

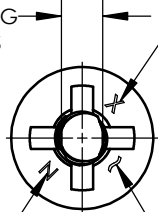


△ DISTORTION OF "D" DIA. PERMISSIBLE IN LOCKING AREA

△ VISUAL MECHANICAL LOCK

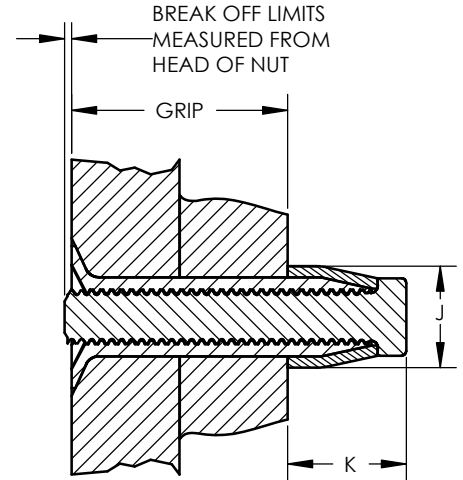
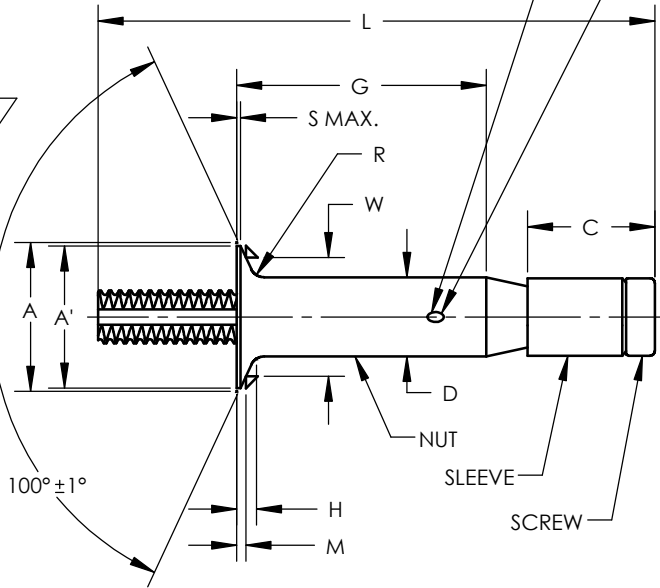
FINISH CODE LETTER "X"
DN "X" CODED PARTS ONLY

F
DRIVING
FLATS



FASTENER IDENTIFICATION

MANUFACTURER'S IDENTIFICATION
MONOGRAM = N
VOI-SHAN = VS



TYPICAL INSTALLATION

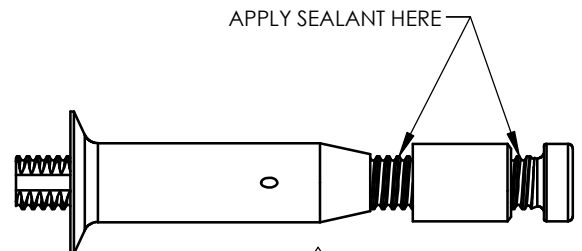
PART NUMBER	NOM DIA.		△ THEO DIA.		△ A' DIA. MIN.		C MAX.		D DIA.		F DRIVING FLATS		△ H REF.		J DIA. MAX.		K MAX.	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
PLT175-06(-)	.1890	4,801	.385 .378	9,78 9,60	.342	8,69	.320	8,13	.1900 .1880	4,826 4,775	.104 .099	2,64 2,51	.081	2,06	.300	7,62	.288	7,31
PLT175-08(-)	.2480	6,230	.507 .499	12,88 12,67	.463	11,76	.365	9,27	.2490 .2470	6,325 6,273	.135 .130	3,43 3,30	.107	2,72	.384	9,75	.320	8,13

PART NUMBER	M GAGE PROT.		R RAD.		S MAX.		W GAGE DIA.		HOLE SIZE		△ BREAK-OFF LIMITS		△ PREVAILING TORQUE IN. LBS. MIN.		DOUBLE SHEAR STRENGTH LBS. MIN.		TENSILE STRENGTH LBS. MIN.	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	IN-LBS	Nm	LBS.	N	LBS.	N
PLT175-06(-)	.0299 .0259	0,760 0,658	.030	0,76 0,38	.015	0,38	.3147 .3143	7,993 7,983	.193 .190	4,90 4,82	+0.15 -0.073	+0.38 -1.85	1.5	0,170	4200	18680	1400	6230
PLT175-08(-)	.0353 .0307	0,897 0,907	.015	0,38	.015	0,38	.4245 .4241	10,782 10,772	.252 .249	6,40 6,32	+0.10 -0.078	+0.25 -1.98	2.5	0,282	7200	32030	2100	9340

SEE PLT170 FOR -05; -10; & -12 DIAMETERS

PART CODE & EXAMPLE:
PLT175 X 08 - 08

GRIP LENGTHS IN 1/16THS OF AN INCH (1,59 mm)
NOMINAL BODY DIAMETER IN 1/32NDS OF AN INCH (0,79 mm)
DESIGNATES SPECIAL FINISH CODE, SEE ESCBB-4
BASIC CODE, SELF LOCKING BLIND FASTENER



△ FIGURE 1.
(e.g. PLT175SA-08-08 OR PLT175XSA-08-08)



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

TITLE:

VISU-LOK, FASTENER, BLIND
INTERNALLY THREADED, EXTERNAL SLEEVE
100° FLUSH HEAD, SELF LOCKING
FRACTIONAL DIAMETER, 75 KSI SHEAR
TITANIUM

DRAWING NO:

PLT175(-)(-)(-)

DRAWN BY:

G.MARTINEZ

DRAWN DATE:

07-16-13

APPROVED BY:

CHECKED DATE:

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Alcoa
CAGE CODE:
5M902

MONOGRAM
CAGE CODE:
98524

ECN NO:
14-0666
ECN DATE:
11/02/14

REV:
V
SHEET 1 OF 2



PROCUREMENT SPEC: ESCBB-9, CLASS 2.

MATERIAL:

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

SLEEVE: CORROSION RESISTANT STEEL.

HEAT TREAT:

NUT & SCREW: HEAT TREAT PER AMS-H-81200, TO 95 KSI FSU MIN. MAX HYDROGEN 125 PPM.

SLEEVE: AS REQUIRED FOR PERFORMANCE.

FINISH:

(-) NUT & SCREW: NONE.

SLEEVE: PASSIVATE PER AMS2700.

(X) NUT: I.V.D. ALUMINUM COAT PER MIL-DTL-83488.

SCREW: KAL-GARD ANN-RD #1012 OPTIONAL.

SLEEVE: PASSIVATE PER AMS2700. KAL-GARD ANN-RD #1013 OPTIONAL.

LUBRICANT:

(-) NUT, SCREW, & SLEEVE: DRY FILM LUBE & CETYL, OPTIONAL & AS REQUIRED.

(X) NUT: CARBO-WAX, PARAFFIN WAX, TIOLON A-20, TIOLON X-20 OR CETYL ALCOHOL AS REQUIRED FOR PERFORMANCE.

SCREW & SLEEVE: LUBRICANTS USED ON SLEEVES AND SCREWS MUST NOT CONTAIN SULFIDES OR GRAPHITE. EXAMPLE OF ACCEPTABLE LUBRICANTS ARE TIO-LON X-20 AND A-20, KAL-GARD FC-2, AND THOSE LUBRICANTS LISTED ABOVE FOR THE NUT COMPONENT.

("SA" & "XSA") DRY FILM LUBE AS REQUIRED FOR PERFORMANCE.

SECOND DASH NUMBER										
	GRIP		MIN		MAX		-06(-)		-08(-)	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
-02	.156	3.96	.094	2.39	.156	3.96	.853	22.67	-	-
-03	.219	5.56	.157	3.99	.219	5.56	.916	23.27	.944	23.978
-04	.281	7.14	.220	5.59	.281	7.14	.978	24.84	1.006	25.557
-05	.344	8.74	.282	7.16	.344	8.74	1.041	26.441	1.069	27.153
-06	.406	10.31	.345	8.76	.406	10.31	1.103	28.016	1.131	28.727
-07	.469	11.91	.407	10.34	.469	11.91	1.166	29.616	1.194	30.328
-08	.531	13.49	.470	11.94	.531	13.49	1.228	31.191	1.256	31.902
-09	.594	15.11	.532	13.51	.594	15.11	1.291	32.791	1.319	33.503
-10	.656	16.66	.595	15.11	.656	16.66	1.353	34.366	1.381	35.077
-11	.719	18.26	.657	16.69	.719	18.26	1.416	35.966	1.444	36.678
-12	.781	19.84	.720	18.29	.781	19.84	1.478	37.541	1.506	38.252
-13	.844	21.44	.782	19.86	.844	21.44	1.541	39.141	1.569	39.853
-14	.906	23.01	.845	21.46	.906	23.01	1.603	40.716	1.631	41.427
-15	.969	24.61	.907	23.04	.969	24.61	1.666	42.316	1.694	43.028
-16	1.031	26.19	.970	24.64	1.031	26.19	1.728	43.891	1.756	44.602
-17	1.094	27.79	1.032	26.21	1.094	27.79	1.791	45.491	1.819	46.203
-18	1.156	29.36	1.095	27.81	1.156	29.36	1.853	47.066	1.881	47.777
-19	1.219	30.96	1.157	29.39	1.219	30.96	1.916	48.666	1.944	49.378
-20	1.281	32.54	1.220	30.99	1.281	32.54	1.978	50.241	2.006	50.952
-21	1.344	34.14	1.282	32.56	1.344	34.14	2.041	51.841	2.069	52.553
-22	1.406	35.71	1.345	34.16	1.406	35.71	2.103	53.416	2.131	54.127
-23	1.469	37.31	1.407	35.74	1.469	37.31	2.166	55.016	2.194	55.728
-24	1.531	38.89	1.470	37.34	1.531	38.89	2.228	56.591	2.256	57.302
-25	1.594	40.49	1.532	38.91	1.594	40.49	2.291	58.191	2.319	58.903
-26	1.656	42.06	1.595	40.51	1.656	42.06	2.353	59.766	2.381	60.477
-27	1.719	43.66	1.657	42.09	1.719	43.66	2.416	61.366	2.444	62.078
-28	1.781	45.24	1.720	43.69	1.781	45.24	2.478	62.941	2.506	63.652
-29	1.844	46.84	1.782	45.26	1.844	46.84	2.541	64.541	2.569	65.253
-30	1.906	48.41	1.845	46.86	1.906	48.41	2.603	66.116	2.631	66.827
-31	1.969	50.01	1.907	48.44	1.969	50.01	2.666	67.716	2.694	68.428
-32	2.031	51.59	1.970	50.04	2.031	51.59	2.728	69.291	2.756	70.029

GENERAL NOTES:

- LOCKING FEATURE CONSISTS OF THREE (3) INDENTATIONS LOCATED 120° APART ON THE PERIPHERY OF THE NUT COMPONENT.
- FASTENER IDENTIFICATION: "175" IN ONE QUADRANT OF "5175" IN TWO QUADRANTS.
- HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.
EXAMPLE: PLT175-06-4.5 INDICATES A NOMINAL GRIP LENGTH OF 4.5 SIXTEENTHS (.281" = 7.14 mm). THE GRIP RANGE FOR THESE HALF-GRIP SIZES WILL BE NOMINAL GRIP +.031"/-.030" (+0.79/-0.79 mm). THE BASIC "G" DIMENSION WILL BE NOMINAL GRIP +.031 (+0.79) AND THE OVERALL SCREW LENGTH "L" DIMENSION MAY VARY AT MANUFACTURER'S OPTION.
- 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.
- "SA" PARTS ARE PARTIALLY DIASSEMBLED TO PERMIT THE APPLICATION OF WET SEALANT AS SHOWN IN FIGURE 1., SEE SHEET 1. ("SA" PARTS MUST HAVE SEALANT APPLIED FOR PROPER FUNCTION).
6. MAXIMUM RECOMMENDED TEMPERATURE 750°F.
- 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).
8. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.
9. OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT BE GREATER THAN MAXIMUM "D" DIAMETER.
10. CONCENTRICITY OF NUT HEAD CONICAL SURFACE TO "D" DIAMETER SHALL BE WITHIN .005" T.I.R., EXCEPT OVER INDENTATIONS.
11. REMOVE ALL LOOSE OR HANGING BURRS.
- 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.
13. "G" TOLERANCES: FOR -06 SIZE +.030/-0.010 (+0.762/-0.254mm), FOR -08 SIZE +.040/-0.010 (+1.016/-0.254mm).



TITLE:
 VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE 100° FLUSH HEAD, SELF LOCKING FRACTIONAL DIAMETER, 75 KSI SHEAR TITANIUM

DRAWING NO:
 PLT175(-)(-)(-)

DRAWN BY: G.MARTINEZ DRAWN DATE: 07-16-13

APPROVED BY: CHECKED DATE:

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Alcoa CAGE CODE: 5M902

MONOGRAM CAGE CODE: 98524

ECN NO: 14-0666 ECN DATE: 11/02/14

REV: V SHEET 2 OF 2