

PART NUMBER	NOM. DIA.		A		C MAX.		D DIA.		F DRIVING FLATS		H HEAD HEIGHT		J DIA MAX.		K MAX.		L REF.	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
PLT1013-06-(-)	.2290	5,817	.312 .305	7,92 7,75	.360	9,14	.2300 .2280	5,84 5,79	.104 .099	2,64 2,52	.113 .074	2,87 1,88	.300	7,62	.333	8,46	.780	19,81
PLT1013-08-(-)	.2900	7,866	.375 .367	9,52 9,32	.404	10,26	.2910 .2890	7,39 7,34	.135 .130	3,43 3,30	.135 .084	3,43 2,13	.384	9,75	.366	9,30	.850	21,59
PLT1013-10-(-)	.3415	8,674	.437 .429	11,10 10,90	.493	12,52	.2425 .3405	8,70 8,65	.152 .147	3,86 3,73	.160 .106	4,06 2,69	.427	10,85	.447	11,35	1,002	25,45
PLT1013-12-(-)	.4045	10,273	.500 .491	12,70 12,47	.583	14,80	.4055 .4035	10,30 10,25	.185 .180	4,70 4,57	.190 .127	4,83 3,22	.516	13,11	.527	13,39	1,085	27,56

PART NUMBER	N MIN.		R RAD.		BREAK-OFF LIMITS		MINIMUM AVAILABLE GRIP LENGTH	HOLE SIZE		PREVAILING TORQUE MIN.		DOUBLE SHEAR STRENGTH MIN.		TENSILE STRENGTH MIN.	
	INCH	MM	INCH	mm	INCH	mm		INCH	mm	INCH-LBS	Nm	LBS	N	LBS	N
PLT1013-06-(-)	.340	8,64	.025	0,63	+0,098 +0,10	+2,49 +0,25	-01	.233 .230	5,92 5,84	1.5	0,170	5240	23300	1400	6230
PLT1013-08-(-)	.409	10,39	.015	0,38	+0,135 +0,047	+3,43 +1,19	-02	.294 .291	7,47 7,39	2.5	0,282	9000	40000	2100	9340
PLT1013-10-(-)	.479	12,17	.030 .015	0,76 0,38	+0,146 +0,043	+3,71 +1,09	-03	.346 .343	8,79 8,71	3.5	0,400	12000	53400	3600	16010
PLT1013-12-(-)	.548	13,92	.015	0,38	+0,152 +0,049	+3,86 +1,24	-03	.409 .406	10,39 10,32	4.0	0,452	19500	86700	5600	24910

▲ "G" TOLERANCES: FOR -06 SIZES +.030/-0.10 (+0,762/-0,254mm), FOR -08 & -10 SIZES +.040/-0.10 (+1,016/-0,254mm), FOR -12 SIZES +.050/-0.10 (+1,270/-0,254mm).

MONOGRAM AEROSPACE FASTENERS
a TriMas company
3423 SOUTH GARFIELD AVENUE
COMMERCE, CALIFORNIA 90040
(323) 722-4760 FAX (323) 727-1029

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

DRAWING NO:
PLT1013(-)(-)(-)

DRAWN BY:
B. GEE

APPROVED BY:

DRAWN DATE:
09/24/13

CHECKED DATE:

PROPRIETARY AND CONFIDENTIAL:
NOTICE: THIS DRAWING IS PART OF THE PROPRIETARY ARTICLE HEREIN DISCLOSED, OWNED BY MONOGRAM AEROSPACE FASTENERS. ANY PARTY BY ACCEPTING THIS DOCUMENT ASSUME 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 THE DELIVERY OF THIS DOCUMENT SHALL NOT CONSTITUTE ANY RIGHT OR LICENSE TO DO SO.

Alcoa
CAGE CODE:
5M902

MONOGRAM
CAGE CODE:
98524

DCN NO:
14-0708

DCN DATE:
11/08/14

REV:
L

SHEET 1 OF 2



PROCUREMENT SPEC: ESCBB-2 OR NAS1675, CLASS 1.

MATERIAL:

NUT & SCREW: ALLOY STEEL: 4130 PER AMS-S-6758, 4140 PER AMS6382 OR AMS6349 OR 8740 PER AMS6322.
SLEEVE: CORROSION RESISTANT STEEL: 303 OR 304 PER AMS-QQ-S-763, AMS5639 OR AMS5641.

HEAT TREAT:

NUT & SCREW: HEAT TREAT PER AMS2759, APPROXIMATELY 180,000-200,000 PSI TENSILE (HRC 39-43).
SLEEVE: AS REQUIRED FOR PERFORMANCE.

FINISH:

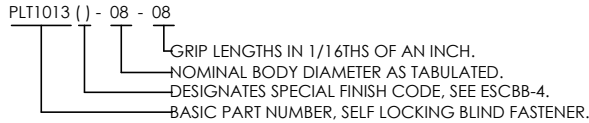
NUT & SCREW: CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS. CADMIUM PLATE PER NAS672 IS PERMISSIBLE PROVIDED IT IS FOLLOWED BY A DICHROMATE POST TREATMENT PER AMS-QQ-P-416.
SLEEVE: PASSIVATE PER AMS2700. CADMIUM PLATE PER AMS-QQ-P-416, TYPE I CLASS 3.

LUBRICANT:

LUBRICANTS LISTED BELOW MAY BE APPLIED TO ANY OR ALL COMPONENTS IF REQUIRED FOR PERFORMANCE:

NUT: WWM CARBO-WAX, PARAFFIN WAX, CETYL ALCOHOL
SCREW & SLEEVE: DRY FILM LUBE PER AS5272, WWM CARBO-WAX TYPE, PARAFFIN WAX, CETYL ALCOHOL.

PART CODE & EXAMPLE:



GENERAL NOTES:

1. OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NO BE GREATER THAN MAXIMUM "D" DIAMETER.
2. HEAD MARKINGS ON NUT DEPRESSED .010 MAX.
3. REMOVE ALL LOOSE OR HANGING BURRS.
4. LOCKING FEATURE CONSISTS OF THREE (3) INDENTATIONS LOCATED 120° APART ON THE PERIPHERY OF THE NUT COMPONENT AND APPROXIMATELY .040" (1.02 mm) ABOVE THE INTERSECTION OF THE NUT NOSE ANGLE AND O.D. (MEAN GRIP OF FASTENER).
5. MANUFACTURER'S IDENTIFICATION:
LETTER "N" DESIGNATES MONOGRAM AEROSPACE FASTENERS.
LETTERS "VS" DESIGNATE ALCOA.
6. HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.
EXAMPLE: PLT1013-06-4.5 INDICATES A NOMINAL GRIP LENGTH OF 4.5 SIXTEENTHS (.281 = 7.14mm).
THE GRIP RANGE FOR THESE HALF-GRIP SIZES WILL BE NOMINAL GRIP +.031/- .030 (+0.79/-0.79mm).
THE BASIC "G" DIMENSION WILL BE NOMINAL GRIP +.031 (+0.79) AND THE OVERALL SCREW LENGTH "L" DIMENSION MAY VARY AT MANUFACTURER'S OPTION.
7. 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 AND PREVAILING TORQUES DO NOT APPLY.
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 MAXIMUM "D" MAX + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS (22.23 NEWTONS).
9. STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.
10. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.

SECOND DASH NUMBER	G GRIP		GRIP RANGE			
	INCH	mm	INCH	mm	INCH	mm
-02	.156	3,96	.094	2,39	.156	3,96
-03	.219	5,56	.157	3,99	.219	5,56
-04	.281	7,14	.220	5,59	.281	7,14
-05	.344	8,74	.282	7,16	.344	8,74
-06	.406	10,31	.345	8,76	.406	10,31
-07	.469	11,91	.407	10,34	.469	11,91
-08	.531	13,49	.470	11,94	.531	13,49
-09	.595	15,11	.532	13,51	.595	15,11
-10	.656	16,66	.595	15,11	.656	16,66
-11	.719	18,26	.657	16,69	.719	18,26
-12	.781	19,84	.720	18,29	.781	19,84
-13	.844	21,44	.782	19,86	.844	21,44
-14	.906	23,01	.845	21,46	.906	23,01
-15	.969	24,61	.907	23,04	.969	24,61
-16	1.031	26,19	.970	24,64	1.031	26,19
-17	1.094	27,79	1.032	26,21	1.094	27,79
-18	1.156	29,36	1.095	27,81	1.156	29,36
-19	1.219	30,96	1.157	29,39	1.219	30,97
-20	1.281	32,54	1.220	30,99	1.281	32,54
-21	1.344	34,14	1.282	32,56	1.344	34,14
-22	1.406	35,71	1.345	34,16	1.406	35,71
-23	1.469	37,31	1.407	35,74	1.469	37,31
-24	1.531	38,89	1.470	37,34	1.531	38,89
-25	1.594	40,49	1.532	38,91	1.594	40,49
-26	1.656	42,06	1.595	40,51	1.656	42,06
-27	1.719	43,66	1.657	42,09	1.719	43,66
-28	1.781	45,24	1.720	43,69	1.781	45,24
-29	1.844	46,84	1.782	45,26	1.844	46,84
-30	1.906	48,41	1.845	46,86	1.906	48,41
-31	1.969	50,01	1.907	48,44	1.969	50,01
-32	2.031	51,59	1.970	50,04	2.031	51,59

3423 SOUTH GARFIELD AVENUE
COMMERCE, CALIFORNIA 90040
(323) 722-4760 FAX (323) 727-1029

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

DRAWING NO:
PLT1013()-()-()

DRAWN BY:
B. GEE

DRAWN DATE:
09/24/13

APPROVED BY:

CHECKED DATE:

PROPRIETARY AND CONFIDENTIAL:
NOTICE: THIS DRAWING IS PART OF THE PROPRIETARY ARTICLE HEREIN DISCLOSED, OWNED BY MONOGRAM AEROSPACE FASTENERS. ANY PARTY BY ACCEPTING THIS DOCUMENT ASSUME 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 THE DELIVERY OF THIS DOCUMENT SHALL NOT CONSTITUTE ANY RIGHT OR LICENSE TO DO SO.

Alcoa
CAGE CODE:
5M902

MONOGRAM
CAGE CODE:
98524

DCN NO:
14-0708

DCN DATE:
11/08/14

REV:
L

SHEET 2 OF 2