

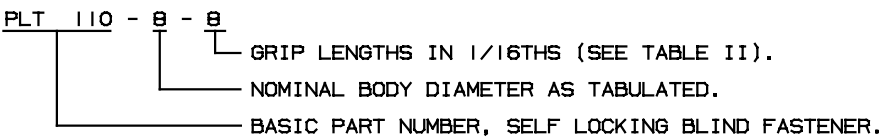
PROCUREMENT SPEC. : ESCBB2 CLASS 1.

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 (Rc 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 MoS₂ PER MIL-L-46010 TYPE I OR MIL-L-81329, WWM CARBO-WAX, PARAFFIN WAX AND/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.) CONCENTRICITY OF NUT HEAD CONICAL SURFACE TO "D" DIAMETER SHALL BE WITHIN .005 T.I.R., EXCEPT OVER INDENTATIONS.
- 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: (REFER TO NOTE 7 FOR INTERIM IDENTIFICATION) LETTER "N" DESIGNATES MONOGRAM/AEROSPACE FASTENERS. LETTERS "VS" DESIGNATE VOI-SHAN.
- 6.) HEAD MARKINGS ON NUT DEPRESSED .010 MAX.
- △ 7.) THE PRODUCT DESCRIBED BY THIS DRAWING IS "EQUIVALENT TO" AND "INTERCHANGEABLE WITH" THE MANUFACTURER'S PRODUCT LISTED BELOW EXCEPT FOR THE HEAD IDENTIFICATION MARKING. WHEN THESE EQUIVALENT FASTENERS ARE SUPPLIED, THE HEAD IDENTIFICATION MAY BE AS SHOWN BELOW: MONOGRAM... : FL164-FL375 SERIES (MARKING: "-" AND/OR "N" OVERSTAMPED "L" OR "SL" NUT MAY BE COLORED RED.) VOI-SHAN... : VA 404 SERIES (MARKING: "VS", "AV", AND "SL"; NUT HEAD MAY BE COLORED BLUE.)
- △ 8.) STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.
- △ 9.) HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.
 EXAMPLE: PLT 110-6-4.5 INDICATES A NOMINAL GRIP LENGTH OF 4.5 SIXTEENTHS = .281. THE GRIP RANGE FOR THESE HALF-GRIP SIZES WILL BE NOMINAL GRIP + .031/- .030. EXCEPT: THE GRIP RANGE FOR -1.5 GRIP SHALL BE MAX GRIP = .125", MIN GRIP = .078". THE BASIC "G" DIMENSION WILL BE NOMINAL GRIP + .031 AND THE OVERALL SCREW LENGTH "L" DIMENSION MAY VARY AT MANUFACTURER'S OPTION.
- △ 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.) 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 INCH. FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS
- △ 12.) 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.
13. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.

Fairchild
 CODE IDENT. NO.
 92215

MONOGRAM
 CODE IDENT. NO.
 98524

APPROVED DATE
 13 NOVEMBER 1970
 REV. LETTER AND DATE
 ECN#3526
 01-12-06

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TITLE
 VISU-LOK, FASTENER, BLIND
 INTERNALLY THREADED, EXTERNAL SLEEVE
 ALLOY STEEL
 100° FLUSH HEAD, SELF LOCKING

STANDARD
 PLT 110
 SHEET 2 OF 2