

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.
PLT271-05-()	.179	.250 .244	.315	.1800 .1780	.086 .081	.096	.244	.300	.272	.020 .010	.183 .180	+0.088 +0.000	1.0	3150	900
PLT271-06-()	.214	.312 .305	.350	.2150 .2130	.104 .099	.113	.300	.333	.340	.025 .015	.218 .215	+0.098 +0.010	1.5	4600	1400
PLT271-08-()	.275	.375 .367	.385	.2760 .2740	.135 .130	.135	.384	.366	.409	.025 .015	.279 .276	+0.135 +0.047	2.5	7900	2100
PLT271-10-()	.326	.437 .429	.470	.3270 .3250	.152 .147	.160	.427	.447	.479	.030 .015	.330 .327	+0.146 +0.043	3.5	11350	3600
PLT271-12-()	.389	.500 .491	.555	.3900 .3880	.185 .180	.190	.516	.527	.548	.030 .015	.393 .390	+0.152 +0.049	4.0	16450	5600

SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF. PLT271				
		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. PLT271				
		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/-0.010; FOR -08 & -10 SIZES +.040/-0.010; FOR -12 SIZE +.050/-0.010.

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
TITANIUM
PROTRUDING HEX HEAD, SELF LOCKING
1/64" OVERSIZE

DRAWING NO:
PLT271() () - () - ()

DRAWN BY: G.MARTINEZ DRAWN DATE: 07-24-13

APPROVED BY: CHECKED DATE:

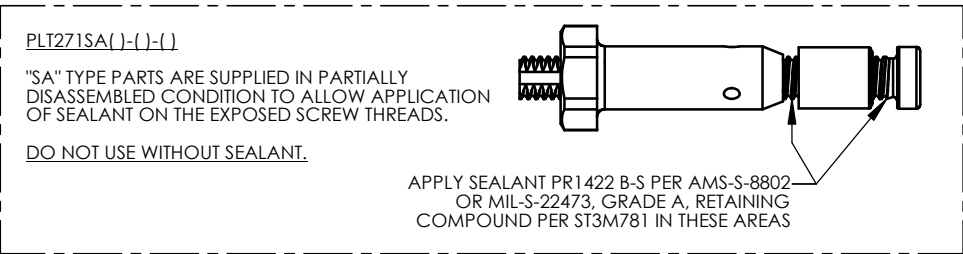
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CAGE CODE:
5M902

MONOGRAM
CAGE CODE:
98524

ECN NO:
14-0687
ECN DATE:
11/05/14

REV:
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SHEET 1 OF 2



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.

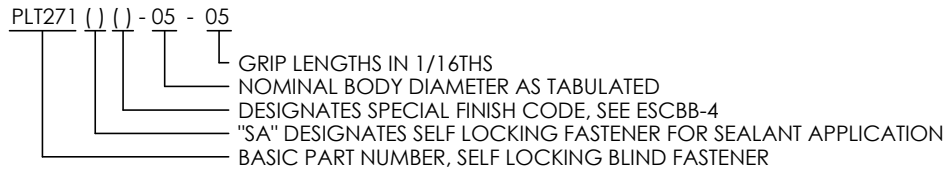
FINISH: "-" NUT & SCREW: NONE
SLEEVE: PASSIVATE PER AMS2700.

"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:



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:
LETTER "N" DESIGNATES MONOGRAM AEROSPACE FASTENERS.
LETTERS "VS" DESIGNATE VOI-SHAN.
 - HEAD MARKINGS ON NUT DEPRESSED .010 MAX. LOCATION OPTIONAL.
 - HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.
- EXAMPLE: PLT271-06-4.5 INDICATES A NOMINAL GRIP LENGTH OF 4.5 SIXTEENTHS = .281.
THE GRIP RANGE FOR THESE HALF-GRIP SIZES WILL BE NOMINAL GRIP +.031/-.030.
THE BASIC "G" DIMENSION WILL BE NOMINAL GRIP +.031 AND THE OVERALL SCREW LENGTH "L" DIMENSION MAY VARY AT MANUFACTURER'S OPTION.
- STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.
 - 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.



TITLE:
VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE TITANIUM PROTRUDING HEX HEAD, SELF LOCKING 1/64" OVERSIZE

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DRAWN BY: G.MARTINEZ	DRAWN DATE: 07-24-13
APPROVED BY:	CHECKED DATE:

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SHEET 2 OF 2