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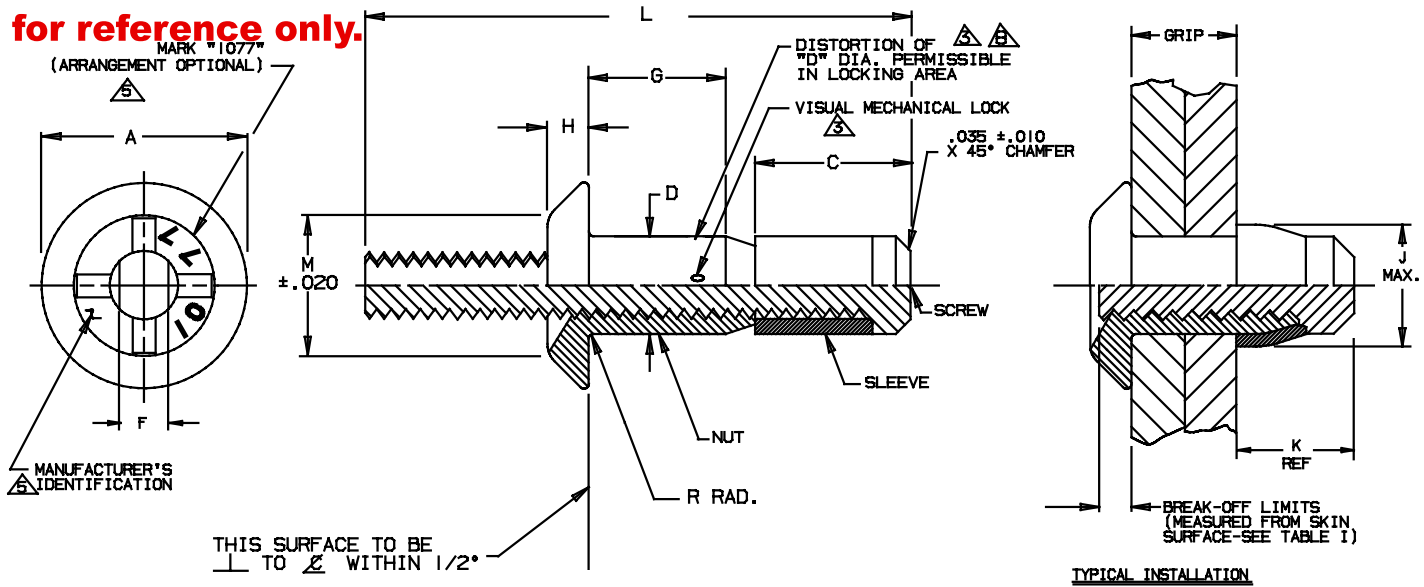


TABLE I

PART NUMBER	NOM. DIA.	A THEO. DIA.	C MAX.	D DIA.	F DRIVING FLATS	H	J DIA. MAX.	K REF.	M	R RAD.	RECOMMENDED HOLE SIZE	BREAK-OFF LIMITS	PREVAILING TORQUE IN. LBS. MIN.	DOUBLE SHEAR STRENGTH LBS. MIN.	TENSILE STRENGTH LBS. MIN.
PLT 1077-8-(*)	.2590	.416 .396	.354	.2600 .2580	.135 .130	.063 .053	.384	.325	.380 .340	.025 .015	.264 .261	+.053 -.035	2.5	9000	2100
PLT 1077-8-(4.5)	.2590	.416 .396	.354	.2600 .2580	.135 .130	.063 .053	.384	.325	.380 .340	.025 .015	.264 .261	+.073 -.035	2.5	9000	2100

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

TABLE II

SECOND DASH NUMBER	G GRIP +.040/-0.010	GRIP RANGE		L REF.	
		MIN.	MAX.	PLT 1077-8-(*)	
-	-	-	-	-	-
-3	.202	.162	.202	.966	
-4	.244	.203	.244	1.006	
-4.5	.285	.223	.285	1.026	
-5	.285	.245	.285	1.044	
-6	.320	.280	.320	1.082	
-7	.447	.407	.447	1.215	
-8	.500	.460	.500	1.270	

VOI-SHAN
CODE IDENT. NO.
92215

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

MONOGRAM
CODE IDENT. NO.
98524

APPROVED DATE
ECN #2043 09-29-80
REV. LETTER AND DATE
02-07-82

TITLE
VISU-LOK, FASTENER, BLIND
INTERNALLY THREADED, EXTERNAL SLEEVE
ALLOY STEEL
DOMED HEAD, SELF-LOCKING

STANDARD
PLT 1077-()-()
SHEET 1 OF 2

PROCUREMENT SPEC. : NAS 1675, CLASS I, EXCEPT HEAD STYLE, GRIP RANGE AND BREAK-OFF LIMITS.

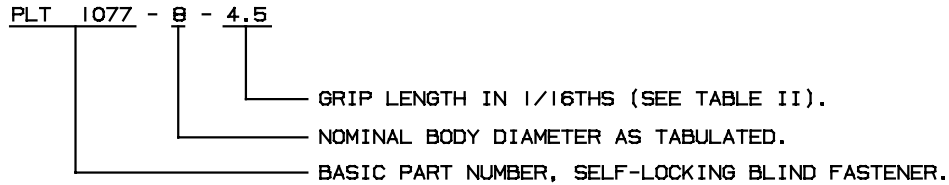
MATERIAL : NUT & SCREW : ALLOY STEEL: 4130 PER MIL-S-6758, 4140 PER MIL-S-5626 or 8740 PER MIL-S-6049.
SLEEVE : CORROSION RESISTANT STEEL: 303 or 304 PER QQ-S-763, AMS 5639 or AMS 5641.

HEAT TREAT : NUT & SCREW : HEAT TREAT PER MIL-H-6875. APPROXIMATELY 180,000-200,000 PSI TENSILE (R_c 39-43).
SLEEVE : AS REQUIRED FOR PERFORMANCE.

△ FINISH : NUT & SCREW : CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2. CADMIUM PLATE PER NAS 672 IS PERMISSIBLE PROVIDED IT IS FOLLOWED BY A DICHROMATE POST TREATMENT PER QQ-P-416.
SLEEVE : PASSIVATE PER MIL-S-5002. CADMIUM PLATE PER QQ-P-416, TYPE I, CLASS 3.

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

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.) 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.) THE PREVAILING TORQUE SHALL CONFORM TO THE VALUES AS TABULATED, WHEN TESTED IN ACCORDANCE WITH SPECIFICATION NAS 1675.
- 5.) MANUFACTURER'S IDENTIFICATION:
LETTER "N" DESIGNATES MONOGRAM/AEROSPACE FASTENERS.
LETTERS "VS" DESIGNATE VOI-SHAN.
- 6.) HEAD MARKINGS ON NUT DEPRESSED .010 MAX.
- 7.) STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.
- 8.) RECOMMENDED INSTALLATION TOOL : MPR-8A.
- 9.) MUST ENTER A .2610 HOLE WITH FINGER PRESSURE.
- 10.) MIL-S-8802 SEALANT IN FAYING SURFACES.
- 11.) HALF - GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP NUMBER.

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