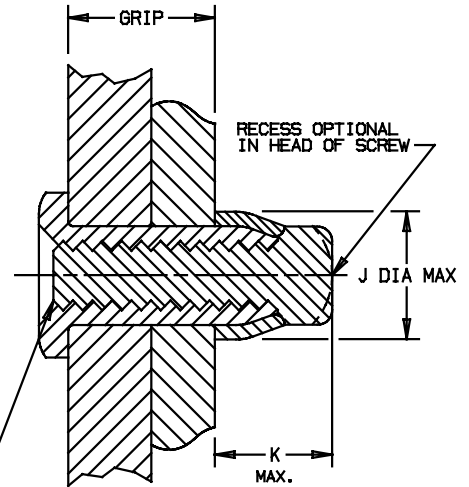
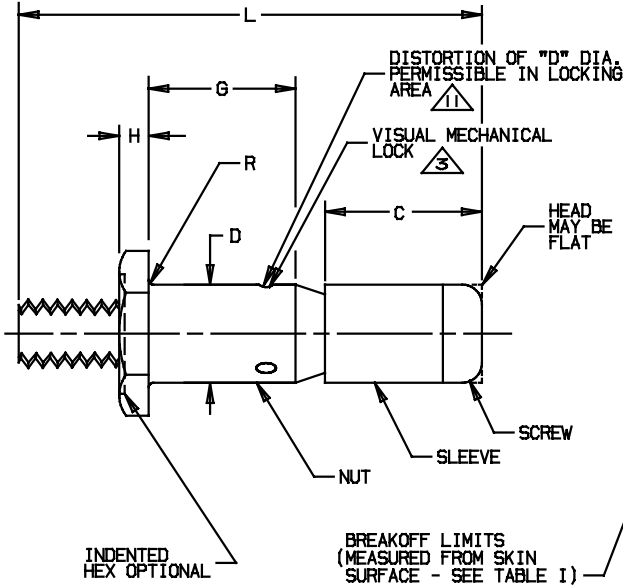
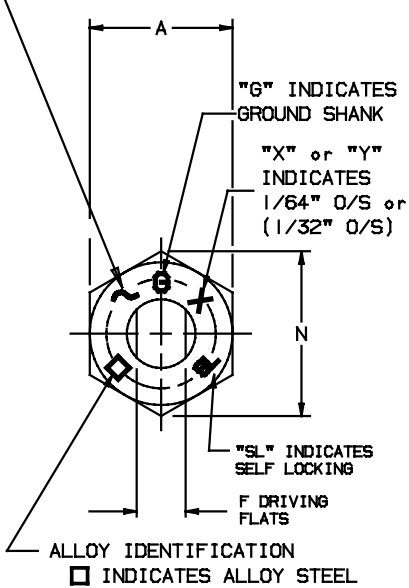


Printed copies are for reference only.

MANUFACTURERS IDENTIFICATION

MONOGRAM = N
 VOI-SHAN = VS



TYPICAL INSTALLATION

TABLE I

PART NUMBER	NOM. DIA.	A	C MAX.	D DIA.	F DRIVING FLATS	H MAX.	J DIA. MAX.	K MAX.	N MIN.	R RAD.	HOLE SIZE	BREAK-OFF LIMITS	PREVAILING TORQUE IN. LBS. MIN.		DOUBLE SHEAR STRENGTH LBS. MIN.	TENSILE STRENGTH LBS. MIN.
													1	2		
PLT 214-5-(*)	.1640	.250 .244	.268	.1645 .1635	.086 .081	.096	.244	.246	.272	.020 .010	.1680 .1650	+0.088 +0.000	1.0	3355	900	
PLT 214-5-(*)X	.1795	.250 .244	.293	.1800 .1790	.086 .081	.096	.244	.272	.272	.020 .010	.1830 .1800	+0.088 +0.000	1.0	3355	900	
PLT 214-6-(*)	.2021	.312 .305	.303	.2026 .2016	.104 .099	.113	.300	.281	.340	.025 .015	.2060 .2030	+0.098 +0.010	1.5	5240	1400	
PLT 214-6-(*)X	.2145	.312 .305	.328	.2150 .2140	.104 .099	.113	.300	.312	.340	.025 .015	.2180 .2150	+0.098 +0.010	1.5	5240	1400	
PLT 214-6-(*)Y	.2295	.312 .305	.360	.2300 .2290	.104 .099	.113	.315	.334	.340	.025 .015	.2330 .2300	+0.098 +0.010	1.5	5240	1400	
PLT 214-8-(*)	.2645	.375 .367	.354	.2651 .2641	.135 .130	.135	.384	.325	.409	.025 .015	.2685 .2655	+1.135 +0.047	2.5	9000	2100	
PLT 214-8-(*)x	.2755	.375 .367	.379	.2760 .2750	.135 .130	.135	.384	.351	.409	.025 .015	.2790 .2760	+1.135 +0.047	2.5	9000	2100	
PLT 214-8-(*)Y	.2905	.375 .367	.404	.2910 .2900	.135 .130	.135	.401	.375	.409	.025 .015	.2940 .2910	+1.135 +0.047	2.5	9000	2100	
PLT 214-10-(*)	.3115	.437 .429	.423	.3120 .3110	.152 .147	.160	.427	.390	.479	.030 .015	.3150 .3120	+1.146 +0.043	3.5	12000	3600	
PLT 214-10-(*)X	.3265	.437 .429	.448	.3270 .3260	.152 .147	.160	.427	.426	.479	.030 .015	.3300 .3270	+1.146 +0.043	3.5	12000	3600	
PLT 214-10-(*)Y	.3420	.437 .429	.493	.3425 .3415	.152 .147	.160	.442	.460	.479	.030 .015	.3460 .3430	+1.146 +0.043	3.5	12000	3600	
PLT 214-12-(*)	.3740	.500 .491	.510	.3745 .3735	.185 .180	.190	.516	.470	.548	.030 .015	.3780 .3750	+1.152 +0.049	4.0	19500	5600	
PLT 214-12-(*)X	.3895	.500 .491	.535	.3900 .3890	.185 .180	.190	.516	.495	.548	.030 .015	.3930 .3900	+1.152 +0.049	4.0	19500	5600	
PLT 214-12-(*)Y	.4050	.500 .491	.583	.4055 .4045	.185 .180	.190	.531	.543	.548	.030 .015	.4090 .4060	+1.152 +0.049	4.0	19500	5600	

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

Fairchild
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5M902

▲ "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.

MONOGRAM
 CODE IDENT. NO.
98524

APPROVED DATE
 25 OCTOBER 1971

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TITLE
VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE ALLOY STEEL PROTRUDING HEX HEAD, SELF LOCKING GROUND SHANK

STANDARD
PLT 214
 SHEET 1 OF 3

REV. LETTER AND DATE
 (C) EDN #0670 02-14-01

TABLE II

SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF.					SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF.				
		9	12	PLT 214							PLT 214						
		MIN.	MAX.	-5-(*)	-6-(*)	-8-(*)	-10-(*)	-12-(*)			-5-(*)	-6-(*)	-8-(*)	-10-(*)	-12-(*)		
-1	.093	.031	.093	.733	.874	-	-	-	-17	1.094	1.032	1.094	NOT	1.874	1.944	2.096	2.179
-2	.156	.094	.156	.795	.936	1.006	1.158	-	-18	1.156	1.095	1.156	NOT	1.936	2.006	2.158	2.242
-3	.219	.157	.219	.858	.999	1.069	1.221	1.304	-19	1.219	1.157	1.219	NOT	1.999	2.069	2.221	2.304
-4	.281	.220	.281	.920	1.061	1.131	1.283	1.367	-20	1.281	1.220	1.281	AVAILABLE	2.061	2.131	2.283	2.367
-5	.344	.282	.344	.983	1.124	1.194	1.346	1.429	-21	1.344	1.282	1.344	AVAILABLE	2.124	2.194	2.346	2.429
-6	.406	.345	.406	1.045	1.186	1.256	1.408	1.492	-22	1.406	1.345	1.406	AVAILABLE	2.186	2.256	2.408	2.492
-7	.469	.407	.469	1.108	1.249	1.319	1.471	1.554	-23	1.469	1.407	1.469	IN	2.249	2.319	2.471	2.554
-8	.531	.470	.531	1.170	1.311	1.381	1.533	1.617	-24	1.531	1.470	1.531	IN	2.311	2.381	2.533	2.617
-9	.594	.532	.594	1.233	1.374	1.444	1.596	1.679	-25	1.594	1.532	1.594	-5	2.374	2.444	2.596	2.679
-10	.656	.595	.656	1.295	1.436	1.506	1.658	1.742	-26	1.656	1.595	1.656	-5	2.436	2.506	2.658	2.742
-11	.719	.657	.719	1.358	1.499	1.569	1.721	1.804	-27	1.719	1.657	1.719	DIAMETER	2.499	2.569	2.721	2.804
-12	.781	.720	.781	1.420	1.561	1.631	1.783	1.867	-28	1.781	1.720	1.781	DIAMETER	2.561	2.631	2.783	2.867
-13	.844	.782	.844	1.483	1.624	1.694	1.846	1.929	-29	1.844	1.782	1.844	DIAMETER	2.624	2.694	2.846	2.929
-14	.906	.845	.906	1.545	1.686	1.756	1.908	1.992	-30	1.906	1.845	1.906	DIAMETER	2.686	2.756	2.908	2.992
-15	.969	.907	.969	1.608	1.749	1.819	1.971	2.054	-31	1.969	1.907	1.969	DIAMETER	2.749	2.819	2.971	3.054
-16	1.031	.970	1.031	1.670	1.811	1.881	2.033	2.117	-32	2.031	1.970	2.031	DIAMETER	2.811	2.881	3.033	3.117

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

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 : W/M 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, W/M CARBO-WAX, PARAFFIN WAX AND/OR CETYL ALCOHOL PER MIL-L-87132.

Fairchild
 CODE IDENT. NO.
5M902

▲ *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.

MONOGRAM
 CODE IDENT. NO.
98524

APPROVED DATE
 25 OCTOBER 1971

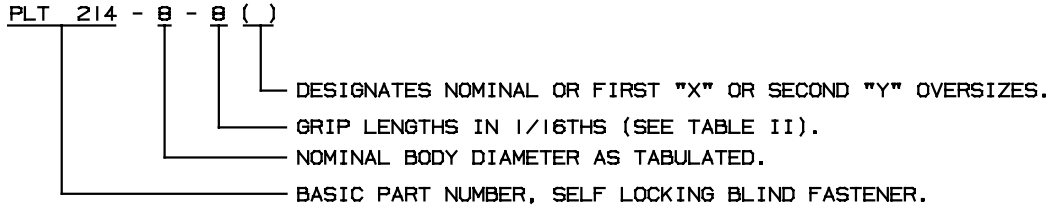
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TITLE
VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE ALLOY STEEL PROTRUDING HEX HEAD, SELF LOCKING GROUND SHANK

STANDARD
PLT 214
SHEET 2 OF 3

REV. LETTER AND DATE
 (B) EDN #0870 02-14-01

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.) REMOVE ALL LOOSE OR HANGING BURRS.
3. 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).
4. THE PREVAILING TORQUE SHALL CONFORM TO THE VALUES AS TABULATED, WHEN TESTED IN ACCORDANCE WITH SPECIFICATION ESCBB-2. HOWEVER, PREVAILING TORQUES FOR THE PLT214-5-1 AND PLT214-6-1 SHALL BE RECORDED THRU A ROTATION OF ONLY 360° OF THE NUT.
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., LOCATION OPTIONAL.
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 INCORPORATE THE LOCK. WHEN THESE REWORKED FASTENERS ARE SUPPLIED, THE HEAD IDENTIFICATION MAY BE AS SHOWN BELOW :
 MONOGRAM... : PPG164-PPG375 SERIES (MARKING: "-" AND/OR "N" OVERSTAMPED "L" OR "SL").
 VOI-SHAN... : BAGAH SERIES (MARKING: "VS", "AG" AND "SL"; NUT HEAD MAY BE COLORED ORANGE).
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 214-6-4.5 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. 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.
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 MAXIMUM "D" + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS.
12. 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.
13. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.

Fairchild
 CODE IDENT. NO.
 5M902

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TITLE
 VISU-LOK, FASTENER, BLIND
 INTERNALLY THREADED, EXTERNAL SLEEVE
 ALLOY STEEL
 PROTRUDING HEX HEAD, SELF LOCKING
 GROUND SHANK

STANDARD
 PLT 214
 SHEET 3 OF 3

REV. LETTER AND DATE
 (C) ECN #0970 02-14-01