### TABLE I

<table>
<thead>
<tr>
<th>PART NUMBER</th>
<th>NOM. DIA.</th>
<th>A DIA. THED.</th>
<th>A' DIA. MIN.</th>
<th>C MAX.</th>
<th>D DIA.</th>
<th>F FLATS</th>
<th>H REF.</th>
<th>J DIA. MAX.</th>
<th>K REF.</th>
<th>R RAD.</th>
</tr>
</thead>
<tbody>
<tr>
<td>PLS140-5(-)</td>
<td>0.1635</td>
<td>4.153</td>
<td>3.323</td>
<td>3.258</td>
<td>0.296</td>
<td>7.522</td>
<td>2.688</td>
<td>5.714</td>
<td>0.096</td>
<td>2.18</td>
</tr>
<tr>
<td>PLS140-6(-)</td>
<td>0.1900</td>
<td>5.029</td>
<td>3.959</td>
<td>3.787</td>
<td>0.342</td>
<td>8.697</td>
<td>3.903</td>
<td>7.670</td>
<td>0.097</td>
<td>2.64</td>
</tr>
<tr>
<td>PLS140-8(-)</td>
<td>0.2590</td>
<td>6.579</td>
<td>3.507</td>
<td>3.499</td>
<td>0.463</td>
<td>11.76</td>
<td>3.545</td>
<td>8.992</td>
<td>0.077</td>
<td>1.96</td>
</tr>
<tr>
<td>PLS140-10(-)</td>
<td>0.3105</td>
<td>7.867</td>
<td>3.635</td>
<td>3.626</td>
<td>0.577</td>
<td>13.40</td>
<td>3.646</td>
<td>10.12</td>
<td>0.102</td>
<td>2.59</td>
</tr>
<tr>
<td>PLS140-12(-)</td>
<td>0.3735</td>
<td>9.467</td>
<td>3.752</td>
<td>3.752</td>
<td>0.699</td>
<td>17.66</td>
<td>3.510</td>
<td>12.95</td>
<td>0.160</td>
<td>4.06</td>
</tr>
</tbody>
</table>

### TABLE I (CONT.)

<table>
<thead>
<tr>
<th>PART NUMBER</th>
<th>S MAX.</th>
<th>V GAGE PROT.</th>
<th>W GAGE DIA.</th>
<th>BREAK-OFF LIMITS</th>
<th>MINIMUM AVAILABLE GRIP LENGTH (TABLE II)</th>
<th>HOLE SIZE</th>
<th>IN-LB</th>
<th>NM</th>
<th>LBS.</th>
<th>N</th>
<th>LBS.</th>
<th>N</th>
<th>LBS.</th>
<th>N</th>
</tr>
</thead>
<tbody>
<tr>
<td>PLS140-5(-)</td>
<td>0.012</td>
<td>0.0276</td>
<td>0.070</td>
<td>0.067</td>
<td>6.774</td>
<td>0.082</td>
<td>2.09</td>
<td>-2</td>
<td>1.68</td>
<td>0.004</td>
<td>1.0</td>
<td>0.113</td>
<td>35900</td>
<td>17610</td>
</tr>
<tr>
<td>PLS140-6(-)</td>
<td>0.015</td>
<td>0.0299</td>
<td>0.075</td>
<td>0.068</td>
<td>7.635</td>
<td>0.072</td>
<td>1.63</td>
<td>-2</td>
<td>2.02</td>
<td>0.019</td>
<td>1.5</td>
<td>0.170</td>
<td>56950</td>
<td>26200</td>
</tr>
<tr>
<td>PLS140-8(-)</td>
<td>0.015</td>
<td>0.0329</td>
<td>0.079</td>
<td>0.071</td>
<td>10.772</td>
<td>0.072</td>
<td>1.63</td>
<td>-3</td>
<td>2.63</td>
<td>0.020</td>
<td>2.5</td>
<td>0.282</td>
<td>100000</td>
<td>44480</td>
</tr>
<tr>
<td>PLS140-10(-)</td>
<td>0.020</td>
<td>0.0409</td>
<td>0.093</td>
<td>0.083</td>
<td>13.668</td>
<td>0.072</td>
<td>1.63</td>
<td>-4</td>
<td>3.15</td>
<td>0.012</td>
<td>3.5</td>
<td>0.400</td>
<td>144000</td>
<td>64050</td>
</tr>
<tr>
<td>PLS140-12(-)</td>
<td>0.023</td>
<td>0.0466</td>
<td>0.104</td>
<td>0.085</td>
<td>16.591</td>
<td>0.072</td>
<td>1.63</td>
<td>-4</td>
<td>3.78</td>
<td>0.053</td>
<td>4.0</td>
<td>0.452</td>
<td>207600</td>
<td>92340</td>
</tr>
</tbody>
</table>

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**VOI-SHAN**
**CODE IDENT. NO.**
92215
**APPROVED DATE**
3-27-97 EDT 4078
**REV. LETTER AND DATE**
*B* 12-05-91

**U.S. PATENT NO. 3643544 AND 4747202**
**EUROPEAN PATENT NO. 021690**
**TITLE**
VISU-LOK® II FASTENER, BLIND
100° FLUSH TENSION HEAD NOMINAL DIAMETER
95 KSI Faus CRES

**MONOGRAM**
**CODE IDENT. NO.**
98524
**STANDARD**
PLT 5140
**SHEET** 1 OF 2

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**FASTENER IDENTIFICATION: "5140"**
**HEAD MARKINGS DEPRESSED .010 INCH (0.254 mm) MAX. (POSITION OPTIONAL)**
*DRIVE-NUT NOT SHOWN FOR CLARITY OF HEAD MARKINGS.*

**TYPICAL INSTALLATION**
APPLICABLE SPECIFICATIONS:

PROCUREMENT SPECIFICATION = PLT 5000, CLASS 6, TYPE I
PART NUMBER ASSIGNMENT = PLT 5001
INSTALLATION AND REMOVAL = PLT 5002
SPECIAL LUBE AND FINISH = PLT 5003

MATERIAL: NUT & SLEEVE: CORROSION AND HEAT RESISTANT STEEL, A-296
PER AMS 5731, AMS 5732 OR AMS 5737
SCREW: INCONEL 718 PER AMS 5662
DRIVE NUT: MILD STEEL

HEAT TREAT: NUT: HEAT TREAT TO A CORE HARDNESS OF RC 30-45
SLEEVE: AS REQUIRED FOR PERFORMANCE
SCREW: HEAT TREATED TO 125 KSI Fsu
DRIVE NUT: AS REQUIRED FOR PERFORMANCE

FINISH: NUT, SCREW & SLEEVE: PASSIVATE PER QQ-P-35
DRIVE NUT: CORROSION RESISTANT COATING, COLOR BLACK

LUBRICATION: SOLID DRY FILM LUBRICANT PER THE CHEMICAL REQUIREMENTS OF
MIL-L-46010 TYPE I OR EVERLUBE B12 PER MIL-L-81329, PARAFFIN
WAX OR Cetyl ALCOHOL PER MIL-L-81712 MAY BE APPLIED TO ANY
OR ALL COMPONENTS AS REQUIRED FOR PERFORMANCE,
(SEE PLT 5003 FOR SPECIAL LUBRICANTS AND FINISHES)

PART CODE & EXAMPLE: PLT 5140 -6-6

- GRIP LENGTH IN 1/16THS (SEE TABLE II)
- NOMINAL BODY DIAMETER IN 1/32NDs (SEE TABLE I)
- DASH (-) INDICATES STANDARD LUBRICATION AND FINISH
  (SEE PLT 5003)
- BASIC PART NUMBER, SELF LOCKING BLIND BOLT
  (SEE PLT 5001)

GENERAL NOTES:

CAUTION: LOCATING FEATURE CONSISTS OF THREE (3) INDENTATIONS LOCATED 120° APART ON THE PERIPHERY OF THE NUT COMPONENT

CAUTION: HALF GRIP SIZES MAY BE ORDERED BY ADDING .5 TO THE GRIP DASH NUMBER
EXAMPLE: PLT 5140-6-4.5 HAS A NOMINAL GRIP LENGTH OF 4-1/2 16THS (.251" = 7.44mm) AND A GRIP RANGE OF .250" THRU .312".
(6.35mm THRU 7.92mm)

CAUTION: DISTORTION OF "D" DIAMETER SHALL NOT PREVENT INSERTION OF THE FASTENER INTO A RING GAUGE OF LENGTH EQUA TO ONE DIAMETER AND DIAMETER EQUAL TO MINIMUM RECOMMENDED HOLE SIZE. FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS (22.23 NEWTONS)

CAUTION: SECOND DASH NUMBER (GRIP RANGE) -17 THROUGH -32 NOT AVAILABLE IN -.5 DIAMETER