



CUSTODIAN: ENGINEERING STANDARD COMMITTEE FOR BLIND BOLTS
 3423 SOUTH GARFIELD AVENUE
 LOS ANGELES, CALIFORNIA 90040



Printed copies are for reference only.

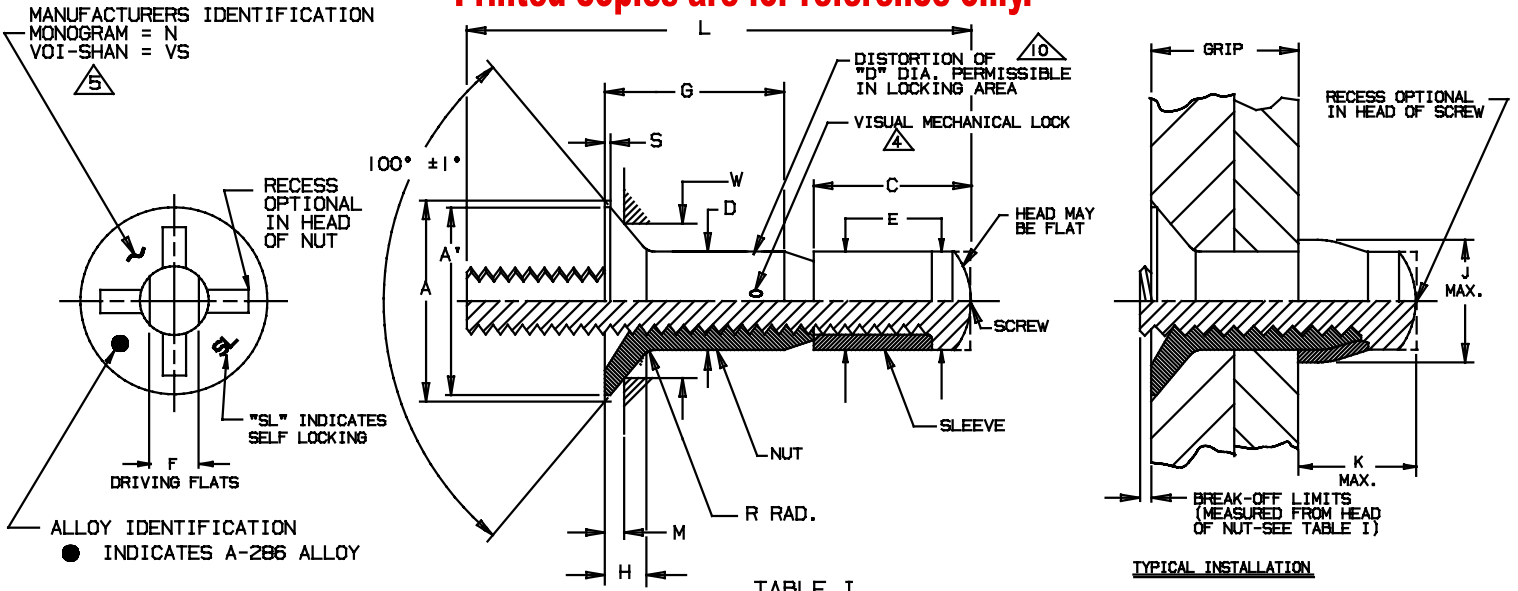


TABLE I

PART NUMBER	NOM. DIA.	A. THEO. DIA.	A' DIA. MIN.	C MAX.	D DIA.	E DIA. MAX.	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 124-5-(*)	.1640	.332 .325	.296	.285	.1645 .1635	.1625	.086 .081	.069	.244	.257	.0276 .0238	.030 .010	.012	.2671 .2667	.1680 .1650	+ .082 - .006	1.0	3150	900
PLT 124-6-(*)	.2021	.385 .378	.342	.320	.2026 .2016	.1980	.104 .099	.077	.300	.288	.0299 .0259	.030 .015	.015	.3147 .3143	.2060 .2030	+ .072 - .016	1.5	4600	1400
PLT 124-8-(*)	.2645	.507 .499	.463	.355	.2651 .2641	.2590	.135 .130	.102	.384	.325	.0353 .0307	.030 .015	.015	.4245 .4241	.2685 .2655	+ .072 - .026	2.5	7900	2100
PLT 124-10-(*)	.3115	.635 .626	.577	.440	.3120 .3110	.3095	.152 .147	.134	.427	.396	.0409 .0357	.040 .020	.020	.5389 .5385	.3150 .3120	+ .072 - .031	3.5	11350	3600
PLT 124-12-(*)	.3740	.762 .752	.696	.525	.3745 .3735	.3725	.185 .180	.160	.516	.473	.0466 .0407	.040 .020	.023	.6532 .6528	.3780 .3750	+ .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 124							MIN.	MAX.	PLT 124				
				-5-(*)	-6-(*)	-8-(*)	-10-(*)	-12-(*)					-5-(*)	-6-(*)	-8-(*)	-10-(*)	-12-(*)
-	-	-	-	-	-	-	-	-	-17	1.094	1.032	1.094	NOT AVAILABLE IN -5 DIAMETER	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. 364.3544, OTHER PATENTS PENDING.

Fairchild
 CODE IDENT. NO.
92215

MONOGRAM
 CODE IDENT. NO.
98524

APPROVED DATE
 29 JANUARY 1979
 REV. LETTER AND DATE
 ⑥ 06-02-94

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 HIGH TEMPERATURE (A-286 ALLOY) 100° FLUSH HEAD, SELF LOCKING GROUND SHANK

STANDARD
PLT 124
SHEET 1 OF 2



PROCUREMENT SPEC. : ESCBB-2 CLASS 2, EXCEPT AS SPECIFIED HEREIN.

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

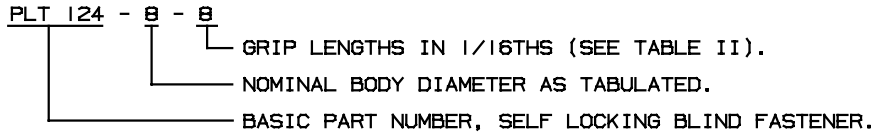
HEAT TREAT : NUT & SCREW SOLUTION HEAT TREATED AND AGED TO A HARDNESS OF Rc 30 TO Rc 45. ALL CORE HARDNESS READINGS ARE TAKEN ON MOUNTED SPECIMEN, USING A BRALE PENETRATOR AND A 30 Kg LOAD (ROCKWELL 30N).

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 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: 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 NUMBERS.
 EXAMPLE: PLT 124-6-4.5 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.) GROUND SHANK VISU-LOKS SHOULD NOT BE USED, EXCEPT WITH CONSIDERABLE CAUTION, IN APPLICATIONS WHICH EXCEED APPROXIMATELY .0005 INTERFERENCE FIT. GROUND SHANK VISU-LOKS WILL PERFORM SATISFACTORILY WHEN INSTALLED IN THE TABULATED HOLE SIZES.
- 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.

Fairchild
 CODE IDENT. NO.
92215

MONOGRAM
 CODE IDENT. NO.
98524

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

APPROVED DATE
 29 JANUARY 1979

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 HIGH TEMPERATURE (A-286 ALLOY) 100° FLUSH HEAD, SELF LOCKING GROUND SHANK

STANDARD
PLT 124
SHEET 2 OF 2

REV. LETTER AND DATE
 (B) 08-02-94