

PART NUMBER	NOM DIA.	A THEO DIA.	A' DIA. MIN.	C MAX.	D DIA.	E MAX.	F DRIVING FLATS	H REF.	J DIA. MAX.	K MAX.	M GAGE PROT.	R RAD.	S MAX.	W GAGE DIA.	BREAK-OFF LIMITS	PREVAILING TORQUE IN. LBS. MIN.	DOUBLE SHEAR STRENGTH LBS. MIN.	TENSILE STRENGTH LBS. MIN.
PLT1100-12(-)	.3730	.762 .752	.695	.525	.3735 .3730	.3705	.185 .180	.160	.516	.473	.0466 .0407	.040 .020	.023	.6532 .6528	+.010 -.093	4.0	16450	5600

SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF.			
		7 MIN	8 MAX	PLT1100			
-	-	-	-				-12(-)
-04	.281	.220	.281				1.242
-05	.344	.282	.344				1.304
-06	.406	.345	.406				1.367
-07	.469	.407	.469				1.429
-08	.531	.470	.531				1.492
-09	.594	.532	.594				1.554
-10	.656	.595	.656				1.617
-11	.719	.657	.719				1.679
-12	.781	.720	.781				1.742
-13	.844	.782	.844				1.804
-14	.906	.845	.906				1.867
-15	.969	.907	.969				1.929
-16	1.031	.970	1.031				1.992

SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF.			
		7 MIN	8 MAX	PLT1100			
-17	1.094	1.032	1.094				2.054
-18	1.156	1.095	1.156				2.117
-19	1.219	1.157	1.219				2.179
-20	1.281	1.220	1.281				2.242
-21	1.344	1.282	1.344				2.304
-22	1.406	1.345	1.406				2.367
-23	1.469	1.407	1.469				2.429
-24	1.531	1.470	1.531				2.492
-25	1.594	1.532	1.594				2.554
-26	1.656	1.595	1.656				2.617
-27	1.719	1.657	1.719				2.679
-28	1.781	1.720	1.781				2.742
-29	1.844	1.782	1.844				2.804
-30	1.906	1.845	1.906				2.867
-31	1.969	1.907	1.969				2.929
-32	2.031	1.970	2.031				2.992

▲ "G" TOLERANCE: FOR -12 SIZES +.050/- .010.

TITLE:

VISU-LOK, FASTENER, BLIND  
 INTERNALLY THREADED, EXTERNAL SLEEVE  
 TITANIUM, 75KSI SHEAR  
 100° FLUSH HEAD, SELF LOCKING, NOMINAL DIA.  
 CLOSE TOLERANCE GROUND SHANK

DRAWING NO:

PLT1100(-)(-)(-)

DRAWN BY:

B. GEE

DRAWN DATE:

12/13/13

APPROVED BY:

CHECKED DATE:



PROCUREMENT SPEC: ESCBB-9, CLASS 3, EXCEPT AS SPECIFIED HEREIN.

MATERIAL:

NUT & SCREW: 6AL-4V TITANIUM PER AMS4928 OR AMS4967.

SLEEVE: CORROSION RESISTANT STEEL.

HEAT TREAT:

NUT & SCREW: HEAT TREAT PER AMS-H-81200 MAX. HYDROGEN 125 PPM.

SLEEVE: AS REQUIRED FOR PERFORMANCE.

FINISH  $\triangle_6$  :

"-" NUT & SCREW: NONE.

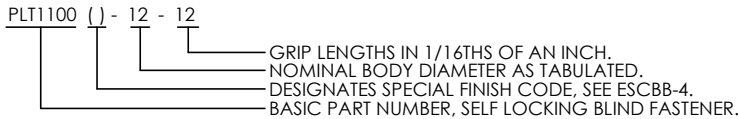
SLEEVE: PASSIVATE PER AMS2700.

LUBRICANT  $\triangle_6$  :

NUT: SOLID FILM LUBE PER AS5272 AND CETYL ALCOHOL PER AS87132.

SCREW & SLEEVE: LUBRICANTS LISTED BELOW MAY BE APPLIED IF REQUIRED FOR PERFORMANCE:  
 DRY FILM LUBE PER AS5272 AND/OR PARAFFIN WAX. CETYL ALCOHOL PER AS87132.

PART CODE & EXAMPLE:



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 INDENTATIONS.

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. MANUFACTURER'S IDENTIFICATION:  
 LETTER "N" DESIGNATES MONOGRAM AEROSPACE FASTENERS.  
 LETTERS "VS" DESIGNATE VOI-SHAN.

5. HEAD MARKINGS ON NUT DESPRESSED .010" MAXIMUM. LOCATION OPTIONAL.

6. STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.

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

EXAMPLE: PLT1100-12-4.5 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.

8. 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.

9. THESE PARTS HAVE A CLOSE TOLERANCE (.0005) GROUND SHANK AND ARE INTENDED FOR USE IN UP TO .0035 DIAMETRAL INTERFERENCE FIT APPLICATIONS.

10. 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).

11. 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.

12. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.



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 INTERNALLY THREADED, EXTERNAL SLEEVE  
 TITANIUM, 75KSI SHEAR  
 100° FLUSH HEAD, SELF LOCKING, NOMINAL DIA.  
 CLOSE TOLERANCE GROUND SHANK

DRAWING NO:

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 SHEET 2 OF 2