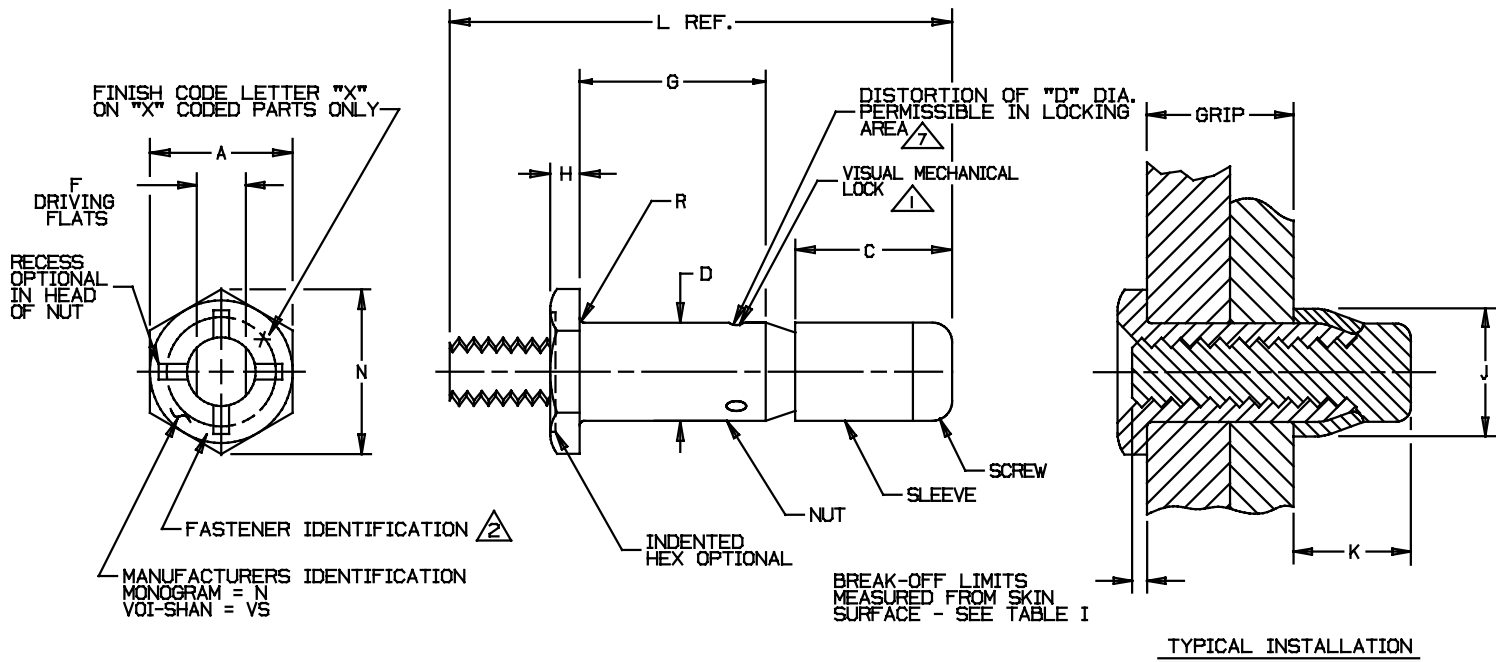


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HEAD MARKINGS DEPRESSED .010 INCH (0,254 mm MAX.) (POSITION OPTIONAL)

TABLE I

PART NUMBER	NOM. DIA.		A HEX.		C MAX.		D DIA.		F FLATS		H MAX.		J DIA. MAX.		K MAX.		N MIN.		R RAD.	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
PLT 275-5-()	.1635	4,153	.250 .244	6,35 6,20	.285	7,24	.1645 .1625	4,178 4,128	.086 .081	2,18 2,06	.096	2,44	.244	6,20	.257	6,53	.272	6,91	.020 .010	0,51 0,25
PLT 275-6-()	.1890	4,800	.312 .305	7,92 7,75	.320	8,13	.1900 .1880	4,826 4,775	.104 .099	2,64 2,51	.113	2,87	.300	7,62	.288	7,31	.340	8,64	.025 .015	0,63 0,38
PLT 275-8-()	.2480	6,299	.375 .367	9,52 9,32	.355	9,02	.2490 .2470	6,325 6,274	.135 .130	3,43 3,30	.135	3,43	.384	9,75	.320	8,13	.409	10,39	.025 .015	0,63 0,38
PLT 275-10-()	.3105	7,887	.437 .429	11,10 10,90	.440	11,18	.3115 .3095	7,912 7,861	.152 .147	3,86 3,73	.160	4,06	.427	10,85	.396	10,06	.479	12,17	.030 .015	0,76 0,38
PLT 275-12-()	.3735	9,487	.500 .491	12,70 12,47	.525	13,34	.3745 .3725	9,512 9,462	.185 .180	4,70 4,57	.190	4,83	.516	13,11	.473	12,01	.548	13,92	.030 .015	0,76 0,38

TABLE I (CONT.)

PART NUMBER	BREAK-OFF LIMITS		HOLE SIZE		PREVAILING TORQUE MIN.		DOUBLE SHEAR STRENGTH MIN.		TENSILE STRENGTH MIN.	
	INCH	mm	INCH	mm	IN-LBS	Nm	LBS.	N	LBS.	N
PLT 275-5-()	+0,088 +0,000	+2,23 +0,00	.168 .165	4,27 4,19	1.0	0,113	3150	14010	900	4000
PLT 275-6-()	+0,098 +0,010	+2,49 +0,25	.193 .190	4,90 4,82	1.5	0,170	4200	18680	1400	6230
PLT 275-8-()	+0,135 +0,047	+3,43 +1,19	.252 .249	6,40 6,32	2.5	0,282	7200	32030	2100	9340
PLT 275-10-()	+0,146 +0,043	+3,71 +1,09	.315 .312	8,00 7,92	3.5	0,400	11350	50480	3600	16010
PLT 275-12-()	+0,152 +0,049	+3,86 +1,24	.378 .375	9,60 9,52	4.0	0,452	16450	73170	5600	24910

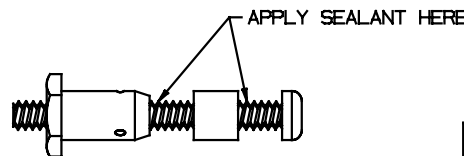


FIGURE I (XSA) CODED

Fairchild

CODE IDENT. NO.
 92215

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

MONOGRAM

CODE IDENT. NO.
 98524

APPROVED DATE
 08-07-84 ECN 3927 "F"

REV. LETTER AND DATE
 "P" 12-12-94

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

STANDARD

PLT 275

SHEET 1 OF 2



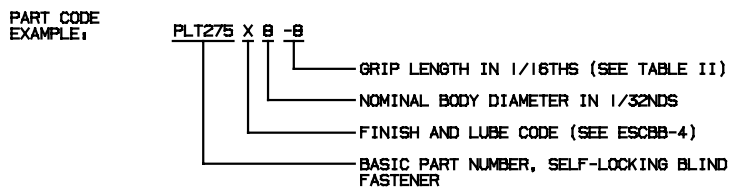
TABLE II

SECOND DASH NUMBER	GRIP RANGE \triangle \triangle				G GRIP (a)		L REF.									
	MIN.		MAX.				-5		-6		-8		-10		-12	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
-1	.031	0,79	.093	2,36	.093	2,39	.733	18,62	.874	22,20						
-2	.094	2,39	.156	3,96	.156	3,96	.795	20,19	.936	23,77	1.006	25,557	1.158	29,413		
-3	.157	3,99	.219	5,56	.219	5,56	.858	21,80	.999	25,37	1.069	27,153	1.221	31,013	1.367	34,722
-4	.220	5,59	.281	7,14	.281	7,14	.920	23,37	1.061	26,949	1.131	28,727	1.283	32,588	1.429	36,230
-5	.282	7,16	.344	8,74	.344	8,74	.983	24,97	1.124	28,550	1.194	30,328	1.346	34,188	1.492	36,897
-6	.345	8,76	.406	10,31	.406	10,31	1.045	26,543	1.186	30,124	1.256	31,902	1.408	35,763	1.554	39,472
-7	.407	10,34	.469	11,91	.469	11,91	1.108	28,143	1.249	31,725	1.319	33,503	1.471	37,363	1.617	41,072
-8	.470	11,94	.531	13,49	.531	13,49	1.170	29,718	1.311	33,300	1.381	35,077	1.533	38,938	1.679	42,647
-9	.532	13,51	.594	15,11	.594	15,11	1.233	31,318	1.374	34,900	1.444	36,678	1.596	40,538	1.742	44,247
-10	.595	15,11	.656	16,66	.656	16,66	1.295	32,893	1.436	36,474	1.506	38,252	1.658	42,113	1.804	45,822
-11	.657	16,69	.719	18,26	.719	18,26	1.358	34,493	1.499	38,075	1.569	39,853	1.721	43,713	1.867	47,422
-12	.720	18,29	.781	19,84	.781	19,84	1.420	36,068	1.561	39,650	1.631	41,427	1.783	45,288	1.929	48,997
-13	.782	19,86	.844	21,44	.844	21,44	1.483	37,668	1.524	41,250	1.694	43,028	1.846	46,888	1.992	50,597
-14	.845	21,46	.906	23,01	.906	23,01	1.545	39,243	1.686	42,824	1.756	44,602	1.908	48,463	2.054	52,172
-15	.907	23,04	.969	24,61	.969	24,61	1.608	40,843	1.749	44,425	1.819	46,203	1.971	50,063	2.117	53,772
-16	.970	24,64	1.031	26,19	1.031	26,19	1.670	42,418	1.811	46,000	1.881	47,777	2.033	51,638	2.179	55,347
-17	1.032	26,21	1.094	27,79	1.094	27,79			1.936	47,600	1.944	49,378	2.096	53,238	2.242	56,947
-18	1.095	27,81	1.156	29,36	1.156	29,36			1.999	49,174	2.006	50,952	2.158	54,813	2.304	58,522
-19	1.157	29,39	1.219	30,96	1.219	30,96			2.061	50,775	2.069	52,553	2.221	56,413	2.367	60,122
-20	1.220	30,99	1.281	32,54	1.281	32,54			2.124	52,350	2.131	54,127	2.283	57,988	2.429	61,697
-21	1.282	32,56	1.344	34,14	1.344	34,14			2.186	53,950	2.194	55,728	2.346	59,588	2.492	63,297
-22	1.345	34,16	1.406	35,71	1.406	35,71			2.249	55,524	2.256	57,302	2.408	61,163	2.554	64,872
-23	1.407	35,74	1.469	37,31	1.469	37,31			2.311	57,125	2.319	58,903	2.471	62,763	2.617	66,472
-24	1.470	37,34	1.531	38,89	1.531	38,89			2.374	58,700	2.381	60,477	2.533	64,338	2.679	68,047
-25	1.532	38,91	1.594	40,49	1.594	40,49			2.436	60,300	2.444	62,078	2.596	65,938	2.742	69,647
-26	1.595	40,51	1.656	42,06	1.656	42,06			2.499	61,874	2.506	63,652	2.658	67,513	2.804	71,222
-27	1.657	42,09	1.719	43,66	1.719	43,66			2.561	63,475	2.569	65,253	2.721	69,113	2.867	72,822
-28	1.720	43,69	1.781	45,24	1.781	45,24			2.624	65,049	2.631	66,827	2.783	70,688	2.929	74,397
-29	1.782	45,26	1.844	46,84	1.844	46,84			2.624	66,650	2.694	68,428	2.846	72,288	2.992	75,997
-30	1.845	46,86	1.906	48,41	1.906	48,41			2.686	68,224	2.756	70,002	2.908	73,863	3.054	77,572
-31	1.907	48,44	1.969	50,01	1.969	50,01			2.749	69,825	2.819	71,603	2.971	75,463	3.117	79,172
-32	1.970	50,04	2.031	51,59	2.031	51,59			2.811	71,400	2.881	73,177	3.033	77,038	3.179	80,747

(a) "G" TOLERANCES: FOR -5 & -6 SIZES $+0,030$ ($+0,762$); FOR -8 & -10 SIZES $+0,040$ ($+1,016$); FOR -12 SIZES $+0,050$ ($+1,270$)
 $-0,010$ ($-0,254$); $-0,010$ ($-0,254$); $-0,010$ ($-0,254$)

PROCUREMENT SPECIFICATION: ESCBB-9 CLASS 2
 MATERIAL: NUT & SCREW: 6A1-4V TITANIUM PER AMS 4928 OR AMS 4967
 SLEEVE: CORROSION RESISTANT STEEL
 HEAT TREAT: NUT & SCREW: HEAT TREAT PER MIL-H-81200 TO 95 KSI
 F_{su} MINIMUM, MAX. HYDROGEN 125 PPM
 SLEEVE: AS REQUIRED FOR PERFORMANCE
 FINISH: (-) NUT & SCREW: NONE
 SLEEVE: PASSIVATE PER QQ-P-35 (MIL-S-5002)
 (X) NUT: I.V.D. ALUMINUM COAT PER MIL-C-83488 CLASS 3, TYPE II
 SCREW: KAL-GARD ANN-RO #1012 OPTIONAL
 SLEEVE: PASSIVATE PER QQ-P-35 (MIL-S-5002)
 KAL-GARD ANN-RO #1013 OPTIONAL
 LUBRICATION: (-) NUT, SCREW & SLEEVE: DRY FILM & CETYL, OPTIONAL & AS REQUIRED
 (X) NUT: CARBO WAX, PARAFFIN WAX, TIO-LON A-20, TIO-LON X-20, OR CETYL ALCOHOL AS REQUIRED FOR PERFORMANCE
 SCREW & SLEEVE: LUBRICANTS USED ON SLEEVES AND SCREWS MUST NOT CONTAIN SULFIDES (e.g. MoS₂) OR GRAPHITE. EXAMPLE OF ACCEPTABLE LUBRICANTS ARE TIO-LON X-20 AND A-20, KAL-GARD FC-2, AND THOSE LUBRICANTS LISTED ABOVE FOR THE NUT COMPONENT
 (XSA) DRY FILM LUBE MoS₂ AS REQUIRED FOR PERFORMANCE

- GENERAL NOTES:
- LOCKING FEATURE CONSISTS OF THREE (3) INDENTATIONS LOCATED 120° APART ON PERIPHERY OF THE NUT COMPONENT
 - FASTENER IDENTIFICATION: "275" IN ONE QUADRANT OR "5275" IN TWO QUADRANTS. OPTIONAL HEAD MARKING FOR -5, -10, AND -12 SIZES "270" IN ONE QUADRANT OR "5270" IN TWO QUADRANTS
 - HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS
 EXAMPLE: PLT 275-5-4.5 INDICATES NOMINAL GRIP LENGTH OF 4-1/2 16THS (.281" = 7,14mm) THE GRIP RANGE FOR THESE HALF GRIP SIZES WILL BE NOMINAL GRIP $+0,031/-0,030$ ($+0,79/-0,79$ mm)
 THE BASIC "G" DIMENSION WILL BE NOMINAL GRIP $+0,031$ ($+0,79$ mm) AND THE OVERALL SCREW LENGTH "L" DIMENSION MAY VARY AT THE MANUFACTURER'S OPTION
 - 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
 - "XSA" PARTS ARE PARTIALLY DISASSEMBLED TO PERMIT THE APPLICATION OF WET SEALANT AS SHOWN IN FIGURE 1 (SEE SHEET 1)
 (XSA PARTS MUST HAVE SEALANT APPLIED FOR PROPER FUNCTION)
 - MAXIMUM RECOMMENDED TEMPERATURE 750°F.
 - 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. $+0,001$ INCH. FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS (22.23 NEWTONS)
 - DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.
 - OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT BE GREATER THAN MAXIMUM "D" DIAMETER.
 - REMOVE ALL LOOSE OR HANGING BURRS.



Fairchild
 CODE IDENT. NO.
92215

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

MONOGRAM
 CODE IDENT. NO.
98524

APPROVED DATE
 08-07-84 ECN 3927 "F"

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

STANDARD
 PLT 275
 SHEET 2 OF 2