



PART NUMBER	NOM DIA.		A THEO DIA.		A' DIA. MIN.		C MAX.		D DIA.		E DIA. MAX.		F FLATS		H REF.		J DIA. MAX.		K MAX.		R RAD.	
	INCH	mm	INCH	MM	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
PLT5115-05-(-)	.1635	4,153	.332 .325	8,43 8,25	.296	7,52	.268	6,81	.1645 .1625	4,178 4,128	.1620	4,12	.086 .081	2,18 2,06	.069	1,75	.244	6,20	.246	6,25	.030 .010	0,76 0,25
PLT5115-06-(-)	.1890	4,800	.385 .378	9,78 9,60	.342	8,69	.303	7,70	.1900 .1880	4,826 4,775	.1875	4,77	.104 .099	2,64 2,52	.081	2,06	.300	7,62	.281	7,14	.030 .015	0,76 0,38
PLT5115-08-(-)	.2480	6,300	.507 .499	12,88 12,67	.463	11,76	.354	8,99	.2490 .2470	6,325 6,274	.2465	6,27	.135 .130	3,43 3,30	.107	2,72	.384	9,75	.325	8,25	.030 .015	0,76 0,38
PLT5115-10-(-)	.3105	7,887	.635 .626	16,13 15,95	.577	14,66	.423	10,74	.3115 .3095	7,912 7,861	.3090	7,85	.152 .147	3,86 3,73	.134	3,40	.427	10,85	.390	9,91	.040 .020	1,02 0,51
PLT5115-12-(-)	.3735	9,487	.762 .752	19,35 19,10	.696	17,68	.510	12,95	.3745 .3725	9,512 9,462	.3720	9,45	.185 .180	4,70 4,57	.160	4,06	.516	13,11	.470	11,94	.040 .020	1,02 0,51

PART NUMBER	S MAX.		V GAGE DIA.		W GAGE DIA.		BREAK-OFF LIMITS		MINIMUM AVAILABLE GRIP LENGTH	HOLE SIZE		PREVAILING TORQUE MIN.		DOUBLE SHEAR STRENGTH MIN.		TENSILE STRENGTH MIN.	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm		INCH	mm	IN-LB	Nm	LBS.	N	LBS.	N
PLT5115-05-(-)	.012	0,30	.0276 .0238	0,701 0,604	.2671 .2667	6,784 6,774	+0,20 -0,068	+0,51 -1,73	-02	.168 .165	4,27 4,19	1.0	0,113	3355	14900	900	4000
PLT5115-06-(-)	.015	0,38	.0299 .0259	0,759 0,658	.3147 .3143	7,993 7,983	+0,15 -0,073	+0,38 -1,85	-02	.193 .190	4,90 4,82	1.5	0,170	4650	20600	1400	6230
PLT5115-08-(-)	.015	0,38	.0353 .0307	0,897 0,780	.4245 .4241	10,782 10,772	+0,10 -0,078	+0,25 -1,98	-03	.252 .249	6,40 6,32	2.5	0,282	7770	34500	2100	9340
PLT5115-10-(-)	.020	0,51	.0409 .0357	1,039 0,907	.5389 .5385	13,688 13,678	+0,10 -0,083	+0,25 -2,11	-03	.315 .312	8,00 7,92	3.5	0,400	12000	53400	3600	16010
PLT5115-12-(-)	.023	0,58	.0466 .0407	1,184 1,034	.6532 .6528	16,591 16,581	+0,10 -0,093	+0,25 -2,36	-04	.378 .375	9,60 9,52	4.0	0,452	19500	86700	5600	24910

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

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
DRAWN DATE: 08-14-13
APPROVED BY:
CHECKED DATE:

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Alcoa
CAGE CODE:
5M902

MONOGRAM
CAGE CODE:
98524

ECN NO:
14-0767
ECN DATE:
11/15/14

REV:
F
SHEET 1 OF 2



2ND DASH NO.	GRIP RANGE \triangle			
	GRIP MIN.		GRIP MAX.	
	INCH	mm	INCH	mm
-01	-	-	-	-
-02	.094	2,39	.156	3,96
-03	.157	3,99	.219	5,56
-04	.220	5,59	.281	7,14
-05	.282	7,16	.344	8,74
-06	.345	8,76	.406	10,31
-07	.407	10,34	.469	11,91
-08	.470	11,94	.531	13,49
-09	.532	13,51	.594	15,09
-10	.595	15,11	.656	16,66
-11	.657	16,69	.719	18,26
-12	.720	18,29	.781	19,84
-13	.782	19,86	.844	21,44
-14	.845	21,46	.906	23,01
-15	.907	23,04	.969	24,61
-16	.970	24,64	1,031	26,19

2ND DASH NO.	GRIP RANGE \triangle			
	GRIP MIN.		GRIP MAX.	
	INCH	mm	INCH	mm
-17	1,032	26,21	1,094	27,79
-18	1,095	27,81	1,156	29,36
-19	1,157	29,39	1,219	30,97
-20	1,220	30,98	1,281	32,54
-21	1,282	32,55	1,344	34,14
-22	1,345	34,15	1,406	35,72
-23	1,407	35,73	1,469	37,32
-24	1,470	37,33	1,531	38,89
-25	1,532	38,90	1,594	40,49
-26	1,595	40,50	1,656	42,07
-27	1,657	42,08	1,719	43,67
-28	1,720	43,68	1,781	45,24
-29	1,782	45,25	1,844	46,84
-30	1,845	46,85	1,906	48,42
-31	1,907	48,43	1,969	50,02
-32	1,970	50,03	2,031	51,59



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 AMS6382 OR 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.



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PLT5115-()-()

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

APPROVED BY: CHECKED DATE:

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SHEET 2 OF 2