3600
PLT 1068-12-(*)	.4045	.762 .752	.696	.567	.4055 .4035	.185 .180	.147	.531	.527	.0466 .0407	.040 .020	.023	.6532 .6528	+ .010 - .093	4.0	16450	5600

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

TABLE II

SECOND DASH NUMBER	G GRIP \blacktriangle	GRIP RANGE Δ Δ		L REF.			
		MIN.	MAX.	PLT 1068-6-(*)	PLT 1068-8-(*)	PLT 1068-10-(*)	PLT 1068-12-(*)
-	-	-	-	-	-	-	-
-2	.156	.094	.156	.853	-	-	-
-3	.219	.157	.219	.916	-	-	-
-4	.281	.220	.281	.978	1.006	1.158	1.242
-5	.344	.282	.344	1.041	1.069	1.221	1.304
-6	.406	.345	.406	1.103	1.131	1.283	1.367
-7	.469	.407	.469	1.166	1.194	1.346	1.429
-8	.531	.470	.531	1.228	1.256	1.408	1.492
-9	.594	.532	.594	1.291	1.319	1.471	1.554
-10	.656	.595	.656	1.353	1.381	1.533	1.617
-11	.719	.657	.719	1.416	1.444	1.596	1.679
-12	.781	.720	.781	1.478	1.506	1.658	1.742
-13	.844	.782	.844	1.541	1.569	1.721	1.804
-14	.906	.845	.906	1.603	1.631	1.783	1.867
-15	.969	.907	.969	1.666	1.694	1.844	1.929
-16	1.031	.970	1.031	1.728	1.756	1.908	1.992
-17	1.094	1.032	1.094	1.791	1.819	1.971	2.054
-18	1.156	1.095	1.156	1.853	1.881	2.033	2.117
-19	1.219	1.157	1.219	1.916	1.944	2.096	2.179
-20	1.281	1.220	1.281	1.978	2.006	2.158	2.242
-21	1.344	1.282	1.344	2.041	2.069	2.221	2.304
-22	1.406	1.345	1.406	2.103	2.131	2.283	2.367
-23	1.469	1.407	1.469	2.166	2.194	2.346	2.429
-24	1.531	1.470	1.531	2.228	2.257	2.408	2.492
-25	1.594	1.532	1.594	2.291	2.319	2.471	2.554
-26	1.656	1.595	1.656	2.353	2.381	2.533	2.617
-27	1.719	1.657	1.719	2.416	2.444	2.596	2.679
-28	1.781	1.720	1.781	2.478	2.506	2.658	2.742
-29	1.844	1.782	1.844	2.541	2.569	2.721	2.804
-30	1.906	1.845	1.906	2.603	2.631	2.783	2.867
-31	1.969	1.907	1.969	2.666	2.694	2.846	2.929
-32	2.031	1.970	2.031	2.728	2.756	2.908	2.992

\blacktriangle *G* TOLERANCES: FOR -5 & -6 SIZES +.030/- .010; FOR -8 & -10 SIZES +.040/- .010; FOR -12 SIZE +.050/- .010.

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

Fairchild
 CODE IDENT. NO.
92215

MONOGRAM
 CODE IDENT. NO.
98524

APPROVED DATE
 26 OCTOBER 1977

NOTICE: THIS DRAWING IS PART OF THE PROPRIETARY ARTICLE HEREIN DISCLOSED, OWNED BY MONOGRAM AEROSPACE FASTENERS. ANY PARTY BY ACCEPTING THIS DOCUMENT ASSUMES CUSTODY THEREOF AND AGREES: A. THE INFORMATION SET FORTH HEREIN IS GIVEN IN CONFIDENCE AND THIS DOCUMENT WILL NOT BE COPIED OR REPRODUCED IN WHOLE OR IN PART, NOR ITS CONTENTS REVEALED IN ANY MANNER TO ANY PERSON EXCEPT TO THE EXTENT PERMITTED BY THE PATENT OFFICE. B. WITHOUT THE WRITTEN CONSENT OF MONOGRAM AEROSPACE FASTENERS, THIS DOCUMENT AND THE INFORMATION CONTAINED HEREIN UNDER NO CIRCUMSTANCES WILL BE USED IN THE MANUFACTURE OR REPRODUCTION OF THE ARTICLE DISCLOSED, AND DELIVERY OF THIS DOCUMENT SHALL NOT CONSTITUTE ANY RIGHT OR LICENSE TO DO SO.

TITLE
VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE TITANIUM FLUSH HEAD, SELF-LOCKING 1/32" OVERSIZE

STANDARD
PLT 1068
SHEET 1 OF 2

REV. LETTER AND DATE
 © 12-09-94



PROCUREMENT SPEC. : ESCBB-9, CLASS 2, EXCEPT AS SPECIFIED HEREIN.

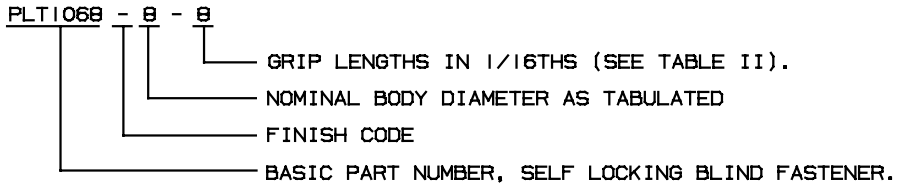
MATERIAL : NUT & SCREW : 6AL-4V TITANIUM PER AMS 4928 OR AMS 4967.
 SLEEVE : CORROSION RESISTANT STEEL.

HEAT TREAT : NUT & SCREW : HEAT TREAT PER MIL-H-81200. MAX. HYDROGEN 125 PPM.
 SLEEVE : AS REQUIRED FOR PERFORMANCE.

FINISH & "L" NUT & SCREW : NONE.
 SLEEVE : PASSIVATE PER QQ-P-35.
 "L" NUT : ALUMINUM COAT PER NAS4006.
 SCREW : NONE.
 SLEEVE : PASSIVATE PER QQ-P-35 AND ALUMINUM COAT PER NAS4006.

LUBRICANT : LUBRICANTS LISTED BELOW MAY BE APPLIED TO ANY OR ALL COMPONENTS IF REQUIRED FOR PERFORMANCE; DRY FILM LUBE MoS₂, WWM-CARBO WAX, PARAFFIN WAX, CETYL ALCOHOL.

PART CODE & EXAMPLE :



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.
7. HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBER.
 EXAMPLE: PLT 1068-6-4.5 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 TORQUE VALUES SHOWN IN TABLE I DO NOT APPLY.
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 "D" MAX. + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS.
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.

Fairchild
 CODE IDENT. NO.
92215

MONOGRAM
 CODE IDENT. NO.
98524

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

APPROVED DATE
 26 OCTOBER 1977

NOTICE: THIS DRAWING IS PART OF THE PROPRIETARY ARTICLE HEREIN DISCLOSED. OWNED BY MONOGRAM AEROSPACE FASTENERS. ANY PARTY BY ACCEPTING THIS DOCUMENT ASSUMES CUSTODY THEREOF AND AGREES:
 A. THE INFORMATION SET FORTH HEREIN IS GIVEN IN CONFIDENCE AND THIS DOCUMENT WILL NOT BE COPIED OR REPRODUCED IN WHOLE OR IN PART, NOR ITS CONTENTS REVEALED IN ANY MANNER TO ANY PERSON EXCEPT TO THE EXTENT NECESSARY FOR THE PURPOSE FOR WHICH IT WAS DELIVERED.
 B. WITHOUT THE WRITTEN CONSENT OF MONOGRAM AEROSPACE FASTENERS, THIS DOCUMENT AND THE INFORMATION CONTAINED HEREIN UNDER NO CIRCUMSTANCES WILL BE USED IN THE MANUFACTURE OR REPRODUCTION OF THE ARTICLE DISCLOSED, AND DELIVERY OF THIS DOCUMENT SHALL NOT CONSTITUTE ANY RIGHT OR LICENSE TO DO SO.

TITLE
**VISU-LOK, FASTENER, BLIND
 INTERNALLY THREADED, EXTERNAL SLEEVE
 TITANIUM
 FLUSH HEAD, SELF-LOCKING
 1/32" OVERSIZE**

STANDARD
 PLT 1068
SHEET 2 OF 2

REV. LETTER AND DATE
 © 12-09-94