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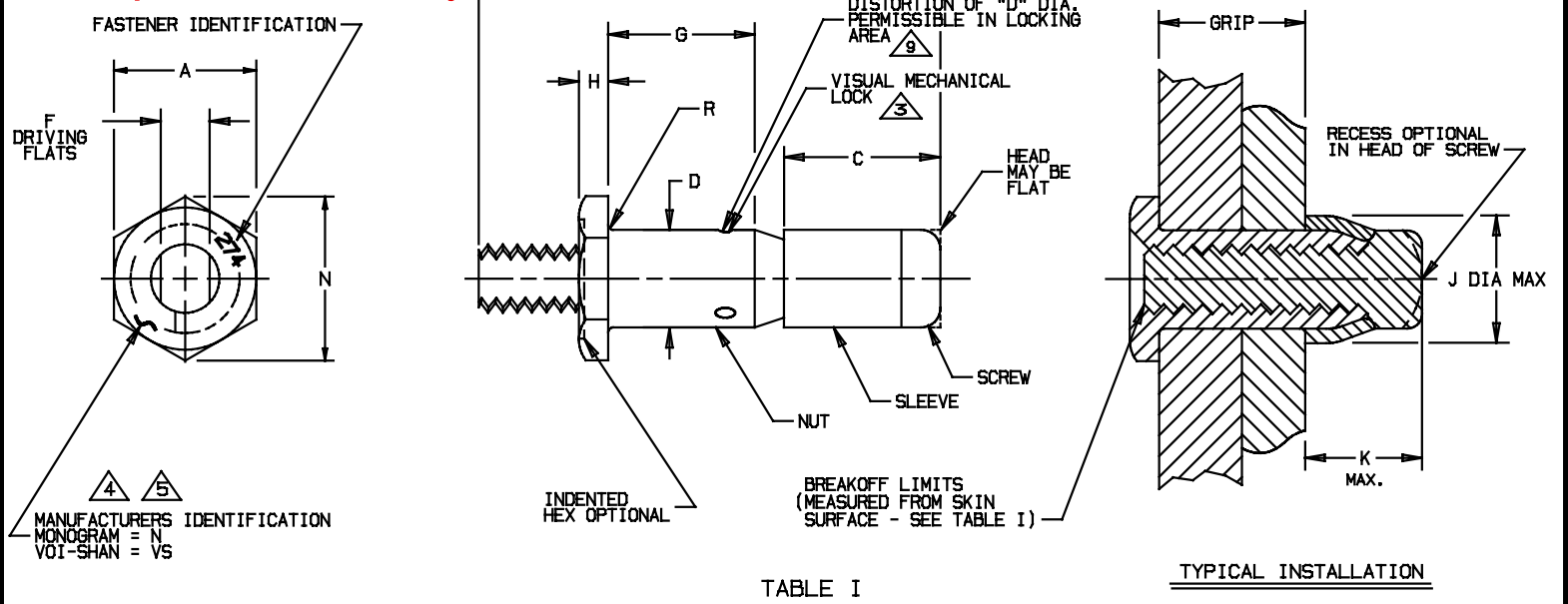


TABLE I

TYPICAL INSTALLATION

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 274-5-(*)	.1640	.250 .244	.285	.1645 .1635	.086 .081	.096	.244	.257	.272	.020 .010	.1680 .1650	+.088 +.000	1.0	3150	900
PLT 274-6-(*)	.2021	.312 .305	.320	.2026 .2016	.104 .099	.113	.300	.288	.340	.025 .015	.2080 .2030	+.098 +.010	1.5	4600	1400
PLT 274-8-(*)	.2646	.375 .367	.355	.2651 .2641	.135 .130	.135	.384	.320	.409	.025 .015	.2685 .2655	+.135 +.047	2.5	7900	2100
PLT 274-10-(*)	.3115	.437 .429	.440	.3120 .3110	.152 .147	.160	.427	.396	.479	.030 .015	.3150 .3120	+.146 +.043	3.5	11350	3600
PLT 274-12-(*)	.3740	.500 .491	.525	.3745 .3735	.185 .180	.190	.516	.473	.548	.030 .015	.3780 .3750	+.152 +.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 274							MIN.	MAX.	PLT 274				
				-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	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	IN	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	-5	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	DIAMETER	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
 09 JUNE 1977

REV. LETTER AND DATE
 (B) 06-17-94

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

STANDARD
PLT 274
 SHEET 1 OF 2

PROCUREMENT SPEC. : ESCBB-9, CLASS 4, EXCEPT AS SPECIFIED HEREIN.

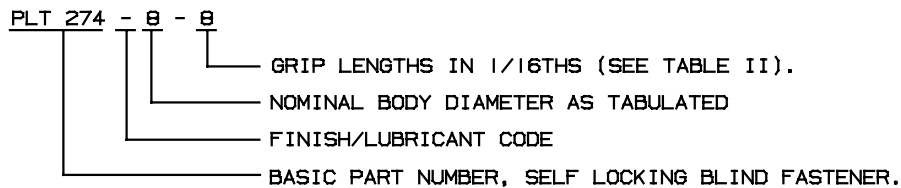
MATERIAL : NUT & SCREW : 6AL-4V TITANIUM PER AMS4928 OR AMS4967.
 SLEEVE : CORROSION RESISTANT STEEL.

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

FINISH: "-" NUT & SCREW : NONE.
 "L" NUT : ALUMINUM COAT (.0002-.0007 THICK) PER NAS4006.
 SLEEVE : PASSIVATE PER QQ-P-35 (MIL-S-5002) ALUMINUM COAT (.0002-.0007 THICK) PER NAS 4006.
 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 274-6-4.5 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.
 - 8.) 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.
 - 9.) 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.
 - 10.) 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.
 11. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.

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STANDARD
PLT 274
SHEET 2 OF 2

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