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<th>C MAX.</th>
<th>D THEO. DIA.</th>
<th>E THEO. DIA.</th>
<th>F FLATS</th>
<th>H REF.</th>
<th>J MAX.</th>
<th>K MAX.</th>
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**PART NUMBER: PLT5115-(-) (-)**

**TITLE:** VISU-LOK® II, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE ALLOY STEEL 100° FLUSH TENSION HEAD, SELF-LOCKING FRACTIONAL DIAMETER

**DRAWING NO.: PLT5115-(-) (-)**

**DRAWN BY:** G. MARTINEZ 08-14-13

**REV.: F**

**ECN NO.: 14-0767**

**ECN DATE:** 11/15/14

**DRAWN DATE:** SHEET 1 OF 2

**TITLE:** VISU-LOK® II, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE ALLOY STEEL 100° FLUSH TENSION HEAD, SELF-LOCKING FRACTIONAL DIAMETER

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**ECN DATE:** 11/15/14

**DRAWN DATE:** SHEET 1 OF 2
PROCUREMENT SPEC:

PROCUREMENT SPECIFICATION = PLT 5000, CLASS I, TYPE I
PART NUMBER ASSIGNMENT = PLT 5001
INSTALLATION AND REMOVAL = PLT 5002
SPECIAL LUBE AND FINISH = PLT 5003

MATERIAL:
NUT & SCREW: ALLOY STEEL, 4130 PER AMS-S-6758, 4140 PER AMS6349 OR 8740 PER AMS6322.
SLEEVE: CORROSION RESISTANT STEEL; 303 OR 304 PER AMS-QQ-S-763, AMS5639 OR AMS5641.
DRIVE NUT: MILD STEEL.
HEAT TREAT: NUT & SCREW: HEAT TREAT PER AMS2759 APPROXIMATELY 180,000 TO 200,000 PSI (1240 TO 1380 N/m²) TENSILE (HRC 39-43).
SLEEVE & DRIVE NUT: AS REQUIRED FOR PERFORMANCE.
FINISH: NUT & SCREW: CADMIUM PLATE PER AMS-QQ-P-416 TYPE II, CLASS 2. CADMIUM PLATE PER NAS672 IS PERMISSIBLE PROVIDED IT IS FOLLOWED BY A DICHROMATE POST TREATMENT PER AMS-QQ-P-416.
SLEEVE: PASSIVATED PER AMS2700 AND CADMIUM PLATED PER AMS-QQ-P-416 TYPE I, CLASS 3.
DRIVE NUT: CORROSION RESISTANT COATING. COLOR GOLD.
LUBRICANT: SOLID DRY FILM LUBE PER THE CHEMICAL REQUIREMENTS OF AS5272, OR EVERLUBE 812 PER MIL-PRF-81329, PARAFFIN WAX OR CETYL ALCOHOL PER AS87132 MAY BE APPLIED TO ANY OR ALL COMPONENTS AS REQUIRED FOR PERFORMANCE. (SEE PLT 5003 FOR SPECIAL LUBRICANTS AND FINISHES).

PART CODE & EXAMPLE:
PLT5115 - 08 - 08
GRIP LENGTHS IN 1/16THS
NOMINAL BODY DIAMETER AS TABULATED IN 1/32NDS
BASIC PART NUMBER, SELF-LOCKING FASTENER

GENERAL NOTES:

1. LOCKING FEATURE CONSISTS OF THREE (3) INDENTATIONS LOCATED 120° APART ON THE PERIPHERY OF THE NUT COMPONENT.
2. HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.
   EXAMPLE: PLT5115-06-4.5 HAS A NOMINAL GRIP LENGTH OF 4.5 SIXTEENTHS = 0.281" (7.14mm) AND A GRIP RANGE OF .250" THRU .312" (6.35mm THRU 7.92mm).
3. 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 MINIMUM RECOMMENDED HOLE SIZE. FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS (22.23 NEWTONS).
4. PLT5115-05-( ) IS EQUIVALENT TO PLT5110-05-( ); PLT5115-10-( ) IS EQUIVALENT TO PLT5110-10-( ); PLT5115-12-( ) IS EQUIVALENT TO PLT5110-12-( ).
5. HEAD MARKING DESPRESSED .010" (0,254mm MAX.), POSITION OPTIONAL.