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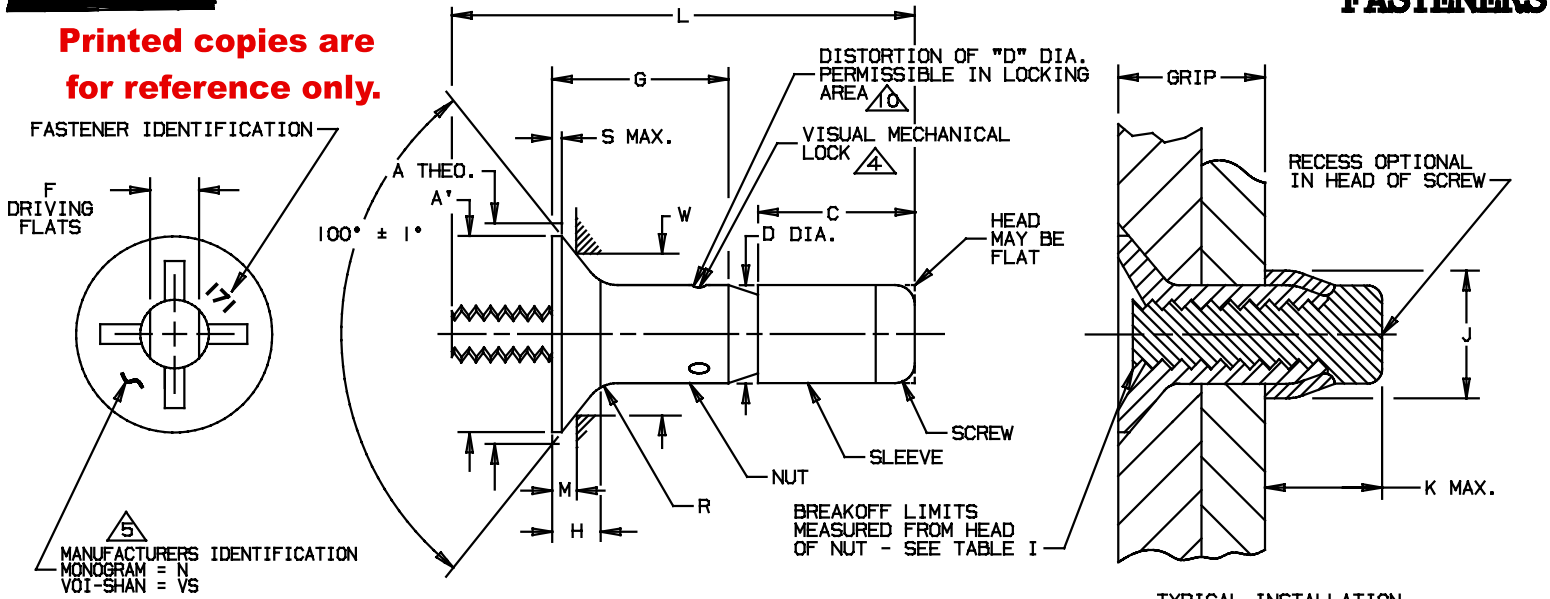


TABLE I

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 171-5-(*)	.179	.332 .325	.296	.315	.1800 .1780	.086 .081	.063	.244	.300	.0276 .0238	.030 .010	.012	.2671 .2667	.183 .180	+0.020 -.069	1.0	3150	900
PLT 171-6-(*)	.214	.395 .378	.342	.350	.2150 .2130	.104 .099	.070	.300	.333	.0299 .0259	.030 .015	.015	.3147 .3143	.218 .215	+0.015 -.073	1.5	4600	1400
PLT 171-8-(*)	.275	.507 .499	.463	.385	.2760 .2740	.135 .130	.096	.384	.366	.0353 .0307	.030 .015	.015	.4245 .4241	.279 .276	+0.010 -.078	2.5	7900	2100
PLT 171-10-(*)	.326	.635 .626	.577	.470	.3270 .3250	.152 .147	.128	.427	.447	.0409 .0357	.040 .020	.020	.5389 .5385	.330 .327	+0.010 -.083	3.5	11350	3600
PLT 171-12-(*)	.389	.752 .752	.696	.555	.3900 .3880	.185 .180	.154	.516	.527	.0466 .0407	.040 .020	.023	.6532 .6528	.393 .390	+0.010 -.093	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 171							MIN.	MAX.	PLT 171				
				-5-(*)	-6-(*)	-8-(*)	-10-(*)	-12-(*)					-5-(*)	-6-(*)	-8-(*)	-10-(*)	-12-(*)
-	-	-	-	-	-	-	-	-	-17	1.094	1.032	1.094	AVAILABLE IN -5 DIAMETER	1.791	1.819	1.971	2.054
-2	.156	.094	.156	.733	.853	-	-	-	-18	1.156	1.095	1.156		1.853	1.881	2.033	2.117
-3	.219	.157	.219	.795	.916	.944	-	-	-19	1.219	1.157	1.219		1.916	1.944	2.096	2.179
-4	.281	.220	.281	.858	.978	1.006	1.158	1.242	-20	1.281	1.220	1.281		1.978	2.006	2.158	2.242
-5	.344	.282	.344	.920	1.041	1.069	1.221	1.304	-21	1.344	1.282	1.344		2.041	2.069	2.221	2.304
-6	.406	.345	.406	.983	1.103	1.131	1.283	1.367	-22	1.406	1.345	1.406		2.103	2.131	2.283	2.367
-7	.469	.407	.469	1.045	1.166	1.194	1.346	1.429	-23	1.469	1.407	1.469		2.166	2.194	2.346	2.429
-8	.531	.470	.531	1.108	1.228	1.256	1.408	1.492	-24	1.531	1.470	1.531		2.228	2.256	2.408	2.492
-9	.594	.532	.594	1.170	1.291	1.319	1.471	1.554	-25	1.594	1.532	1.594		2.291	2.319	2.471	2.554
-10	.656	.595	.656	1.233	1.353	1.381	1.533	1.617	-26	1.656	1.595	1.656		2.353	2.381	2.533	2.617
-11	.719	.657	.719	1.295	1.416	1.444	1.596	1.679	-27	1.719	1.657	1.719		2.416	2.444	2.596	2.679
-12	.781	.720	.781	1.358	1.478	1.506	1.658	1.742	-28	1.781	1.720	1.781		2.478	2.506	2.658	2.742
-13	.844	.782	.844	1.420	1.541	1.569	1.721	1.804	-29	1.844	1.782	1.844		2.541	2.569	2.721	2.804
-14	.906	.845	.906	1.483	1.603	1.631	1.783	1.867	-30	1.906	1.845	1.906		2.603	2.631	2.783	2.867
-15	.969	.907	.969	1.545	1.666	1.694	1.846	1.929	-31	1.969	1.907	1.969		2.666	2.694	2.846	2.929
-16	1.031	.970	1.031	1.608	1.728	1.756	1.908	1.992	-32	2.031	1.970	2.031		2.728	2.756	2.908	2.992

▲ "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.
92215

MONOGRAM
 CODE IDENT. NO.
98524

APPROVED DATE
 6 APRIL 1976

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TITLE
**VISU-LOK, FASTENER, BLIND
 INTERNALLY THREADED, EXTERNAL SLEEVE
 TITANIUM
 100° FLUSH HEAD, SELF LOCKING
 1/64" OVERSIZE**

STANDARD
PLT 171
SHEET 1 OF 2

PROCUREMENT SPEC. : ESCBB-9, CLASS 2, EXCEPT AS NOTED HEREIN.

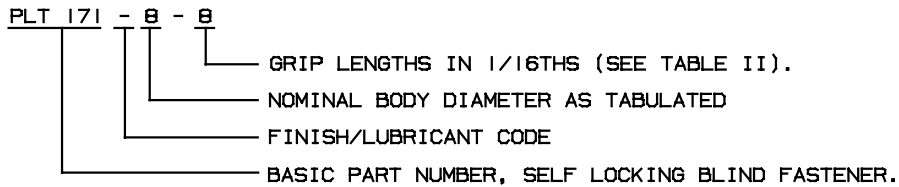
MATERIAL : NUT & SCREW : 6AL-4V TITANIUM PER AMS4928 OR AMS4967.
 SLEEVE : CORROSION RESISTANT STEEL.

HEAT TREAT : NUT & SCREW : HEAT TREAT PER MIL-H-81200 MAX. HYDROGEN 125 PPM.
 SLEEVE : AS REQUIRED FOR PERFORMANCE.

FINISH: "-" NUT & SCREW : NONE.
 SLEEVE : PASSIVATE PER MIL-S-5002 (QQ-P-35).
 "L" NUT : ALUMINUM COAT PER NAS4006.
 SLEEVE : PASSIVATE PER MIL-S-5002 (QQ-P-35) AND ALUMINUM COAT PER NAS4006.
 SCREW : NONE.

LUBRICANT : LUBRICANTS LISTED BELOW MAY BE APPLIED TO ANY OR ALL COMPONENTS IF REQUIRED FOR PERFORMANCE :
 DRY FILM LUBE MOS₂ PER MIL-L-46010 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 "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.) 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 NUMBER.
 EXAMPLE: PLT 171-6-4.5 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.) 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.
 - 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 "D" MAX. + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS.
 - 11.) 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.
 12. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.

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

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STANDARD
PLT 171
SHEET 2 OF 2

REV. LETTER AND DATE
 05-09-94