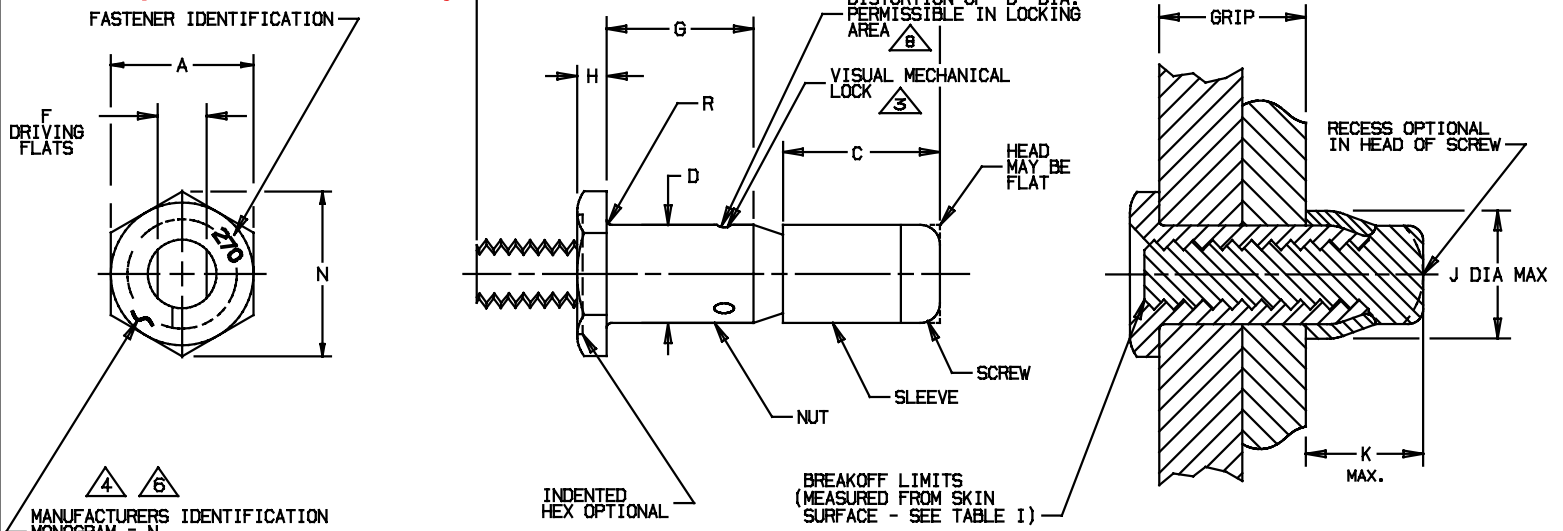


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TYPICAL INSTALLATION

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.
PLT 270-5-(*)	.1635	.250 .244	.265	.1645 .1625	.086 .081	.096	.244	.257	.272	.020 .010	.168 .165	+0.088 +0.000	1.0	3150	900
PLT 270-6-(*)	.1980	.312 .305	.320	.1990 .1970	.104 .099	.113	.300	.268	.340	.025 .015	.202 .199	+0.088 +0.010	1.5	4600	1400
PLT 270-8-(*)	.2590	.375 .367	.355	.2600 .2580	.135 .130	.135	.384	.320	.409	.025 .015	.263 .260	+1.135 +0.047	2.5	7900	2100
PLT 270-10-(*)	.3105	.437 .429	.440	.3115 .3095	.152 .147	.160	.427	.396	.479	.030 .015	.315 .312	+1.146 +0.043	3.5	11350	3600
PLT 270-12-(*)	.3735	.500 .491	.525	.3745 .3725	.185 .180	.190	.516	.473	.548	.030 .015	.378 .375	+1.152 +0.049	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 270							MIN.	MAX.	PLT 270				
				-5-(*)	-6-(*)	-8-(*)	-10-(*)	-12-(*)					-5-(*)	-6-(*)	-8-(*)	-10-(*)	-12-(*)
-1	.093	.031	.093	.733	.874	-	-	-	-17	1.094	1.032	1.094	NOT AVAILABLE	1.874	1.944	2.096	2.242
-2	.156	.094	.156	.795	.936	1.006	1.158	-	-18	1.156	1.095	1.156		1.936	2.006	2.158	2.304
-3	.219	.157	.219	.858	.999	1.069	1.221	1.367	-19	1.219	1.157	1.219		1.999	2.069	2.221	2.367
-4	.281	.220	.281	.920	1.061	1.131	1.283	1.429	-20	1.281	1.220	1.281		2.061	2.131	2.283	2.429
-5	.344	.282	.344	.983	1.124	1.194	1.346	1.492	-21	1.344	1.282	1.344	AVAILABLE IN	2.124	2.194	2.346	2.492
-6	.406	.345	.406	1.045	1.186	1.256	1.408	1.554	-22	1.406	1.345	1.406		2.186	2.256	2.408	2.554
-7	.469	.407	.469	1.108	1.249	1.319	1.471	1.617	-23	1.469	1.407	1.469	-5 DIAMETER	2.249	2.319	2.471	2.617
-8	.531	.470	.531	1.170	1.311	1.381	1.533	1.679	-24	1.531	1.470	1.531		2.311	2.381	2.533	2.679
-9	.594	.532	.594	1.233	1.374	1.444	1.596	1.742	-25	1.594	1.532	1.594		2.374	2.444	2.596	2.742
-10	.656	.595	.656	1.295	1.436	1.506	1.658	1.804	-26	1.656	1.595	1.656		2.436	2.506	2.658	2.804
-11	.719	.657	.719	1.358	1.499	1.569	1.721	1.867	-27	1.719	1.657	1.719	2.499	2.569	2.721	2.867	
-12	.781	.720	.781	1.420	1.561	1.631	1.783	1.929	-28	1.781	1.720	1.781		2.561	2.631	2.783	2.929
-13	.844	.782	.844	1.483	1.624	1.694	1.846	1.992	-29	1.844	1.782	1.844	2.624	2.694	2.846	2.992	
-14	.906	.845	.906	1.545	1.686	1.756	1.908	2.054	-30	1.906	1.845	1.906	2.686	2.756	2.908	3.054	
-15	.969	.907	.969	1.608	1.749	1.819	1.971	2.117	-31	1.969	1.907	1.969	2.749	2.819	2.971	3.117	
-16	1.031	.970	1.031	1.670	1.811	1.881	2.033	2.179	-32	2.031	1.970	2.031	2.811	2.881	3.033	3.179	

*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
 06 APRIL 1976

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TITLE
VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE TITANIUM PROTRUDING HEX HEAD, SELF LOCKING 75 KSI SHEAR

STANDARD
PLT 270
SHEET 1 OF 2

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

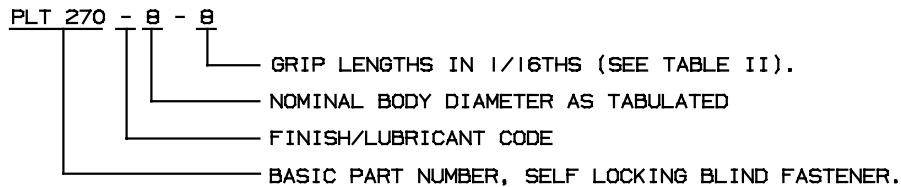
MATERIAL : NUT & SCREW : 6AL-4V TITANIUM PER AMS4928 OR AMS4967.
 SLEEVE : CORROSION RESISTANT STEEL.

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.) 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.) MANUFACTURER'S IDENTIFICATION:
 LETTER "N" DESIGNATES MONOGRAM AEROSPACE FASTENERS.
 LETTERS "VS" DESIGNATE VOI-SHAN.
 - 5.) HEAD MARKINGS ON NUT DEPRESSED .010 MAX. LOCATION OPTIONAL.
 - 6.) STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.
 - 7.) HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBER.
 EXAMPLE: PLT 270-6-4.5 INDICATES A NOMINAL GRIP LENGTH OF 4.5 SIXTEENTHS = .281.
 THE GRIP RANGE FOR THESE HALF-GRIP SIZES WILL BE NOMINAL GRIP + .031/-0.030.
 THE BASIC "G" DIMENSION WILL BE NOMINAL GRIP + .031 AND THE OVERALL SCREW LENGTH "L" DIMENSION MAY VARY AT MANUFACTURER'S OPTION.
 - 8.) 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.
 - 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. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.

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TITLE
**VISU-LOK, FASTENER, BLIND
 INTERNALLY THREADED, EXTERNAL SLEEVE
 TITANIUM
 PROTRUDING HEX HEAD, SELF LOCKING
 75 KSI SHEAR**

STANDARD
PLT 270
SHEET 2 OF 2

REV. LETTER AND DATE
 ⑤ 05-12-94