

PART NUMBER	NOM DIA	A	C MAX	D DIA	F DRIVING FLATS	H MAX	J DIA MAX	K MAX	N MIN	R RAD	HOLE SIZE	BREAK-OFF LIMITS	PREVAILING TORQUE IN. LBS. MIN	DOUBLE SHEAR STRENGTH LBS. MIN	TENSILE STRENGTH LBS. MIN
PLT270-05-()	.1635	.250 .244	.285	.1645 .1625	.086 .081	.096	.244	.257	.272	.020 .010	.168 .165	+0.088 +0.000	1.0	3150	900
PLT270-06-()	.1980	.312 .305	.320	.1990 .1970	.104 .099	.113	.300	.288	.340	.025 .015	.202 .199	+0.098 +0.010	1.5	4600	1400
PLT270-08-()	.2590	.375 .367	.355	.2600 .2580	.135 .130	.135	.384	.320	.409	.025 .015	.263 .260	+0.135 +0.047	2.5	7900	2100
PLT270-10-()	.3105	.437 .429	.440	.3115 .3095	.152 .147	.160	.427	.393	.479	.030 .015	.315 .312	+0.146 +0.043	3.5	11350	3600
PLT270-12-()	.3735	.500 .491	.525	.3745 .3725	.185 .180	.190	.516	.473	.548	.030 .015	.378 .375	+0.152 +0.049	4.0	16450	5600

SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF. PLT270				
		MIN	MAX	-05-()	-06-()	-08-()	-10-()	-12-()
-01	.093	.031	.093	.733	.874	-	-	-
-02	.156	.094	.156	.795	.936	1.006	1.158	-
-03	.219	.157	.219	.858	.999	1.069	1.221	1.367
-04	.281	.220	.281	.920	1.061	1.131	1.283	1.429
-05	.344	.282	.344	.983	1.124	1.194	1.346	1.492
-06	.406	.345	.406	1.045	1.186	1.256	1.408	1.554
-07	.469	.407	.469	1.108	1.249	1.319	1.471	1.617
-08	.531	.470	.531	1.170	1.311	1.381	1.533	1.679
-09	.594	.532	.594	1.233	1.374	1.444	1.596	1.742
-10	.656	.595	.656	1.295	1.436	1.506	1.658	1.804
-11	.719	.657	.719	1.358	1.499	1.569	1.721	1.867
-12	.781	.720	.781	1.420	1.561	1.631	1.783	1.929
-13	.844	.782	.844	1.483	1.624	1.694	1.846	1.992
-14	.906	.845	.906	1.545	1.686	1.756	1.908	2.054
-15	.969	.907	.969	1.608	1.749	1.819	1.971	2.117
-16	1.031	.970	1.031	1.670	1.811	1.881	2.033	2.179

SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF. PLT270				
		MIN	MAX	-05-()	-06-()	-08-()	-10-()	-12-()
-17	1.094	1.032	1.094	1.874	1.944	2.096	2.242	
-18	1.156	1.095	1.156	1.936	2.006	2.158	2.304	
-19	1.219	1.157	1.219	1.999	2.069	2.221	2.367	
-20	1.281	1.220	1.281	2.061	2.131	2.283	2.429	
-21	1.344	1.282	1.344	2.124	2.194	2.346	2.492	
-22	1.406	1.345	1.406	2.186	2.256	2.408	2.554	
-23	1.469	1.407	1.469	2.249	2.319	2.471	2.617	
-24	1.531	1.470	1.531	2.311	2.381	2.533	2.679	
-25	1.594	1.532	1.594	2.374	2.444	2.596	2.742	
-26	1.656	1.595	1.656	2.436	2.506	2.658	2.804	
-27	1.719	1.657	1.719	2.499	2.569	2.721	2.867	
-28	1.781	1.720	1.781	2.561	2.631	2.783	2.929	
-29	1.844	1.782	1.844	2.624	2.694	2.846	2.992	
-30	1.906	1.845	1.906	2.686	2.756	2.908	3.054	
-31	1.969	1.907	1.969	2.749	2.819	2.971	3.117	
-32	2.031	1.970	2.031	2.811	2.881	3.033	3.179	

▲ "G" TOLERANCE: FOR -05 AND -06 SIZES +.030/-0.10; FOR -08 & -10 SIZES +.040/-0.10; FOR -12 SIZE +.050/-0.10.



PROCUREMENT SPEC: ESCBB-9, CLASS 2. EXCEPT AS NOTED 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: "L" NUT & SCREW: NONE
SLEEVE: PASSIVATE PER AMS2700.

"L" NUT: ALUMINUM COAT PER NAS4006.
SLEEVE: PASSIVATE PER AMS2700 AND ALUMINUM COAT PER NAS4006.
SCREW: NONE.

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

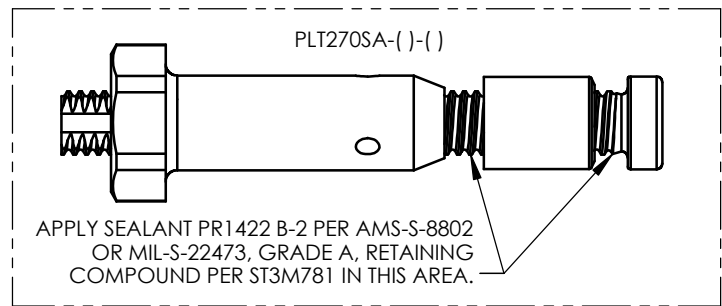
DRY FILM LUBE PER AS5272 OR MIL-PRF-81329, WWM CARBO-WAX, PARAFFIN WAX AND/OR CETYL ALCOHOL PER AS87132.

PART CODE & EXAMPLE: PLT270 - 05 - 05

GRIP LENGTHS IN 1/16THS
NOMINAL BODY DIAMETER AS TABULATED
DASH (-) INDICATES STANDARD LUBRICATION AND FINISH
BASIC PART NUMBER, SELF LOCKING BLIND FASTENER
(BASIC PART NUMBER: PLT270SA(-)-5-5 USE FOR SEALANT APPLICATION)

GENERAL NOTES:

- OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT EXCEED MAXIMUM "D" DIAMETER.
- REMOVE ALL LOOSE OR HANGING BURRS.
- 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).
- MANUFACTURER'S IDENTIFICATION: (REFER TO NOTE 7 FOR INTERIM IDENTIFICATION)
LETTER "N" DESIGNATES MONOGRAM AEROSPACE FASTENERS.
LETTERS "VS" DESIGNATE VOI-SHAN.
- HEAD MARKINGS ON NUT DEPRESSED .010 MAX.
- STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.
- HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.
EXAMPLE: PLT270-06-4.5 INDICATES A NOMINAL GRIP LENGTH OF 4.5 SIXTEENTHS = .281.
THE GRIP RANGE FOR THESE HALF-GRIP SIZES WILL BE NOMINAL GRIP +.031/-0.030.
THE BASIC "G" DIMENSION WILL BE NOMINAL GRIP +.031 AND THE OVERALL SCREW LENGTH "L" DIMENSION MAY VARY AT MANUFACTURER'S OPTION.
- 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.
- 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.
- DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.



MONOGRAM AEROSPACE FASTENERS
a TriMas company
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COMMERCE, CALIFORNIA 90040
(323) 722-4760 FAX (323) 727-1029

TITLE:
VISU-LOK, FASTENER, BLIND
INTERNALLY THREADED, EXTERNAL SLEEVE
TITANIUM
PROTRUDING HEX HEAD, SELF LOCKING
75 KSI SHEAR

DRAWING NO:
PLT270-()-()

DRAWN BY: G.MARTINEZ DRAWN DATE: 06-22-13

APPROVED BY: CHECKED DATE:

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REV: H
SHEET 2 OF 2