



PART NUMBER	A THEO DIA.		A' DIA. MIN.		C MAX.		D DIA.		E DIA. MAX.		F FLATS		H REF.		J DIA. MAX.		K MAX.		L REF.		R RAD.	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
PLT1094-06-(-)	.343 .338	8,71 8,59	.311	7,90	.360	9,14	.2336 .2326	5,93 5,90	.2270	5,76	.104 .099	2,64 2,51	.047	1,19	.315	8,00	.333	8,46	.697	17,7	.030 .015	0,76 0,38
PLT1094-08-(-)	.437 .432	11,10 10,97	.405	10,29	.404	10,26	.2946 .2936	7,48 7,46	.2880	7,31	.135 .130	3,43 3,30	.061	1,55	.401	10,19	.366	9,30	.725	18,4	.030 .015	0,76 0,38
PLT1094-10-(-)	.505 .500	12,83 12,70	.473	12,01	.493	12,52	.3466 .3456	8,80 8,77	.3395	8,62	.152 .147	3,86 3,73	.068	1,73	.442	11,23	.447	11,35	.877	22,3	.040 .020	1,02 0,51
PLT1094-12-(-)	.592 .587	15,04 14,91	.560	14,22	.583	14,80	.4096 .4086	10,40 10,38	.4025	10,22	.185 .180	4,70 4,57	.078	1,98	.531	13,49	.527	13,39	.961	24,4	.040 .020	1,02 0,51

PART NUMBER	S MAX.		V GAGE PROT.		W GAGE DIA.		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	mm	IN-LBS	Nm	LBS.	kN	LBS.	kN
PLT1094-06-(-)	.015	0,38	.0324 .0293	0,823 0,744	.2671 .2669	6,784 6,779	+088 -000	+2,24 -0,00	-02	.2375 .2345	6,03 5,96	1.5	0,170	7000	31,1	1400	6,2
PLT1094-08-(-)	.015	0,38	.0273 .0244	0,693 0,620	.3731 .3729	9,477 9,472	+098 -000	+2,49 -0,00	-03	.2985 .2955	7,58 7,50	2.5	0,282	11300	50,2	2100	9,3
PLT1094-10-(-)	.015	0,38	.0312 .0281	0,792 0,714	.4320 .4318	10,973 10,967	+103 -000	+2,62 -0,00	-03	.3500 .3470	8,89 8,81	3.5	0,400	14500	64,5	3600	16,0
PLT1094-12-(-)	.015	0,38	.0456 .0420	1,158 1,067	.4854 .4852	12,329 12,324	+103 -000	+2,62 -0,00	-04	.4130 .4100	10,49 10,41	4.0	0,452	23000	102,3	5600	24,9

▲ "G" TOLERANCES: FOR -06 SIZES +.030/-010 (+0,762/-0,254mm), FOR -08 & -10 SIZES +.040/-010 (+1,016/-0,254mm), FOR -12 SIZES +.050/-010 (+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, SELF LOCKING 100° FLUSH SHEAR HEAD GROUND SHANK, 1/32" OVERSIZE

DRAWING NO:  
PLT1094-(-)-(-)

DRAWN BY:  
B. GEE

APPROVED BY:

DRAWN DATE:  
12/11/13

CHECKED DATE:

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Alcoa CAGE CODE: 5M902

MONOGRAM CAGE CODE: 98524

DCN NO: 14-0848

DCN DATE: 12/8/14

REV: J

SHEET 1 OF 2



PROCUREMENT SPEC: ESCBB-2, CLASS 1, EXCEPT AS SPECIFIED HEREIN.

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 TO HRC 39-46.
SLEEVE: AS REQUIRED FOR PERFORMANCE.

FINISH:

NUT & SCREW: CADMIUM PLATE 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 PLATE PER AMS-QQ-P-416, TYPE 1, CLASS 3.

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

NUT: WWM CARBO-WAX, PARAFFIN WAX, AND/OR CETYL ALCOHOL PER AS87132.
SCREW & SLEEVE: DRY FILM LUBE PER AS5272 OR MIL-PRF-81329, WWM CARBO-WAX, PARAFFIN WAX, AND/OR CETYL ALCOHOL PER AS87132.

PART CODE & EXAMPLE:

PLT1094 - 08 - 08

GRIP LENGTHS IN 1/16THS.
NOMINAL BODY DIAMETER AS TABULATED.
BASIC PART NUMBER, 1/32" OVERSIZE SELF-LOCKING BLIND FASTENER.

GENERAL NOTES:

- 1. CONCENTRICITY OF NUT HEAD CONICAL SURFACE TO "D" DIAMETER SHALL BE WITHIN 0.005" (0.13 mm) T.I.R. (EXCEPT OVER INDENTS)
2. REMOVE ALL LOOSE OR HANGING BURRS.
3. GROUND SHANK VISU-LOKS SHOULD NOT BE USED, EXCEPT WITH CONSIDERABLE CAUTION, IN APPLICATIONS WHICH EXCEED .0005 INTERFERENCE FIT. GROUND SHANK VISU-LOKS WILL PERFORM SATISFACTORILY WHEN INSTALLED IN THE TABULATED HOLE SIZES.

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. HEAD MARKINGS ON NUT DEPRESSED .010" (0.254 mm) MAXIMUM.

7. HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.

EXAMPLE: PLT1094-06-4.5 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.

8. STANDARD GRIP LENGTHS ARE SHOWN AS TABULATED, 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.

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 "D" MAX + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS (22.23 NEWTONS).

10. 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", "V", "W" AND HEAD ANGLE DIMENSIONS.

11. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION

Table with columns: SECOND DASH NUMBER, G GRIP (INCH, mm), GRIP RANGE (MIN, MAX) in INCH and mm. Rows range from -01 to -32.



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Alcoa
CAGE CODE:
5M902

MONOGRAM
CAGE CODE:
98524

DCN NO:
14-0848
DCN DATE:
12/8/14

REV:
J
SHEET 2 OF 2