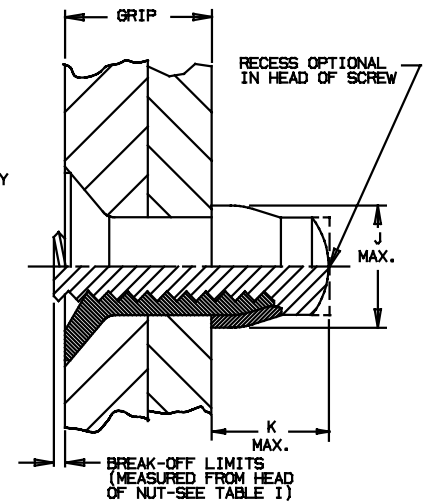
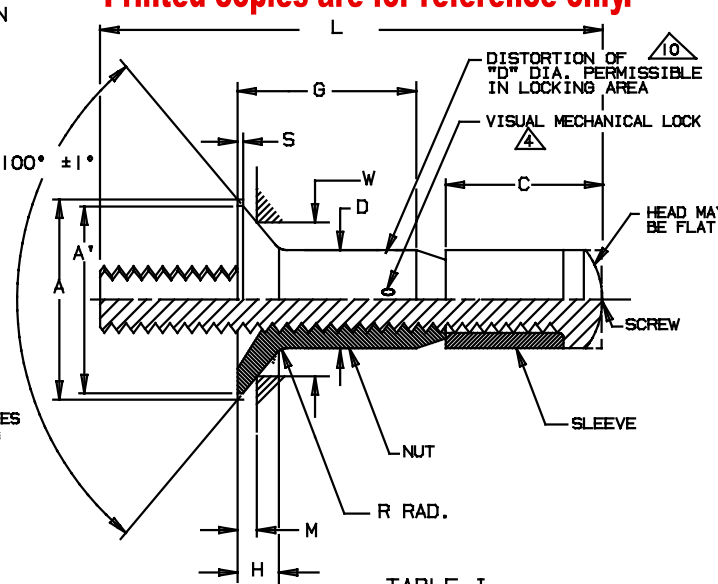
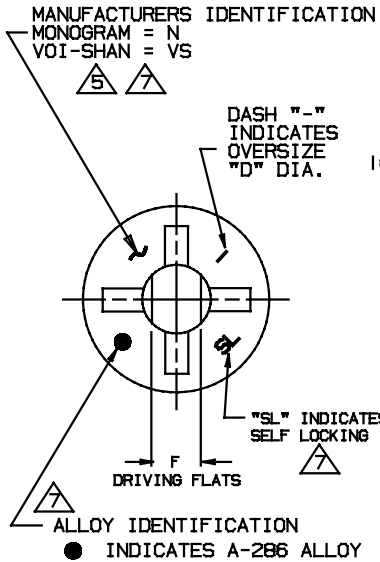


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TYPICAL INSTALLATION

TABLE I

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.
PLT 121-5-(*)	.179	.332 .325	.296	.293	.180 .178	.086 .081	.063	.244	.272	.0276 .0238	.030 .010	.012	.2671 .2667	.183 .180	+0.082 -.006	1.0	3150	900
PLT 121-6-(*)	.214	.385 .378	.342	.328	.215 .213	.104 .099	.070	.300	.312	.0299 .0259	.030 .015	.015	.3147 .3143	.218 .215	+0.072 -.016	1.5	4600	1400
PLT 121-8-(*)	.275	.507 .499	.463	.379	.276 .274	.135 .130	.096	.384	.351	.0353 .0307	.030 .015	.015	.4245 .4241	.279 .276	+0.072 -.026	2.5	7900	2100
PLT 121-10-(*)	.326	.635 .626	.577	.448	.327 .325	.152 .147	.128	.427	.426	.0409 .0357	.040 .020	.020	.5389 .5385	.376 .327	+0.072 -.031	3.5	11350	3600
PLT 121-12-(*)	.389	.762 .752	.696	.535	.390 .388	.185 .180	.154	.516	.495	.0466 .0407	.040 .020	.023	.6532 .6528	.393 .390	+0.072 -.031	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.					SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF.				
		MIN.	MAX.	PLT 121							MIN.	MAX.	PLT 121				
				-5-(*)	-6-(*)	-8-(*)	-10-(*)	-12-(*)					-5-(*)	-6-(*)	-8-(*)	-10-(*)	-12-(*)
-	-	-	-	-	-	-	-	-	-17	1.094	1.032	1.094	AVAILABLE	1.853	1.881	2.033	2.117
-2	.156	.094	.156	.795	.916	-	-	-	-18	1.156	1.095	1.156		1.916	1.944	2.096	2.179
-3	.219	.157	.219	.858	.978	1.006	1.158	-	-19	1.219	1.157	1.219		1.978	2.006	2.158	2.242
-4	.281	.220	.281	.920	1.041	1.069	1.221	1.304	-20	1.281	1.220	1.281		2.041	2.069	2.221	2.304
-5	.344	.282	.344	.983	1.103	1.131	1.283	1.367	-21	1.344	1.282	1.344		2.103	2.131	2.283	2.367
-6	.406	.345	.406	1.045	1.166	1.194	1.346	1.429	-22	1.406	1.345	1.406		2.166	2.194	2.346	2.429
-7	.469	.407	.469	1.108	1.228	1.256	1.408	1.492	-23	1.469	1.407	1.469		2.228	2.256	2.408	2.492
-8	.531	.470	.531	1.170	1.291	1.319	1.471	1.554	-24	1.531	1.470	1.531		2.291	2.319	2.471	2.554
-9	.594	.532	.594	1.233	1.353	1.381	1.533	1.617	-25	1.594	1.532	1.594		2.353	2.381	2.533	2.617
-10	.656	.595	.656	1.295	1.416	1.444	1.596	1.679	-26	1.656	1.595	1.656		2.416	2.444	2.596	2.679
-11	.719	.657	.719	1.358	1.478	1.506	1.658	1.742	-27	1.719	1.657	1.719		2.478	2.506	2.658	2.742
-12	.781	.720	.781	1.420	1.541	1.569	1.721	1.804	-28	1.781	1.720	1.781		2.541	2.569	2.721	2.804
-13	.844	.782	.844	1.483	1.603	1.631	1.783	1.867	-29	1.844	1.782	1.844		2.603	2.631	2.783	2.867
-14	.906	.845	.906	1.545	1.666	1.694	1.846	1.929	-30	1.906	1.845	1.906		2.666	2.694	2.846	2.929
-15	.969	.907	.969	1.608	1.728	1.756	1.908	1.992	-31	1.969	1.907	1.969		2.728	2.756	2.908	2.992
-16	1.031	.970	1.031	1.670	1.791	1.819	1.971	2.054	-32	2.031	1.970	2.031		2.791	2.819	2.971	3.054

▲ "G" TOLERANCES: FOR -5 & -6 SIZES +.030/-0.010; FOR -8 & -10 SIZES +.040/-0.010; FOR -12 SIZE +.050/-0.010.

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

**Fairchild**  
 CODE IDENT. NO.  
**92215**

**MONOGRAM**  
 CODE IDENT. NO.  
**98524**

APPROVED DATE  
 13 NOVEMBER 1970

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TITLE  
**VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE HIGH TEMPERATURE (A-286 ALLOY) 100° FLUSH HEAD, SELF LOCKING 1/64" OVERSIZE**

**STANDARD**  
**PLT 121**  
**SHEET 1 OF 2**

REV. LETTER AND DATE  
 03-28-94

PROCUREMENT SPEC. : ESCBB2 CLASS 2.

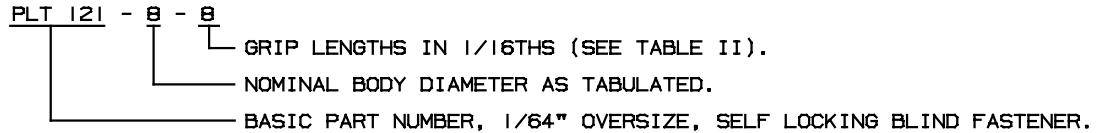
MATERIAL : NUT & SCREW  
 SLEEVE : CORROSION RESISTANT STEEL, TYPE A-286 PER AMS 5731, AMS 5732 OR AMS 5737.

HEAT TREAT : NUT & SCREW SOLUTION HEAT TREATED AND AGED TO A HARDNESS OF Rc 30 TO Rc 45. ALL CORE HARDNESS READINGS ARE TAKEN ON MOUNTED SPECIMEN, USING A BRALE PENETRATOR AND A 30 Kg LOAD (ROCKWELL 30N).  
 SLEEVE : SOLUTION TREATED.

△ FINISH : NUT & SCREW  
 SLEEVE : PASSIVATE PER MIL-S-5002 (QQ-P-35).

△ LUBRICANT: LUBRICANTS LISTED BELOW MAY BE APPLIED TO ANY OR ALL COMPONENTS IF REQUIRED FOR FASTENER PERFORMANCE: DRY FILM LUBE MoS<sub>2</sub> 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; 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 COLOR IDENTIFICATION, HEAD MARKING AND SELF-LOCKING FEATURE. EXISTING STOCK MAY BE REWORKED TO COLOR AND HEAD MARKING MAY BE AS SHOWN BELOW:  
 MONOGRAM... : FLO164ALS-FL0375ALS SERIES (MARKING: "X", "-" AND ".", OVERSTAMPED "L" OR "SL").  
 VOI-SHAN... : VA 406 SERIES (MARKING: "VS", "O", "V" AND "SL", MAY BE COLORED GOLD).
- △ 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 121-6-4.5 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.
- △ 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 MAXIMUM "D" + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS
- △ 11. 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.
- △ 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.

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

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