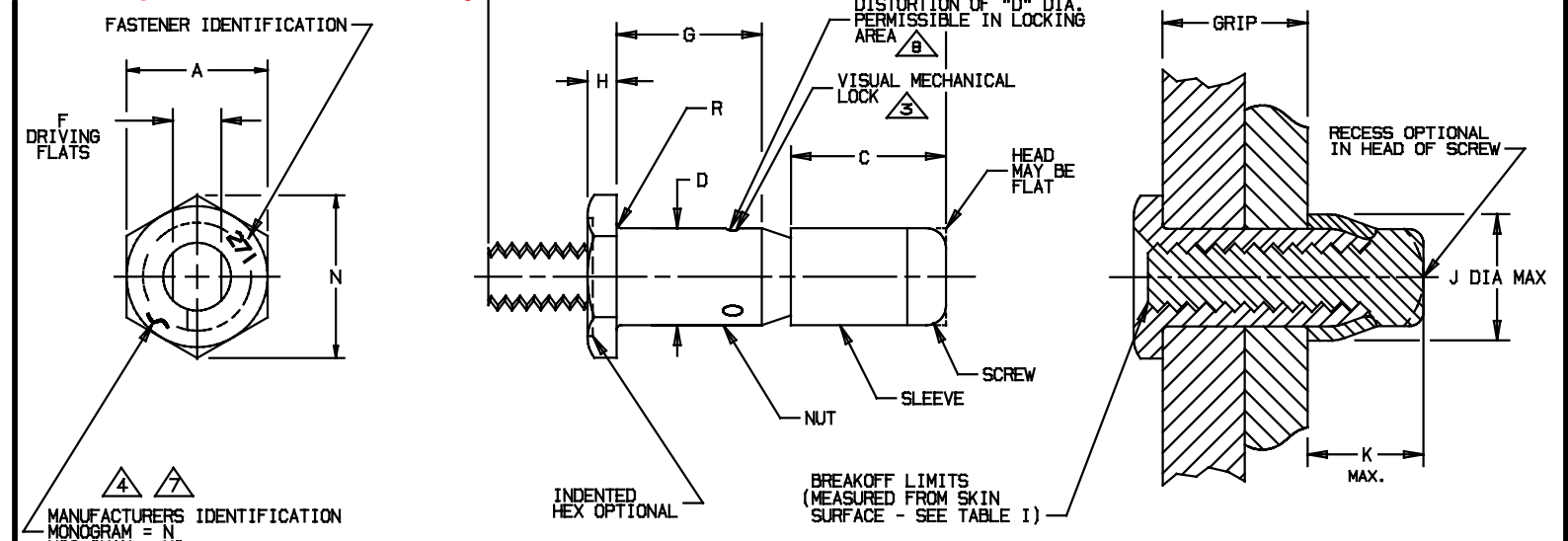


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PART NUMBER	NOM. DIA.	A	C MAX.	D DIA.	F DRIVING FLATS	H MAX.	J DIA. MAX.	K MAX.	N MIN.	R RAD.	HOLE SIZE	BREAK-OFF LIMITS	PREVAILING TORQUE IN. LBS. MIN.	DOUBLE SHEAR STRENGTH LBS. MIN.	TENSILE STRENGTH LBS. MIN.
PLT 271-5-(*)	.179	.250 .244	.315	.1800 .1780	.086 .081	.096	.244	.300	.272	.020 .010	.183 .180	+.088 +.000	1.0	3150	900
PLT 271-6-(*)	.214	.312 .305	.350	.2150 .2130	.104 .099	.113	.300	.333	.340	.025 .015	.218 .215	+.088 +.010	1.5	4600	1400
PLT 271-8-(*)	.275	.375 .367	.385	.2760 .2740	.135 .130	.135	.384	.366	.409	.025 .015	.279 .276	+.135 +.047	2.5	7900	2100
PLT 271-10-(*)	.326	.437 .429	.470	.3270 .3250	.152 .147	.160	.427	.447	.479	.030 .015	.330 .327	+.146 +.043	3.5	11350	3600
PLT 271-12-(*)	.389	.500 .491	.555	.3900 .3880	.185 .180	.190	.516	.527	.548	.030 .015	.393 .390	+.152 +.049	4.0	16450	5600

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

SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF.					SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF.				
		MIN.	MAX.	PLT 271							MIN.	MAX.	PLT 271				
				-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	AVAILABLE	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	IN	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	-5	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	DIAMETER	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		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

Fairchild
CODE IDENT. NO.
92215

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

MONOGRAM
CODE IDENT. NO.
98524

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

<p>APPROVED DATE 06 APRIL 1976</p>	<p>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.</p>	<p>TITLE VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE TITANIUM PROTRUDING HEX HEAD, SELF LOCKING 1/84" OVERSIZE</p>
<p>REV. LETTER AND DATE ① 05-12-94</p>		<p>STANDARD PLT 271 SHEET 1 OF 2</p>

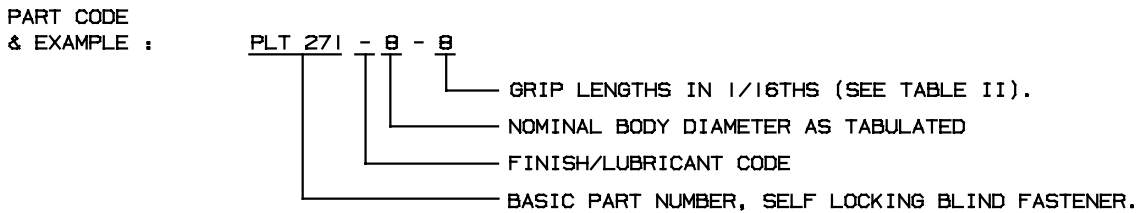
PROCUREMENT SPEC. : ESCBB-9, CLASS 2, EXCEPT AS NOTED HEREIN.

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.



- 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. HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBER.
 EXAMPLE: PLT 271-6-4.5 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.
 7. STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.
 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.

Fairchild
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APPROVED DATE
 06 APRIL 1976

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

STANDARD
PLT 271
SHEET 2 OF 2

REV. LETTER AND DATE
05-12-94