

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
PLT5144-5-()	.1640	4,168	.332 .325	8,43 8,25	.296	7,52	.268	6,81	.1645 .1635	4,178 4,153	.066 .061	2,18 2,06	.069	1,75	.244	6,20	.246	6,25	.030 .010	0,76 0,25
PLT5144-6-()	.2021	5,133	.385 .378	9,78 9,60	.342	8,69	.303	7,70	.2026 .2016	5,146 5,121	.104 .099	2,64 2,51	.077	1,96	.300	7,62	.281	7,14	.030 .015	0,76 0,38
PLT5144-8-()	.2645	6,718	.507 .499	12,88 12,67	.463	11,76	.354	8,99	.2651 .2641	6,733 6,708	.135 .130	3,43 3,30	.102	2,59	.384	9,75	.325	8,25	.030 .015	0,76 0,38
PLT5144-10-()	.3115	7,912	.635 .626	16,13 15,90	.577	14,66	.423	10,74	.3120 .3110	7,925 7,899	.152 .147	3,86 3,73	.134	3,40	.427	10,85	.390	9,91	.040 .020	1,02 0,51
PLT5144-12-()	.3740	9,500	.762 .752	19,35 19,10	.696	17,68	.510	12,95	.3745 .3735	9,512 9,487	.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 Δ		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
PLT5144-5-()	.012	0,30	.0276 .0238	0,704 0,601	.2671 .2669	6,784 6,779	+.082 -.006	+2,09 -0,16	-2	.1680 .1650	4,27 4,19	1.0	0,113	3960	17610	1150	5115	230	1020
PLT5144-6-()	.015	0,38	.0250 .0190	0,635 0,483	.3272 .3270	8,311 8,306	+.072 -.016	+1,83 -0,41	-2	.2060 .2030	5,23 5,16	1.5	0,170	5850	26020	1690	7520	338	1500
PLT5144-8-()	.015	0,38	.0327 .0263	0,831 0,668	.4320 .4318	10,973 10,968	+.072 -.026	+1,83 -0,66	-3	.2685 .2655	6,82 6,74	2.5	0,282	10000	44480	2900	12900	580	2580
PLT5144-10-()	.020	0,51	.0390 .0320	0,991 0,813	.5451 .5449	13,846 13,840	+.072 -.031	+1,83 -0,79	-4	.3150 .3120	8,00 7,92	3.5	0,400	14400	64050	4170	18550	834	3710
PLT5144-12-()	.023	0,58	.0452 .0378	1,148 0,960	.6682 .6680	16,718 16,713	+.072 -.031	+1,83 -0,79	-4	.3780 .3750	9,60 9,52	4.0	0,452	20760	92340	5970	26550	1194	5310

VOI-SHAN
CODE IDENT. NO.
92215

APPROVED DATE
6-08-97 ECN 4684

REV. LETTER AND DATE
"A" 9-9-91 ECN 6888

U.S. PATENT NO. 3643544, 4747202 & 4967463
EUROPEAN PATENT NO. 0152531 & 0216980

MONOGRAM
CODE IDENT. NO.
98524

STANDARD

PLT 5144

SHEET 1 OF 2



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

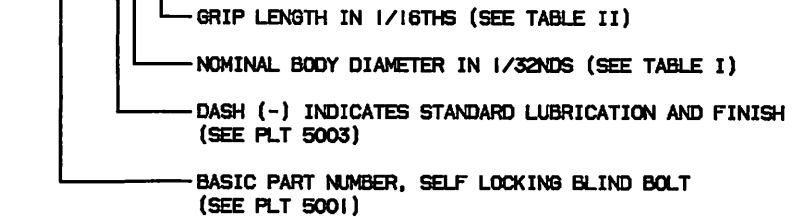
HEAT TREAT: NUT: HEAT TREAT TO A CORE HARDNESS OF RC 30-45
SLEEVE: AS REQUIRED FOR PERFORMANCE
SCREW: HEAT TREATED TO 125 KSI F_{su}
DRIVE NUT: AS REQUIRED FOR PERFORMANCE

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:

PLT 5144 -6 -6



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 5144-6-4.5 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 GROUND SHANK VISU-LOK II BLIND FASTENERS SHOULD NOT BE USED EXCEPT WITH CONSIDERABLE CAUTION IN APPLICATIONS WHICH EXCEED APPROXIMATELY .005 INTERFERENCE FIT. GROUND SHANK VISU-LOK II BLIND FASTENERS WILL PERFORM SATISFACTORILY WHEN INSTALLED IN THE TABULATED HOLE SIZES
- ⑤ SECOND DASH NUMBER (GRIP RANGE) -17 THROUGH -32 NOT AVAILABLE IN -5 DIAMETER

TABLE II

2ND DASH NO. ⑤	GRIP RANGE ②			
	MIN. GRIP		MAX. GRIP	
	INCH	mm	INCH	mm
-2	.094	2,39	.156	3,98
-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	16,68
-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	29,38
-19	1.157	29,38	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

VOI-SHAN
CODE IDENT. NO.
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U.S. PATENT NO. 3643544, 4747202 & 4967463
EUROPEAN PATENT NO. 0152531 & 0216980

MONOGRAM
CODE IDENT. NO.
98524

TITLE
VISU-LOK® II FASTENER, BLIND
100° FLUSH TENSION HEAD NOMINAL DIAMETER
GROUND SHANK
95 KSI F_{su} CRES

STANDARD
PLT 5144
SHEET 2 OF 2