

PART NUMBER	NOM DIA	A	C MAX	D DIA	F DRIVING FLATS	H MAX	J DIA MAX	K MAX	N MIN	R RAD	BREAK-OFF LIMITS	PREVAILING TORQUE IN. LBS. MIN	SINGLE SHEAR STRENGTH LBS. MIN	TENSILE STRENGTH LBS. MIN
PLT1017-05-(-)	.1635	.250 .244	.268	.1645 .1625	.086 .081	.096	.244	.267	.272	.020 .010	+088 +000	1.0	1625	820
PLT1017-06-(-)	.1980	.312 .305	.303	.1990 .1970	.104 .099	.113	.300	.302	.340	.025 .015	+103 +015	1.5	2410	1400
PLT1017-08-(-)	.2590	.375 .367	.354	.2600 .2580	.135 .130	.135	.384	.346	.409	.025 .015	+130 +032	2.5	4170	2100
PLT1017-10-(-)	.3105	.437 .429	.423	.3115 .3095	.152 .147	.160	.427	.406	.479	.030 .015	+130 +027	3.5	6500	3600
PLT1017-12-(-)	.3735	.500 .491	.510	.3745 .3735	.185 .180	.190	.516	.470	.548	.030 .015	+130 +027	4.0	8220	5600

SECOND DASH NUMBER	G GRIP	GRIP RANGE		PLT1017											
		MIN	MAX	-05-(-)		-06-(-)		-08-(-)		-10-(-)		-12-(-)			
				L	B	L	B	L	B	L	B	L	B		
-01	.093	.031	.093	.733	.482	.874	.527	-	-	-	-	-	-	-	-
-02	.156	.094	.156	.795	.545	.936	.590	1.006	.681	1.158	.787	-	-	-	-
-03	.219	.157	.219	.858	.608	.999	.653	1.069	.744	1.221	.850	1.304	1.010	-	-
-04	.281	.220	.281	.920	.670	1.061	.715	1.131	.806	1.283	.912	1.367	1.072	-	-
-05	.344	.282	.344	.983	.733	1.124	.778	1.194	.869	1.346	.975	1.429	1.135	-	-
-06	.406	.345	.406	1.045	.795	1.196	.840	1.256	.931	1.408	1.035	1.492	1.197	-	-
-07	.469	.407	.469	1.108	.858	1.249	.903	1.319	.994	1.471	1.100	1.554	1.260	-	-
-08	.531	.470	.531	1.170	.920	1.361	.965	1.381	1.056	1.533	1.162	1.617	1.322	-	-
-09	.594	.532	.594	1.233	.983	1.374	1.028	1.444	1.119	1.596	1.225	1.679	1.385	-	-
-10	.656	.595	.656	1.295	1.045	1.436	1.090	1.506	1.181	1.658	1.287	1.742	1.447	-	-
-11	.719	.657	.719	1.358	1.108	1.499	1.153	1.569	1.244	1.721	1.350	1.804	1.510	-	-
-12	.781	.720	.781	1.420	1.170	1.561	1.215	1.631	1.306	1.783	1.412	1.867	1.572	-	-
-13	.844	.782	.844	1.483	1.233	1.624	1.278	1.694	1.369	1.846	1.475	1.929	1.635	-	-
-14	.906	.845	.906	1.545	1.295	1.696	1.338	1.756	1.431	1.908	1.537	1.992	1.697	-	-
-15	.969	.907	.969	1.608	1.358	1.749	1.403	1.819	1.494	1.971	1.600	2.054	1.750	-	-
-16	1.031	.970	1.031	1.670	1.420	1.811	1.465	1.881	1.556	2.033	1.662	2.117	1.822	-	-

SECOND DASH NUMBER	G GRIP	GRIP RANGE		PLT1017											
		MIN	MAX	-05-(-)		-06-(-)		-08-(-)		-10-(-)		-12-(-)			
				L	B	L	B	L	B	L	B	L	B		
-17	1.094	1.032	1.094	-	-	1.874	1.528	1.944	1.619	2.096	1.725	2.179	1.885	-	-
-18	1.156	1.095	1.156	-	-	1.936	1.590	2.006	1.681	2.158	1.787	2.242	1.947	-	-
-19	1.219	1.157	1.219	-	-	1.999	1.653	2.069	1.744	2.221	1.850	2.304	2.010	-	-
-20	1.281	1.220	1.281	-	-	2.061	1.715	2.131	1.806	2.283	1.912	2.367	2.072	-	-
-21	1.344	1.282	1.344	-	-	2.124	1.778	2.194	1.869	2.346	1.973	2.429	2.135	-	-
-22	1.406	1.345	1.406	-	-	2.186	1.840	2.256	1.931	2.408	2.037	2.492	2.197	-	-
-23	1.469	1.407	1.469	-	-	2.249	1.903	2.319	1.994	2.471	2.100	2.554	2.260	-	-
-24	1.531	1.470	1.531	-	-	2.311	1.965	2.381	2.056	2.533	2.162	2.617	2.322	-	-
-25	1.594	1.532	1.594	-	-	2.374	2.028	2.444	2.119	2.596	2.225	2.679	2.385	-	-
-26	1.656	1.595	1.656	-	-	2.436	2.090	2.506	2.181	2.658	2.287	2.742	2.447	-	-
-27	1.719	1.657	1.719	-	-	2.499	2.153	2.569	2.244	2.721	2.350	2.804	2.510	-	-
-28	1.781	1.720	1.781	-	-	2.561	2.215	2.631	2.306	2.783	2.412	2.867	2.572	-	-
-29	1.844	1.782	1.844	-	-	2.624	2.278	2.694	2.369	2.846	2.475	2.929	2.635	-	-
-30	1.906	1.845	1.906	-	-	2.686	2.340	2.756	2.431	2.908	2.537	2.992	2.697	-	-
-31	1.969	1.907	1.969	-	-	2.749	2.403	2.819	2.494	2.971	2.600	3.054	2.706	-	-
-32	2.031	1.970	2.031	-	-	2.811	2.465	2.881	2.556	3.033	2.662	3.117	2.822	-	-

▲ "G" TOLERANCE: FOR -05 AND -06 SIZES +.030/-010; FOR -08 & -10 SIZES +.040/-010; FOR -12 SIZE +.050/-010.



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

TITLE:

VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE HIGH TEMPERATURE (A-286 ALLOY) PROTRUDING HEAD, SELF LOCKING HIGH SHEAR STRENGTH

DRAWING NO:

PLT1017(-)(-)(-)

DRAWN BY:

B. GEE

DRAWN DATE:

09/27/13

APPROVED BY:

CHECKED DATE:

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CAGE CODE:
5M902

MONOGRAM
CAGE CODE:
98524

ECN NO:
14-0710
ECN DATE:
11/08/14

REV:
K
SHEET 1 OF 2



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

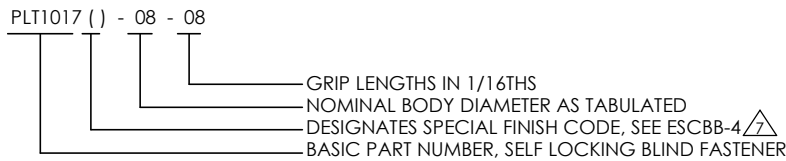
MATERIAL: NUT, SCREW & SLEEVE: CORROSION AND HEAT RESISTANT STEEL, TYPE A-286 PER AMS5731, AMS5732 OR AMS5737.

HEAT TREAT: NUT & SCREW: SOLUTION HEAT TREATED AND AGED TO A CORE HARDNESS OF HRC 30-45. ALL CORE HARDNESS READINGS ARE TAKEN ON MOUNTED SPECIMEN, USING A BRALE PENETRATOR AND A 30 Kg LOAD (ROCKWELL 30N).
SLEEVE: SOLUTION TREATED.

FINISH: $\triangle 7$ NUT, SCREW & SLEEVE: PASSIVATE PER AMS2700 $\triangle 8$

LUBRICANT: $\triangle 7$ LUBRICANTS LISTED BELOW MAY BE APPLIED TO ANY OR ALL COMPONENTS IF REQUIRED FOR PERFORMANCE:
DRY FILM LUBE PER AS5272 TYPE I OR MIL-PRF-81329, WWM CARBO-WAX, PARAFFIN WAX AND OR CETYL ALCOHOL PER AS87132 $\triangle 8$

PART CODE & EXAMPLE:



GENERAL NOTES:

1. OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT EXCEED MAXIMUM "D" DIAMETER.
 2. REMOVE ALL LOOSE OR HANGING BURRS.
 - $\triangle 3$ 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).
 - $\triangle 4$ THE PREVAILING TORQUE SHALL CONFORM TO THE VALUES AS TABULATED, WHEN TESTED IN ACCORDANCE WITH SPECIFICATION ESCBB-2. HOWEVER, PREVAILING TORQUES FOR THE PLT1017-05-01 AND PLT1017-06-01 SHALL BE RECORDED THRU A ROTATION OF ONLY 360° OF THE NUT.
 - $\triangle 5$ MANUFACTURER'S IDENTIFICATION:
LETTER "N" DESIGNATES MONOGRAM AEROSPACE FASTENERS.
LETTERS "VS" DESIGNATE VOI-SHAN.
 6. HEAD MARKINGS ON NUT DEPRESSED .010" MAX. LOCATION OPTIONAL.
 - $\triangle 7$ STANDARD FINISHES AND LUBES ARE SHOWN ABOVE. REFER TO ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBES, IF REQUIRED.
 - $\triangle 8$ HEAD OF NUT TO BE COLORED YELLOW.
 - $\triangle 9$ 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 MAXIMUM "D" + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS.
 - $\triangle 10$ HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.
- EXAMPLE: PLT1017-06-4.5 INDICATES A NOMINAL GRIP LENGTH OF 4.5 SIXTEENTHS = 0.281".
THE GRIP RANGE FOR THESE HALF-GRIP SIZES WILL BE NOMINAL GRIP +.031"/-.030".
EXCEPT: THE GRIP RANGE FOR -1.5 GRIP SHALL BE MAX GRIP = 0.125", MIN GRIP = 0.078".
THE BASIC "G" DIMENSION WILL BE NOMINAL GRIP +.031" AND THE OVERALL SCREW LENGTH "L" DIMENSION MAY VARY AT MANUFACTURER'S OPTION.
- $\triangle 11$ STANDARD GRIP LENGTHS ARE AS TABULATED, 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 AS TABULATED DO NOT APPLY.
12. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.

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a TriMas company
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