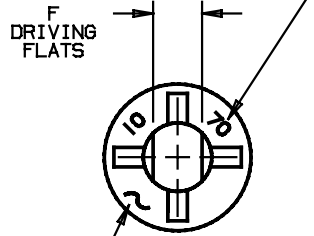


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FASTENER IDENTIFICATION



MANUFACTURERS IDENTIFICATION
 MONOGRAM = N
 VOI-SHAN = VS

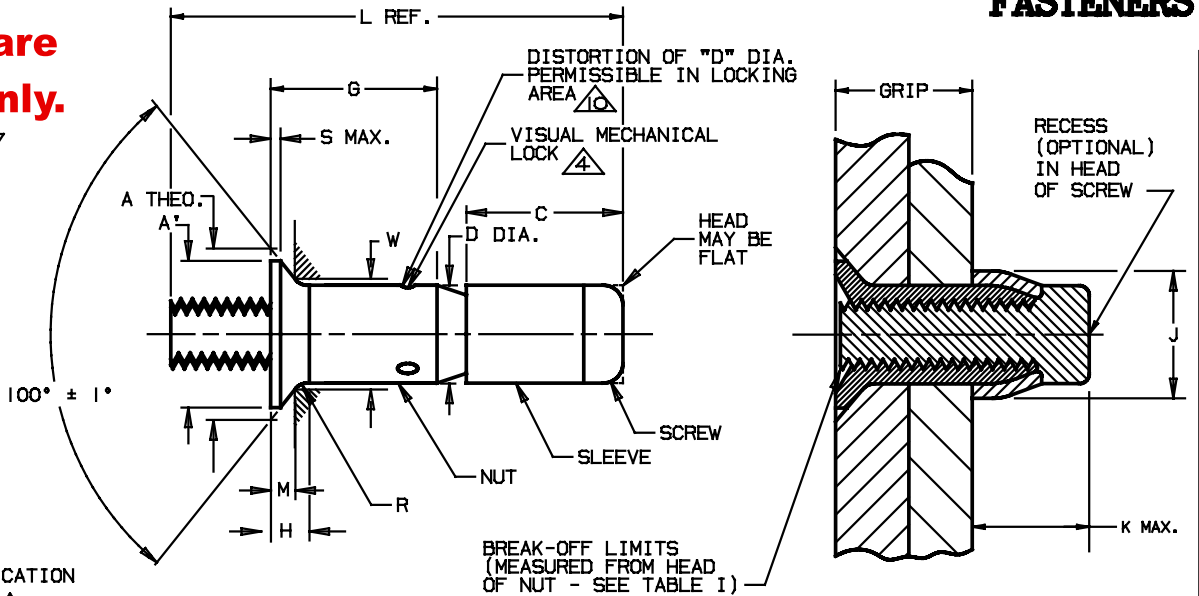


TABLE I

TYPICAL INSTALLATION

PART NUMBER	NOM. DIA.	A THEO. DIA.	A' DIA. MIN.	C MAX.	D DIA.	F DRIVING FLATS	H REF.	J DIA. MAX.	K MAX.	M GAGE PROT.	R RAD.	S MAX.	W GAGE DIA.	HOLE SIZE	BREAK-OFF LIMITS	PREVAILING TORQUE IN. LBS. MIN.	DOUBLE SHEAR STRENGTH LBS. MIN.	TENSILE STRENGTH LBS. MIN.
USE PLT 1058-6																		
PLT 1070-6-(*)	.2290	.343 .338	.311	.364	.2300 .2280	.104 .099	.047	.315	.333	.0324 .0293	.030 .015	.015	.2671 .2669	.233 .230	+.088 -.000	1.5	4600	1250
PLT 1070-8-(*)	.2900	.437 .432	.405	.398	.2910 .2890	.135 .130	.061	.401	.366	.0273 .0244	.030 .015	.015	.3731 .3729	.294 .291	+.098 -.000	2.5	7900	1900
PLT 1070-10-(*)	.3415	.505 .500	.473	.482	.3425 .3405	.152 .147	.068	.442	.447	.0312 .0281	.040 .020	.015	.4320 .4318	.346 .343	+.103 -.000	3.5	11350	3250
PLT 1070-12-(*)	.4045	.592 .587	.560	.567	.4055 .4035	.185 .180	.078	.531	.527	.0456 .0420	.040 .020	.015	.4854 .4852	.409 .406	+.103 -.000	4.0	16450	5050

(*) 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.	PLT1070						MIN.	MAX.	PLT1070			
				-6-(*)	-8-(*)	-10-(*)	-12-(*)					-6-(*)	-8-(*)	-10-(*)	-12-(*)
-	-	-	-	-	-	-	-	-17	1.094	1.032	1.094	1.874	1.944	2.096	2.242
-2	.156	.094	.156	.936	-	-	-	-18	1.156	1.095	1.156	1.936	2.006	2.158	2.304
-3	.219	.157	.219	.999	1.069	1.221	1.367	-19	1.219	1.157	1.219	1.999	2.069	2.221	2.367
-4	.281	.220	.281	1.061	1.131	1.283	1.429	-20	1.281	1.220	1.281	2.061	2.131	2.283	2.429
-5	.344	.282	.344	1.124	1.194	1.346	1.492	-21	1.344	1.282	1.344	2.124	2.194	2.346	2.492
-6	.406	.346	.406	1.186	1.256	1.408	1.554	-22	1.406	1.345	1.406	2.186	2.256	2.408	2.554
-7	.469	.407	.469	1.249	1.319	1.471	1.617	-23	1.469	1.407	1.469	2.249	2.319	2.471	2.617
-8	.531	.470	.531	1.311	1.381	1.533	1.679	-24	1.531	1.470	1.531	2.311	2.381	2.533	2.679
-9	.594	.532	.594	1.374	1.444	1.596	1.742	-25	1.594	1.532	1.594	2.374	2.444	2.596	2.742
-10	.656	.595	.656	1.436	1.506	1.658	1.804	-26	1.656	1.595	1.656	2.436	2.506	2.658	2.804
-11	.719	.657	.719	1.499	1.569	1.721	1.867	-27	1.719	1.657	1.719	2.499	2.569	2.721	2.867
-12	.781	.720	.781	1.561	1.631	1.783	1.929	-28	1.781	1.720	1.781	2.561	2.631	2.783	2.929
-13	.844	.782	.844	1.624	1.694	1.846	1.992	-29	1.844	1.782	1.844	2.624	2.694	2.846	2.992
-14	.906	.845	.906	1.686	1.756	1.908	2.054	-30	1.906	1.845	1.906	2.686	2.756	2.908	3.054
-15	.969	.907	.969	1.749	1.819	1.971	2.117	-31	1.969	1.907	1.969	2.749	2.819	2.971	3.117
-16	1.031	.970	1.031	1.811	1.881	2.033	2.179	-32	2.031	1.970	2.031	2.811	2.881	3.033	3.179

▲ "G" TOLERANCES: FOR -5 & -6 SIZES +.030/-0.10; FOR -8 & -10 SIZES +.040/-0.10; FOR -12 SIZE +.050/-0.10.

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

Fairchild
 CODE IDENT. NO.
92215

MONOGRAM
 CODE IDENT. NO.
98524

APPROVED DATE
 25 OCTOBER 1977

REV. LETTER AND DATE
 © 08-28-94

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TITLE
VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE TITANIUM 100° REDUCED FLUSH HEAD, SELF LOCKING 1/32" OVERSIZE

STANDARD
PLT 1070
SHEET 1 OF 2

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

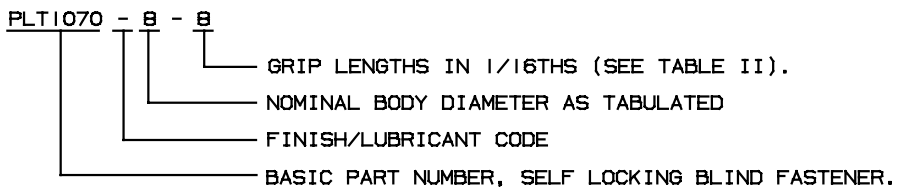
MATERIAL : NUT & SCREW : 6AL-4V TITANIUM PER AMS492B OR AMS4967.
 SLEEVE : CORROSION RESISTANT STEEL.

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

FINISH: "-" NUT & SCREW : NONE.
 △ SLEEVE : PASSIVATE PER MIL-S-5002 (QQ-P-35).
 "L" NUT : ALUMINUM COAT (.0002-.0007 THICK) PER NAS4006.
 SLEEVE : PASSIVATE PER QQ-P-35 (MIL-S-5002) ALUMINUM COAT (.0002-.0007 THICK) PER NAS 4006.
 SCREW : NONE.

LUBRICANT : LUBRICANTS LISTED BELOW MAY BE APPLIED TO ANY OR ALL COMPONENTS IF REQUIRED FOR PERFORMANCE, UNLESS OTHERWISE SPECIFIED BY FINISH CODE. DRY FILM LUBE MOS₂ PER MIL-L-46010 TYPE I OR EVERLUBE 812 PER MIL-L-81329, CETYL ALCOHOL PER MIL-L-87132 AND/OR PARAFFIN WAX.
 △

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. LOCATION OPTIONAL.
- △ 7.) STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.
- △ 8.) HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBER.
 EXAMPLE: PLT1070-6-4.5 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.
- △ 9.) 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.
- △ 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.

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**VISU-LOK, FASTENER, BLIND
 INTERNALLY THREADED, EXTERNAL SLEEVE
 TITANIUM
 100° REDUCED FLUSH HEAD, SELF LOCKING
 1/32" OVERSIZE**

STANDARD
PLT 1070
SHEET 2 OF 2

REV. LETTER AND DATE
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U.S. PATENT NO. 3643544, OTHER PATENTS PENDING.