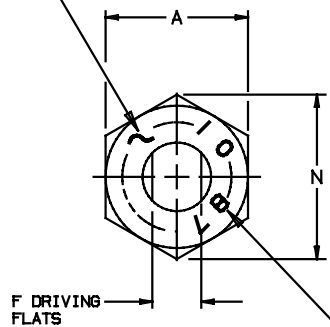
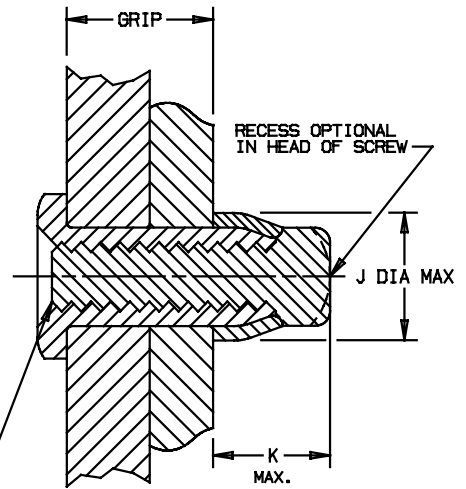
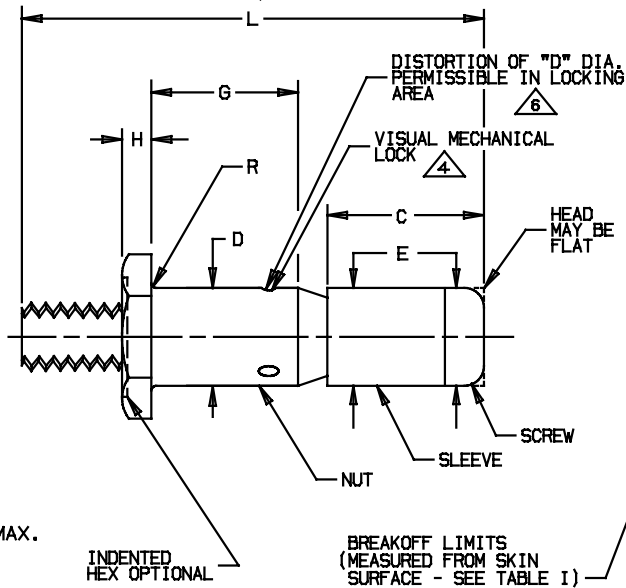


MANUFACTURERS IDENTIFICATION
 MONOGRAM = N
 VOI-SHAN = VS



FASTENER IDENTIFICATION
 HEAD MARKING DEPRESSED .010 INCH MAX.
 (POSITION OPTIONAL)



Printed copies are for reference only.

TABLE I

TYPICAL INSTALLATION

PART NUMBER	A THEO. DIA.	C MAX.	D		E DIA. MAX.	F DRIVING FLATS	H MAX.	J DIA. MAX.	K MAX.	N MIN.	R RAD.	BREAK-OFF LIMITS	PREVAILING TORQUE IN. LBS. MIN.	DOUBLE SHEAR STRENGTH LBS. MIN.	TENSILE STRENGTH LBS. MIN.
			WITHOUT COATING OR SOLID FILM LUBE	WITH COATING OR SOLID FILM LUBE											
PLT1087-5-(*)	.250 .244	.285	.1680 .1675	.1680 .1670	.1645	.086 .081	.096	.244	.257	.272	.020 .010	+ .088 + .000	1.0	3150	900
PLT1087-6-(*)	.312 .305	.320	.2025 .2020	.2025 .2015	.1990	.104 .099	.113	.300	.288	.340	.025 .015	+ .098 + .010	1.5	4600	1400
PLT1087-8-(*)	.375 .367	.355	.2635 .2630	.2635 .2625	.2600	.135 .130	.135	.384	.320	.409	.025 .015	+ .135 + .047	2.5	7900	2100
PLT1087-10-(*)	.437 .429	.440	.3150 .3145	.3150 .3140	.3115	.152 .147	.160	.427	.396	.479	.030 .015	+ .146 + .043	3.5	11350	3600
PLT1087-12-(*)	.500 .491	.525	.3780 .3775	.3780 .3770	.3745	.185 .180	.190	.516	.473	.548	.030 .015	+ .152 + .049	4.0	16450	5600

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

TABLE II

SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF.				
		MIN.	MAX.	PLT1087				
		MIN.	MAX.	-5-(*)	-6-(*)	-8-(*)	-10-(*)	-12-(*)
-1	.093	.031	.093	.733	.874	-	-	-
-2	.156	.094	.156	.795	.936	1.006	1.158	-
-3	.219	.157	.219	.858	.999	1.069	1.221	1.367
-4	.281	.220	.281	.920	1.061	1.131	1.283	1.429
-5	.344	.282	.344	.983	1.124	1.194	1.346	1.492
-6	.406	.345	.406	1.045	1.186	1.256	1.408	1.554
-7	.469	.407	.469	1.108	1.249	1.319	1.471	1.617
-8	.531	.470	.531	1.170	1.311	1.381	1.533	1.679
-9	.594	.532	.594	1.233	1.374	1.444	1.596	1.742
-10	.656	.595	.656	1.295	1.436	1.506	1.658	1.804
-11	.719	.657	.719	1.358	1.499	1.569	1.721	1.867
-12	.781	.720	.781	1.420	1.561	1.631	1.783	1.929
-13	.844	.782	.844	1.483	1.624	1.694	1.846	1.992
-14	.906	.845	.906	1.545	1.686	1.756	1.908	2.054
-15	.969	.907	.969	1.608	1.749	1.819	1.971	2.117
-16	1.031	.970	1.031	1.670	1.811	1.881	2.033	2.179
-17	1.094	1.032	1.094	1.733	1.874	1.944	2.096	2.242
-18	1.156	1.095	1.156	1.795	1.936	2.006	2.158	2.304
-19	1.219	1.157	1.219	1.858	1.999	2.069	2.221	2.367
-20	1.281	1.220	1.281	1.920	2.061	2.131	2.283	2.429
-21	1.344	1.282	1.344	1.983	2.124	2.194	2.346	2.492
-22	1.406	1.345	1.406	2.045	2.186	2.256	2.408	2.554
-23	1.469	1.407	1.469	2.108	2.249	2.319	2.471	2.617
-24	1.531	1.470	1.531	2.170	2.311	2.381	2.533	2.679
-25	1.594	1.532	1.594	2.233	2.374	2.444	2.596	2.742
-26	1.656	1.595	1.656	2.295	2.436	2.506	2.658	2.804
-27	1.719	1.657	1.719	2.358	2.499	2.569	2.721	2.867
-28	1.781	1.720	1.781	2.420	2.561	2.631	2.783	2.929
-29	1.844	1.782	1.844	2.483	2.624	2.694	2.846	2.992
-30	1.906	1.845	1.906	2.545	2.686	2.756	2.908	3.054
-31	1.969	1.907	1.969	2.608	2.749	2.819	2.971	3.117
-32	2.031	1.970	2.031	2.670	2.811	2.881	3.033	3.179

▲ "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.
5M902

MONOGRAM
 CODE IDENT. NO.
98524

APPROVED DATE
 08-15-84 ECN#3935

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 MEET 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
HEXAGONAL - PROTRUDING HEAD, SELF-LOCKING 75 KSI SHEAR, GROUND SHANK

STANDARD
PLT 1087
SHEET 1 OF 2

PROCUREMENT SPEC. : ESCBB-9, EXCEPT AS NOTED HEREIN.

MATERIAL : NUT & SCREW : 6AL-4V TITANIUM PER AMS4928 OR AMS4967.
 SLEEVE : 303 OR 304 CORROSION RESISTANT STEEL PER AMS5639 OR AMS5641 OR A-286 PER AMS5731, AMS5732 OR AMS5737.
 HEAT TREAT : NUT & SCREW : HEAT TREAT PER AMS-H-81200, HYDROGEN 125 PPM
 MAX. SLEEVE : AS REQUIRED FOR PERFORMANCE.
 FINISH: "-" NUT & SCREW : NONE. (SEE ESCBB-4 FOR SPECIAL LUBRICANTS AND FINISHES).
 9 SLEEVE : PASSIVATE PER AMS-QQ-P-35.
 "L" NUT : ALUMINUM COAT PER NAS4006.
 SLEEVE : PASSIVATE PER AMS-QQ-P-35 AND ALUMINUM COAT PER NAS4006.
 SCREW : NONE.

LUBRICANT : NUT: DRY FILM LUBRICANT PER MIL-PRF-46010 TYPE I OR EVERLUBE #812 PER MIL-PRF-81329. CETYL ALCOHOL PER MIL-PRF-87132, OPTIONAL.
 9
 SCREW & SLEEVE: DRY FILM LUBE PER MIL-PRF-46010 TYPE I OR EVERLUBE 812 PER MIL-PRF-81329, PARAFFIN WAX AND/OR CETYL ALCOHOL PER MIL-L-87132 MAY BE APPLIED AS REQUIRED FOR PERFORMANCE.

PART CODE & EXAMPLE : PLT1087 - B - B
 GRIP LENGTHS IN 1/16THS (SEE TABLE II).
 NOMINAL BODY DIAMETER AS TABULATED
 FINISH CODE
 BASIC PART NUMBER, SELF LOCKING BLIND FASTENER.

- GENERAL NOTES :
- 1.) OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT BE GREATER THAN MAXIMUM "E" DIAMETER.
 - 2.) CONCENTRICITY OF NUT HEAD "A" DIAMETER 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.) DIMENSIONS IN INCHES AND APPLY AFTER FINISH BUT PRIOR TO LUBE UNLESS OTHERWISE SPECIFIED.
 6. 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.
 7. HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBER.
 EXAMPLE: PLT 1087-6-4.5 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. THESE PARTS HAVE A CLOSE TOLERANCE (.0005 INCHES) GROUND SHANK AND ARE INTENDED FOR UP TO .0035 INCH DIAMETERICAL INTERFERENCE FIT APPLICATIONS.
 9. STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.
 10. 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.
 11. MAXIMUM "D" DIAMETER MAY BE INCREASED BY .0002 TO ALLOW FOR SOLID FILM OR ALUMINUM COATING APPLICATION.

Fairchild
 CODE IDENT. NO.
5M902

MONOGRAM
 CODE IDENT. NO.
98524

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

APPROVED DATE
 08-15-84 ECN#3935

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 MEET 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 HEXAGONAL - PROTRUDING HEAD, SELF-LOCKING 75 KSI SHEAR, GROUND SHANK

STANDARD
 PLT 1087
SHEET 2 OF 2

REV. LETTER AND DATE
 ④ ECN #3787
 06-29-06