

PART NUMBER	NOM. DIA.		A		C MAX.		D DIA.		E DIA. MAX		F DRIVING FLATS		H MAX.		J DIA MAX.		K MAX.	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
PLT254-05-(-)	.1640	4,166	.250 .244	6,35 6,19	.285	7,24	.1645 .1635	4,179 4,152	.1615	4,11	.086 .081	2,19 2,05	.096	2,44	.244	6,20	.257	6,53
PLT254-06-(-)	.2021	5,133	.312 .305	7,93 7,74	.320	8,13	.2026 .2016	5,147 5,120	.1995	5,07	.104 .099	2,65 2,51	.113	2,88	.300	7,62	.288	7,32
PLT254-08-(-)	.2646	6,721	.375 .367	9,53 9,32	.355	9,02	.2651 .2641	6,734 6,708	.2621	6,66	.135 .130	3,43 3,30	.135	3,43	.384	9,76	.320	8,13
PLT254-10-(-)	.3115	7,912	.437 .429	11,10 10,89	.440	11,18	.3120 .3110	7,925 7,899	.3090	7,85	.152 .147	3,87 3,73	.160	4,07	.427	10,85	.396	10,06
PLT254-12-(-)	.3740	9,500	.500 .491	12,70 12,47	.525	13,34	.3745 .3735	9,513 9,486	.3715	9,44	.185 .180	4,70 4,57	.190	4,83	.516	13,11	.473	12,02

PART NUMBER	N MIN.		R RAD.		HOLE SIZE		BREAK-OFF LIMITS		PREVAILING TORQUE MIN		DOUBLE SHEAR STRENGTH MIN		TENSILE STRENGTH MIN	
	INCH	MM	INCH	mm	INCH	mm	INCH	mm	INCH-LBS	Nm	LBS	N	LBS	N
PLT254-05-(-)	.272	6,90	.025 .020	0,64 0,50	.1680 .1650	4,267 4,191	+0,88 +0,00	+2,24 +0,00	1.0	0,11	4680	20818	1350	6005
PLT254-06-(-)	.340	8,63	.030 .025	0,77 0,63	.2060 .2030	5,232 5,157	+0,98 +0,10	+2,49 +0,25	1.5	0,16	6900	30693	2100	9341
PLT254-08-(-)	.409	10,38	.035 .030	0,89 0,76	.2685 .2655	6,819 6,744	+1,35 +0,47	+3,43 +1,19	2.5	0,28	11800	52489	3650	16236
PLT254-10-(-)	.479	12,16	.045 .035	1,15 0,88	.3150 .3120	8,001 7,925	+1,46 +0,43	+3,71 +1,09	3.5	0,39	17000	75620	5200	23131
PLT254-12-(-)	.548	13,91	.045 .035	1,15 0,88	.3780 .3750	9,601 9,525	+1,52 +0,49	+3,87 +1,24	4.0	0,45	24500	108981	7500	33362



PROCUREMENT SPEC: ESCBB-10.

MATERIAL:

NUT & SCREW: 5% CHROME STEEL (H-11) PER AMS6487.

SLEEVE: UNS N07750 PER AMS5667 OR AMS5582; OR A286 WITH CHEMISTRY PER AMS5731 AND AMS5734.

HEAT TREAT:

NUT & SCREW: ROCKWELL "C" 48-53.

SLEEVE: AS REQUIRED FOR PERFORMANCE.

FINISH: \triangle 4

(-) CODE

NUT & SCREW: CADMIUM PLATE PER NAS672 (0.0003 MIN. THICKNESS) EXCEPT THERMAL INDICATOR MAY BE OMITTED. COLOR NUT RED.

SLEEVE: CADMIUM PLATE PER AMS-QQ-P-416, TYPE I, CLASS 3, OR TYPE II, CLASS 2

"L" CODE

NUT & SLEEVE: ALUMINUM COAT PER NAS4006.

SCREW:

CADMIUM PLATE PER NAS672 (0.0003 MIN. THICKNESS) EXCEPT THERMAL INDICATOR MAY BE OMITTED.

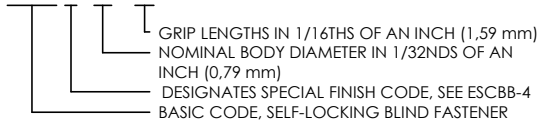
LUBRICANT:

LUBRICANTS LISTED BELOW MAY BE APPLIED TO ANY OR ALL COMPONENTS IF REQUIRED FOR PERFORMANCE.

DRY FILM LUBE PER AS5272 (TYPE I OR TYPE III), OR EVERLUBE 812, PARAFFIN WAX CETYL ALCOHOL PER AS87132, AND OR WWM CARBO-WAX.

PART CODE & EXAMPLE:

PLT254 L - 05 - 05



SECOND DASH NUMBER	\triangle G GRIP		\triangle \triangle GRIP RANGE				L REF.												
							PLT254												
	IN	mm	IN	mm	IN	mm	-05(-)		-06(-)		-08(-)		-10(-)		-12(-)				
-01	.093	2.37	.031	0.79	.093	2.37	.713	18.11	.850	21.59	-	-	-	-	-	-	-	-	-
-02	.156	3.96	.094	2.38	.156	3.96	.775	19.68	.912	23.16	.972	24.69	1.189	30.20	-	-	-	-	-
-03	.219	5.56	.157	3.98	.219	5.56	.838	21.29	.975	24.76	1.035	26.29	1.252	31.80	1.324	33.63	-	-	-
-04	.281	7.14	.220	5.58	.281	7.14	.900	22.86	1.037	26.34	1.097	27.86	1.314	33.38	1.386	35.20	-	-	-
-05	.344	8.74	.282	7.15	.344	8.74	.963	24.46	1.100	27.94	1.160	29.46	1.377	34.98	1.449	36.80	-	-	-
-06	.406	10.31	.345	8.75	.406	10.31	1.025	26.04	1.162	29.51	1.222	31.04	1.439	36.55	1.511	38.38	-	-	-
-07	.469	11.91	.407	10.33	.469	11.91	1.088	27.64	1.225	31.12	1.285	32.64	1.502	38.15	1.574	39.98	-	-	-
-08	.531	13.49	.470	11.93	.531	13.49	1.150	29.21	1.287	32.69	1.347	34.21	1.564	39.73	1.636	41.55	-	-	-
-09	.594	15.09	.532	13.50	.594	15.09	1.213	30.81	1.350	34.29	1.410	34.81	1.627	41.33	1.699	43.15	-	-	-
-10	.656	16.66	.595	15.10	.656	16.66	1.275	32.38	1.412	35.86	1.472	37.39	1.689	42.90	1.761	44.73	-	-	-
-11	.719	18.26	.657	16.68	.719	18.26	1.338	33.99	1.475	37.46	1.535	38.99	1.752	44.50	1.824	46.33	-	-	-
-12	.781	19.84	.720	18.28	.781	19.84	1.400	35.56	1.537	39.04	1.597	40.56	1.814	46.06	1.886	47.90	-	-	-
-13	.844	21.44	.782	19.85	.844	21.44	1.463	37.16	1.600	40.64	1.660	42.16	1.877	47.68	1.949	49.50	-	-	-
-14	.906	23.01	.845	21.45	.906	23.01	1.525	38.74	1.662	42.21	1.722	43.74	1.939	49.25	2.011	51.08	-	-	-
-15	.969	24.61	.907	23.03	.969	24.61	1.588	40.34	1.725	43.82	1.785	45.34	2.002	50.85	2.074	52.68	-	-	-
-16	1.031	26.19	.970	24.63	1.031	26.19	1.650	41.91	1.787	45.39	1.847	46.91	2.064	52.43	2.136	54.25	-	-	-
-17	1.094	27.79	1.032	26.20	1.094	27.79	-	-	1.850	46.99	1.910	48.51	2.127	54.03	2.199	55.85	-	-	-
-18	1.156	29.36	1.095	27.80	1.156	29.36	-	-	1.912	48.56	1.972	50.09	2.189	55.60	2.261	57.43	-	-	-
-19	1.219	30.96	1.157	29.38	1.219	30.96	-	-	1.975	50.16	2.035	51.69	2.252	57.20	2.324	59.03	-	-	-
-20	1.281	32.54	1.220	30.98	1.281	32.54	-	-	2.037	51.74	2.097	53.26	2.314	58.78	2.386	60.60	-	-	-
-21	1.344	34.14	1.282	32.55	1.344	34.14	-	-	2.100	53.34	2.160	54.86	2.377	60.38	2.449	62.20	-	-	-
-22	1.406	35.71	1.345	34.15	1.406	35.71	-	-	2.165	54.91	2.222	56.44	2.439	61.95	2.511	63.78	-	-	-
-23	1.469	37.31	1.407	35.73	1.469	37.31	-	-	2.225	56.52	2.285	58.04	2.502	63.55	2.574	65.38	-	-	-
-24	1.531	38.89	1.470	37.33	1.531	38.89	-	-	2.287	58.09	2.347	59.61	2.564	65.13	2.636	66.95	-	-	-
-25	1.594	40.49	1.532	38.90	1.594	40.49	-	-	2.350	59.69	2.410	61.21	2.627	66.73	2.699	68.55	-	-	-
-26	1.656	42.06	1.595	40.50	1.656	42.06	-	-	2.412	61.26	2.472	62.79	2.689	68.30	2.761	70.13	-	-	-
-27	1.719	43.66	1.657	42.08	1.719	43.66	-	-	2.475	62.86	2.535	64.39	2.752	69.90	2.824	71.73	-	-	-
-28	1.781	45.24	1.720	43.68	1.781	45.24	-	-	2.537	64.44	2.597	65.96	2.814	71.48	2.886	73.30	-	-	-
-29	1.844	46.84	1.782	45.25	1.844	46.84	-	-	2.600	66.04	2.660	67.56	2.877	73.08	2.949	74.90	-	-	-
-30	1.906	48.41	1.845	46.85	1.906	48.41	-	-	2.662	67.61	2.722	69.14	2.939	74.65	3.011	76.47	-	-	-
-31	1.969	50.01	1.907	48.43	1.969	50.01	-	-	2.725	69.22	2.785	70.74	3.002	76.25	3.074	78.08	-	-	-
-32	2.031	51.59	1.970	50.03	2.031	51.59	-	-	2.787	70.79	2.847	72.31	3.064	77.83	3.136	79.65	-	-	-

NOT AVAILABLE IN -05 DIAMETER

GENERAL NOTES:

- DIMENSIONS ARE EXCLUSIVE OF LUBRICATION. SI UNIT VALUES ARE REFERENCE CONVERSION VALUES ROUNDED TO ENCOMPASS THE LIMITING ENGLISH UNIT VALUES LISTED.
 - FASTENERS SHALL BE FREE OF ALL LOOSE OR HANGING BURRS.
 - \triangle 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).
 - \triangle 4 STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.
 - \triangle 5 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.
 - \triangle 6 HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.
- EXAMPLE: PLT254-06-4.5 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/-0.030 (+0.79/-0.76 mm). THE NOMINAL "G" DIMENSION WILL BE NOMINAL GRIP ±.031 (±0.79 mm) AND THE OVERALL SCREW LENGTH "L" DIMENSION MAY VARY AT THE MANUFACTURER'S OPTION.
- \triangle 7 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" + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS (22.23 NEWTONS).
 - \triangle 8 GROUND SHANK VISU-LOK BLIND FASTENERS SHOULD NOT BE USED EXCEPT WITH CONSIDERABLE CAUTION IN APPLICATIONS WHICH EXCEED APPROXIMATELY .0005" INTERFERENCE FIT. GROUND SHANK VISU-LOK BLIND FASTENERS WILL PERFORM SATISFACTORILY WHEN INSTALLED IN THE TABULATED HOLE SIZES.
 - HEAD MARKINGS DEPRESSED .010" (0.254 mm MAX), POSITION OPTIONAL.
 - \triangle 10 "G" TOLERANCES: FOR -05 & -06 SIZES +.030/-0.10 (+0.762/-0.254 mm); FOR -08 & -10 SIZES +.040/-0.10 (+1.016/-0.254 mm); FOR -12 SIZES +.050/-0.10 (+1.270/-0.254 mm).

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

TITLE:
VISU-LOK, FASTENER, BLIND
INTERNALLY THREADED, EXTERNAL SLEEVE
HIGH STRENGTH, 5% CHROME STEEL (H-11)
PROTRUDING HEX HEAD, SELF LOCKING
GROUND SHANK

DRAWING NO: PLT254(-)(-)(-)	
DRAWN BY: G.MARTINEZ	DRAWN DATE: 07-24-13
APPROVED BY:	CHECKED DATE:

PROPRIETARY AND CONFIDENTIAL:
NOTICE: THIS DRAWING IS PART OF THE PROPRIETARY ARTICLE HEREIN DISCLOSED, OWNED BY MONOGRAM AEROSPACE FASTENERS. ANY PARTY BY ACCEPTING THIS DOCUMENT ASSUME CUSTODY THEREOF AND AGREES:
A. THE INFORMATION SET FORTH HEREIN IS GIVEN IN CONFIDENCE AND THIS DOCUMENT WILL NOT BE COPIED OR REPRODUCED IN WHOLE OR IN PART, NOR ITS CONTENTS REVEALED IN ANY MANNER TO ANY PERSON EXCEPT TO MEET THE PURPOSE FOR WHICH IT WAS DELIVERED.
B. WITHOUT THE WRITTEN CONSENT OF MONOGRAM AEROSPACE FASTENERS, THIS DOCUMENT AND THE INFORMATION CONTAINED HEREIN UNDER NO CIRCUMSTANCES WILL BE USED IN THE MANUFACTURE OR REPRODUCTION OF THE ARTICLE DISCLOSED, AND THE DELIVERY OF THIS DOCUMENT SHALL NOT CONSTITUTE ANY RIGHT OR LICENSE TO DO SO.

Alcoa CAGE CODE: 5M902	MONOGRAM CAGE CODE: 98524	ECN NO: 14-0685 ECN DATE: 11/05/14	REV: AA SHEET 2 OF 2
-------------------------------------	--	---	----------------------------