

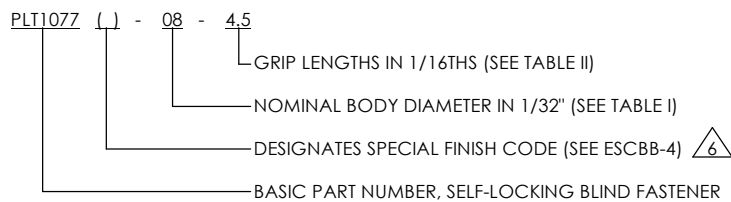
**TABLE I**

PART NUMBER	Ø NOM		Ø A		Ø B		C MAX		Ø D		F WRENCH FLATS		H		Ø J MAX		K MAX		R. R	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
PLT1077-08-( )	.2590	6,579	.416 .396	10,57 10,06	.380 .340	9,65 8,64	.354	8,99	.2600 .2580	6,604 6,553	.135 .130	3,43 3,30	.063 .053	1,60 1,35	.384	9,75	.325	8,26	.025 .015	0,64 0,38
PLT1077-08-(4.5)	.2590	6,579	.416 .396	10,57 10,06	.380 .340	9,65 8,64	.354	8,99	.2600 .2580	6,604 6,553	.135 .130	3,43 3,30	.063 .053	1,60 1,35	.384	9,75	.325	8,26	.025 .015	0,64 0,38

**TABLE I (CONTINUED)**

PART NUMBER	BREAK-OFF LIMITS		MINIMUM AVAILABLE GRIP LENGTH (TABLE II)	HOLE SIZE		PREVAILING TORQUE MIN		DOUBLE SHEAR STRENGTH MIN		TENSILE STRENGTH MIN	
	INCH	mm		INCH	mm	IN-LBS	Nm	LBS	N	LBS	N
PLT1077-08-( )	+0.053 -0.035	+1,35 -0,89	-03	.264 .261	6,71 6,63	2.5	0,282	9000	40030	2100	9340
PLT1077-08-(4.5)	+0.073 -0.035	+1,85 -0,89	-03	.264 .261	6,71 6,63	2.5	0,282	9000	40030	2100	9340

EXAMPLE PART NUMBER:





11

2ND DASH NO.	G +.040/- .010 [+1.02/-0.25 mm]		GRIP RANGE				( L )	
			MIN		MAX		-08	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm
-03	.202	5.13	.162	4.11	.202	5.13	.966	24.54
-04	.244	6.20	.203	5.16	.244	6.20	1.006	25.55
-4.5	.285	7.24	.223	5.66	.285	7.24	1.026	26.06
-05	.285	7.24	.245	6.22	.285	7.24	1.044	26.52
-06	.320	8.13	.280	7.11	.320	8.13	1.082	27.48
-07	.447	11.35	.407	10.34	.447	11.35	1.215	30.86
-08	.500	12.70	.460	11.68	.500	12.70	1.270	32.26

APPLICABLE SPECIFICATIONS:  
 PROCUREMENT SPECIFICATION: NAS1675, CLASS I, EXCEPT HEAD STYLE, GRIP RANGE AND BREAK-OFF LIMITS.

**MATERIAL:**  
 NUT AND SCREW: ALLOY STEEL 4130 PER AMS-S-6758, ALLOY STEEL 4140 PER AMS6382 OR AMS6349 OR ALLOY STEEL 8740 PER AMS6322.  
 SLEEVE: CRES 303 OR CRES 304 PER AMS-QQ-S-763, AMS5639 OR AMS5641.

**HEAT TREAT:**  
 NUT AND SCREW: HEAT TREAT TO 39-43 HRC (180-200 KSI) PER AMS2759.  
 SLEEVE: AS REQUIRED FOR PERFORMANCE.

**FINISH:**  
 NUT AND SCREW: CADMIUM PLATED PER AMS-QQ-P-416 TYPE II, CLASS 2. 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 PLATED PER AMS-QQ-P-416, TYPE I, CLASS 3.

**LUBRICATION:**  
 NUT: WWM CARBO-WAX, PARAFFIN WAX AND/OR CETYL ALCOHOL PER AS87132.  
 SCREW AND SLEEVE: SOLID DRY FILM LUBRICANT PER THE CHEMICAL REQUIREMENTS OF AS5272 TYPE I OR EVERLUBE 812 PER MIL-PRF-81329, WWM CARBO-WAX, PARAFFIN WAX AND/OR CETYL ALCOHOL PER AS87132.  
 LUBRICANTS LISTED MAY BE APPLIED TO ANY OR ALL COMPONENTS AS REQUIRED FOR PERFORMANCE.

- GENERAL NOTES:**
1. OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT BE GREATER THAN MAXIMUM "  $\phi$ D".
  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" [1.02 mm] ABOVE THE INTERSECTION OF THE NUT NOSE ANGLE AND O.D. (MEAN GRIP OF FASTENER).
  4. THE PREVAILING TORQUE SHALL CONFORM TO THE VALUES AS TABULATED, WHEN TESTED IN ACCORDANCE WITH SPECIFICATION NAS1675.
  5. HEAD MARKINGS ON NUT DEPRESSED .010 INCH [0.254 mm] MAXIMUM. POSITION OPTIONAL.
  6. STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.
  7. RECOMMENDED INSTALLATION TOOL: MPR-8A.
  8. DISTORTION OF "  $\phi$ D" PERMISSIBLE IN LOCKING AREA.
  9. MUST ENTER A .2610" [6.63 mm] HOLE WITH FINGER PRESSURE.
  10. AMS-S-8802 SEALANT IN FAYING SURFACES.
  11. HALF GRIP SIZES MAY BE ORDERED BY ADDING ".5" TO THE GRIP DASH NUMBER.

 3423 SOUTH GARFIELD AVENUE COMMERCE, CALIFORNIA 90040 (323) 722-4760 FAX (323) 727-1029	TITLE:	DRAWING NO:	
	VISU-LOK®, FASTENER, BLIND, DOMED HEAD, SELF-LOCKING, ALLOY STEEL		PLT1077( )-( )-( )
	DRAWN BY: A PEREZ		DRAWN DATE: 03/23/2014
APPROVED BY:		CHECKED DATE:	
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