

PART NUMBER	A THEO. DIA.	A' DIA. MIN.	C MAX.	D DIA. 4		E DIA. MAX.	F DRIVING FLATS	H REF.	J DIA. MAX.	K MAX.	M GAGE PROT.	R RAD.	S MAX.	W GAGE DIA.	HOLE SIZE	13 BREAK-OFF LIMITS	13 PREVAILING TORQUE IN. LBS. MIN	DOUBLE SHEAR STRENGTH LBS. MIN	TENSILE STRENGTH LBS. MIN
				BARE	ALUM. COATED														
PLT1081-05-(-)	.2612 .2564	.241	.315	.1835 .1830	.1835 .1825	.1800	.086 .081	.032	.244	.300	.0178 .0153	.030 .010	.010	.2195 .2193	.1875 .1845	+0.088 -0.000	1.0	3150	750
PLT1081-06-(-)	.3016 .2966	.270	.350	.2185 .2180	.2185 .2175	.2150	.104 .099	.034	.300	.333	.0246 .0218	.030 .015	.015	.2440 .2438	.2225 .2195	+0.088 -0.000	1.5	4600	1250
PLT1081-08-(-)	.3948 .3898	.363	.385	.2795 .2790	.2795 .2785	.2760	.135 .130	.047	.384	.366	.0271 .0242	.030 .015	.015	.3314 .3312	.2835 .2805	+0.098 -0.000	2.5	7900	1900
PLT1081-10-(-)	.4739 .4689	.442	.470	.3305 .3300	.3305 .3295	.3270	.152 .147	.059	.427	.447	.0296 .0266	.040 .020	.015	.4047 .4045	.3345 .3315	+1.103 -0.000	3.5	11350	3250
PLT1081-12-(-)	.5604 .5554	.529	.555	.3935 .3930	.3935 .3925	.3900	.185 .180	.059	.516	.527	.0321 .0290	.040 .020	.015	.4854 .4852	.3975 .3945	+1.103 -0.000	4.0	16450	5050

SECOND DASH NUMBER	G GRIP	13 GRIP RANGE		L REF. PLT1081				
		MIN	MAX	-05-(-)	-06-(-)	-08-(-)	-10-(-)	-12-(-)
-	-	-	-	-	-	-	-	-
-02	.156	.094	.156	.733	.853	-	-	-
-03	.219	.157	.219	.795	.916	.944	1.096	1.180
-04	.281	.220	.281	.858	.978	1.006	1.158	1.242
-05	.344	.282	.344	.920	1.041	1.069	1.221	1.304
-06	.406	.345	.406	.983	1.103	1.131	1.283	1.367
-07	.469	.407	.469	1.045	1.166	1.194	1.346	1.429
-08	.531	.470	.531	1.108	1.228	1.256	1.408	1.492
-09	.594	.532	.594	1.170	1.291	1.319	1.471	1.554
-10	.656	.595	.656	1.233	1.353	1.381	1.533	1.617
-11	.719	.657	.719	1.295	1.416	1.444	1.596	1.679
-12	.781	.720	.781	1.358	1.478	1.506	1.658	1.742
-13	.844	.782	.844	1.420	1.541	1.569	1.721	1.804
-14	.906	.845	.906	1.483	1.603	1.631	1.783	1.867
-15	.969	.907	.969	1.545	1.666	1.694	1.846	1.929
-16	1.031	.970	1.031	1.608	1.728	1.756	1.908	1.992

SECOND DASH NUMBER	G GRIP	13 GRIP RANGE		L REF. PLT1081				
		MIN	MAX	-05-(-)	-06-(-)	-08-(-)	-10-(-)	-12-(-)
-17	1.094	1.032	1.094		1.791	1.819	1.971	2.054
-18	1.156	1.095	1.156		1.853	1.881	2.033	2.117
-19	1.219	1.157	1.219		1.916	1.944	2.096	2.179
-20	1.281	1.220	1.281		1.978	2.006	2.158	2.242
-21	1.344	1.282	1.344		2.041	2.069	2.221	2.304
-22	1.406	1.345	1.406		2.103	2.131	2.283	2.367
-23	1.469	1.407	1.469		2.166	2.194	2.346	2.429
-24	1.531	1.470	1.531		2.228	2.256	2.408	2.492
-25	1.594	1.532	1.594		2.291	2.319	2.471	2.554
-26	1.656	1.595	1.656		2.353	2.381	2.533	2.617
-27	1.719	1.657	1.719		2.416	2.444	2.596	2.679
-28	1.781	1.720	1.781		2.478	2.506	2.658	2.742
-29	1.844	1.782	1.844		2.541	2.569	2.721	2.804
-30	1.906	1.845	1.906		2.603	2.631	2.783	2.867
-31	1.969	1.907	1.969		2.666	2.694	2.846	2.929
-32	2.031	1.970	2.031		2.728	2.756	2.908	2.992

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



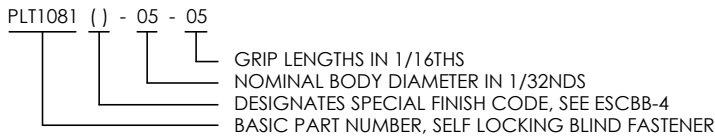
PROCUREMENT SPEC: ESCBB-9 CLASS 3.

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

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

FINISH & LUBRICANT: NUT: DRY FILM LUBE PER AS5272 TYPE I OR EVERLUBE 812 PER MIL-PRF-81329. CETYL ALCOHOL PER AS87132, OPTIONAL.
 SLEEVE: PASSIVATE PER AMS2700. DRY FILM LUBE PER AS5272 TYPE I OR EVERLUBE 812 PER MIL-PRF-81329, WWM CARBO-WAX, PARAFFIN WAX, AND/OR CETYL ALCOHOL PER AS87132, AT MANUFACTURER'S OPTION.
 SCREW: DRY FILM LUBE PER AS5272 TYPE I OR EVERLUBE 812 PER MIL-PRF-81329, WWM CARBO-WAX, PARAFFIN WAX, AND/OR CETYL ALCOHOL PER AS87132, AT MANUFACTURER'S OPTION.

PART CODE & EXAMPLE:



GENERAL NOTES:

1. OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT EXCEED MAXIMUM "E" DIAMETER.
2. CONCENTRICITY OF NUT HEAD CONICAL SURFACE TO "D" DIAMETER SHALL BE WITHIN .005" T.I.R., EXCEPT OVER INDENTATIONS.
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" ABOVE THE INTERSECTION OF THE NUT NOSE ANGLE AND O.D. (MEAN GRIP OF FASTENER). SHANK DIAMETER IN AREA OF LOCKING INDENTS SHALL NOT EXCEED THE MAXIMUM "D" DIAMETER PLUS .001".
5. MANUFACTURER'S IDENTIFICATION: LETTER "N" DESIGNATES MONOGRAM AEROSPACE FASTENERS. LETTERS "VS" DESIGNATE VOI-SHAN.
6. HEAD MARKINGS ON NUT DEPRESSED .010" MAX.
7. HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.
 EXAMPLE: PLT1081-06-4.5 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".
 THE BASIC "G" DIMENSION WILL BE NOMINAL GRIP +.031" AND THE OVERALL SCREW LENGTH "L" DIMENSION MAY VARY AT MANUFACTURER'S OPTION.
8. THESE PARTS HAVE A CLOSE TOLERANCE (.0005") GROUND SHANK AND ARE INTENDED FOR UP TO .0035" DIAMETRAL INTERFERENCE FIT APPLICATIONS.
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" MAX + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS.
10. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.
11. STANDARD FINISHES AND LUBES ARE SHOWN ABOVE. REFER TO ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBES, IF REQUIRED.
12. DIMENSIONS "A", "A'", AND "H" ARE FOR ENGINEERING REFERENCE PURPOSES ONLY AND ARE NOT TO BE USED FOR INSPECTION PURPOSES. THESE DIMENSIONS ARE THEORETICAL VALUES DERIVED FROM "D", "S", "M", "W" AND HEAD ANGLE DIMENSIONS.
13. 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.
14. MAXIMUM "D" DIAMETER MAY BE INCREASED BY .0002" TO ALLOW FOR ALUMINUM COATING APPLICATION.

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

TITLE:
 VISU-LOK, FASTENER, BLIND
 INTERNALLY THREADED, EXTERNAL SLEEVE
 TITANIUM
 100° REDUCED FLUSH HEAD, SELF-LOCKING
 75 KSI SHEAR, 1/64" OVERSIZE

DRAWING NO: PLT1081 () - () - ()	
DRAWN BY: G.MARTINEZ	DRAWN DATE: 08-13-13
APPROVED BY:	CHECKED DATE:

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Alcoa CAGE CODE: 5M902	MONOGRAM CAGE CODE: 98524	ECN NO: 14-0736 ECN DATE: 11/10/14	REV: M SHEET 2 OF 2
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