

HEAD MARKINGS DEPRESSED .010 INCH (0,254 mm) MAX. (POSITION OPTIONAL)
* DRIVE-NUT NOT SHOWN FOR CLARITY OF HEAD MARKINGS.

TABLE I

PART NUMBER	NOM. DIA.		A DIA. THEO.		A' DIA. MIN.		C MAX.		D DIA.		F FLATS		H REF.		J DIA. MAX.		K REF.		R RAD.	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
PLT5140-5-()	.1635	4,153	.332 .325	8,43 8,25	.296	7,52	.268	6,81	.1645 .1625	4,178 4,128	.086 .081	2,18 2,06	.069	1,75	.244	6,20	.246	6,25	.030 .010	0,76 0,25
PLT5140-6-()	.1980	5,029	.385 .378	9,78 9,60	.342	8,69	.303	7,70	.1990 .1970	5,055 5,004	.104 .099	2,64 2,51	.077	1,96	.300	7,62	.281	7,14	.030 .015	0,76 0,38
PLT5140-8-()	.2590	6,579	.507 .499	12,88 12,67	.463	11,76	.354	8,99	.2600 .2580	6,604 6,553	.135 .130	3,43 3,30	.102	2,59	.384	9,75	.325	8,25	.030 .015	0,76 0,38
PLT5140-10-()	.3105	7,887	.635 .626	16,13 15,90	.577	14,66	.423	10,74	.3115 .3095	7,912 7,861	.152 .147	3,86 3,73	.134	3,40	.427	10,85	.390	9,91	.040 .020	1,02 0,51
PLT5140-12-()	.3735	9,487	.762 .752	19,35 19,10	.696	17,68	.510	12,95	.3745 .3725	9,512 9,462	.185 .180	4,70 4,57	.160	4,06	.516	13,11	.470	11,94	.040 .020	1,02 0,51

TABLE I (CONT.)

PART NUMBER	S MAX.		V GAGE PROT.		W GAGE DIA.		BREAK-OFF LIMITS		MINIMUM AVAILABLE GRIP LENGTH (TABLE II)	HOLE SIZE		PREVAILING TORQUE MIN.		DOUBLE SHEAR STRENGTH MIN.		TENSILE STRENGTH MIN.		TENSILE PRELOAD MIN.	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm		INCH	mm	IN-LB	Nm	LBS.	N	LBS.	N	LBS.	N
PLT5140-5-()	.012	0,30	.0276 .0238	0,701 0,604	.2671 .2667	6,784 6,774	+.082 -.006	+2,09 -0,16	-2	.168 .165	4,27 4,19	1.0	0,113	3960	17610	1150	5115	230	1020
PLT5140-6-()	.015	0,38	.0299 .0259	0,759 0,658	.3147 .3143	7,993 7,983	+.072 -.016	+1,83 -0,41	-2	.202 .199	5,13 5,05	1.5	0,170	5850	26020	1690	7520	338	1500
PLT5140-8-()	.015	0,38	.0353 .0307	0,897 0,780	.4245 .4241	10,782 10,772	+.072 -.026	+1,83 -0,66	-3	.263 .260	6,68 6,60	2.5	0,282	10000	44480	2900	12900	580	2580
PLT5140-10-()	.020	0,51	.0409 .0357	1,039 0,907	.5389 .5385	13,688 13,678	+.072 -.031	+1,83 -0,79	-4	.315 .312	8,00 7,92	3.5	0,400	14400	64050	4170	18550	834	3710
PLT5140-12-()	.023	0,58	.0466 .0407	1,184 1,034	.6532 .6528	16,591 16,581	+.072 -.031	+1,83 -0,79	-4	.378 .375	9,60 9,52	4.0	0,452	20760	92340	5970	26550	1194	5310

VOI-SHAN
CODE IDENT. NO.
92215

APPROVED DATE
3-27-87 ECN 4878

REV. LETTER AND DATE
"B" 12-05-91

U.S. PATENT NO. 3643544 AND 4747202
EUROPEAN PATENT NO. 0216980

MONOGRAM
CODE IDENT. NO.
98524

STANDARD

PLT 5140

SHEET 1 OF 2

TITLE
VISU-LOK® II FASTENER, BLIND
100° FLUSH TENSION HEAD NOMINAL DIAMETER
95 KSI Fsu CRES

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

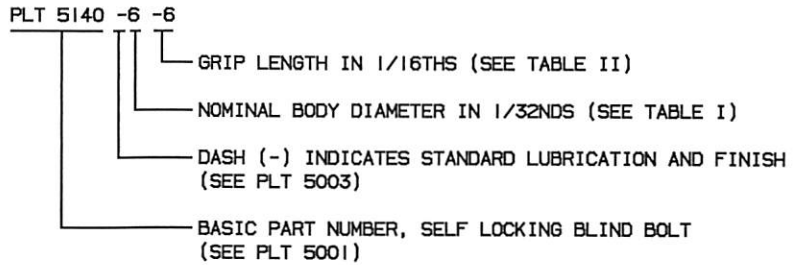
MATERIAL: NUT & SLEEVE: CORROSION AND HEAT RESISTANT STEEL, A-286
PER AMS 5731, AMS 5732 OR AMS 5737
SCREW: INCONEL 718 PER AMS 5662
DRIVE NUT: MILD STEEL

HEAT TREAT: NUT: HEAT TREAT TO A CORE HARDNESS OF RC 30-45
SLEEVE: AS REQUIRED FOR PERFORMANCE
SCREW: HEAT TREATED TO 125 KSI F_{su}
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 812 PER MIL-L-81329, PARAFFIN
WAX OR CETYL ALCOHOL PER MIL-L-87132 MAY BE APPLIED TO ANY
OR ALL COMPONENTS AS REQUIRED FOR PERFORMANCE,
(SEE PLT 5003 FOR SPECIAL LUBRICANTS AND FINISHES)

PART CODE
& EXAMPLE:



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 NUMBER
EXAMPLE: PLT 5140-6-4.5 HAS A NOMINAL GRIP LENGTH OF 4-1/2 16THS (.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 SECOND DASH NUMBER (GRIP RANGE) -17 THROUGH -32 NOT AVAILABLE IN -5 DIAMETER

TABLE II

2ND DASH NO. ④	GRIP RANGE ②			
	MIN. GRIP		MAX. GRIP	
	INCH	mm	INCH	mm
-2	.094	2,39	.156	3,96
-3	.157	3,99	.219	5,56
-4	.220	5,59	.281	7,14
-5	.282	7,16	.344	8,74
-6	.345	8,76	.406	10,31
-7	.407	10,34	.469	11,91
-8	.470	11,94	.531	13,49
-9	.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
-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	30,96
-20	1.220	30,99	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

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SHEET 2 OF 2

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