



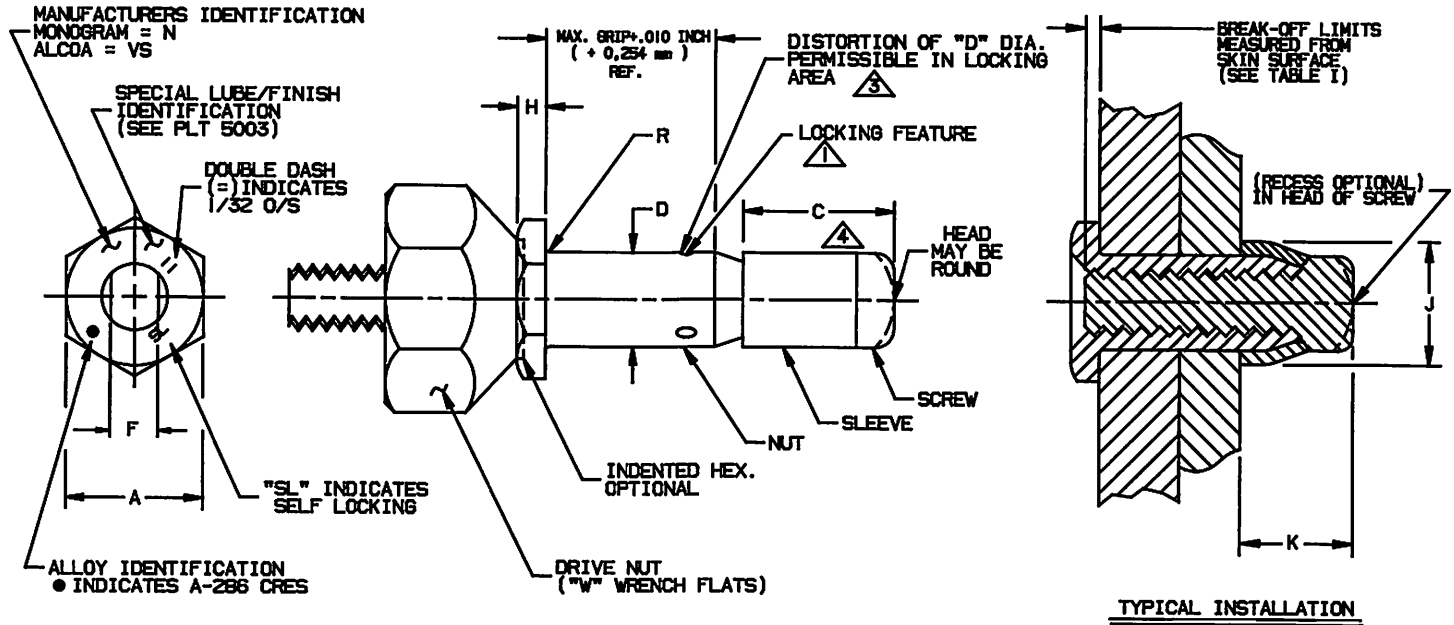
ALCOA

Alcoa Fastening Systems

CUSTODIAN: ENGINEERING STANDARD COMMITTEE FOR BLIND BOLTS
3423 SOUTH GARFIELD AVENUE
LOS ANGELES, CALIFORNIA 90040



MONOGRAM
AEROSPACE
FASTENERS



HEAD MARKING DEPRESSED .010 INCH (0.254 mm MAX.) (POSITION OPTIONAL)
DRIVE-NUT NOT SHOWN FOR CLARITY OF HEAD MARKINGS.

TABLE I

Table with 11 columns: PART NUMBER, NOM. DIA., A HEX., C MAX., D DIA., F FLATS, H HEAD HEIGHT, J DIA. MAX., K MAX., R RAD., W REF. (DRIVE NUT). Rows include part numbers PLT 5222-6-(), PLT 5222-8-(), PLT 5222-10-(), and PLT 5222-12-() with their respective dimensions in inches and mm.

TABLE I (CONT.)

Table with 7 columns: PART NUMBER, BREAK-OFF LIMITS, MINIMUM AVAILABLE GRIP LENGTH (TABLE II), HOLE SIZE, PREVAILING TORQUE MIN., DOUBLE SHEAR STRENGTH MIN., TENSILE STRENGTH MIN. Rows include part numbers PLT 5222-6-(), PLT 5222-8-(), PLT 5222-10-(), and PLT 5222-12-() with their respective mechanical properties.

ALCOA

CODE IDENT. NO.
5M902

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

MONOGRAM

CODE IDENT. NO.
98524

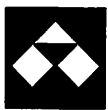
APPROVED DATE
4-30-85 EDN 4107

TITLE
VISU-LOK® II FASTENER, BLIND
INTERNALLY THREADED, EXTERNAL SLEEVE
A-286 CRES, -1200°F
PROTRUDING HEX HEAD, SELF LOCKING

STANDARD

1/32" O/S to PLT5220, 1/64" O/S to PLT5221

PLT 5222
(EQUIV. PLT1055)
SHEET 1 OF 2



ALCOA

Alcoa Fastening Systems

CUSTODIAN: ENGINEERING STANDARD COMMITTEE FOR BLIND BOLTS
3423 SOUTH GARFIELD AVENUE
LOS ANGELES, CALIFORNIA 90040



MONOGRAM
AEROSPACE
FASTENERS

APPLICABLE SPECIFICATIONS:

PROCUREMENT SPECIFICATION = PLT 5000, CLASS 2, TYPE V
PART NUMBER ASSIGNMENT = PLT 5001
INSTALLATION AND REMOVAL = PLT 5002
SPECIAL LUBE AND FINISH = PLT 5003

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

DRIVE NUT: MILD STEEL

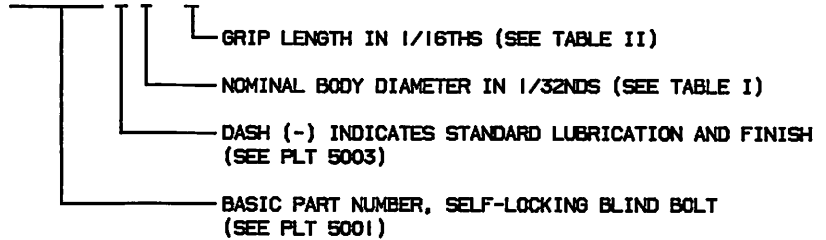
HEAT TREAT: NUT & SCREW: HEAT TREAT TO A CORE HARDNESS OF RC 30-45
SLEEVE: AS REQUIRED FOR PERFORMANCE
DRIVE NUT: AS REQUIRED FOR PERFORMANCE

FINISH: NUT, SCREW & SLEEVE: PASSIVATE PER MIL-S-5002
DRIVE NUT: CORROSION RESISTANT COATING. COLOR BLACK

LUBRICATION: SOLID DRY FILM LUBRICANT PER THE CHEMICAL REQUIREMENTS OF
ASS272 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 5222 - 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 5222-6-4.5 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. OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT BE GREATER THAN MAXIMUM "D" DIAMETER.
5. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.

TABLE II

Table with columns: 2ND DASH NO., GRIP RANGE (MIN. GRIP, MAX. GRIP) in INCH and mm. Rows range from -1 to -32.

ALCOA
CODE IDENT. NO.
5M902

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

MONOGRAM
CODE IDENT. NO.
98524

APPROVED DATE
4-30-85 ECN 4107

REV. LETTER AND DATE
ECN #4928
01-12-09

TITLE
VISU-LOK® II FASTENER, BLIND
INTERNALLY THREADED, EXTERNAL SLEEVE
A-286 CRES, -1200°F
PROTRUDING HEX HEAD, SELF LOCKING
1/32" O/S to PLT5220, 1/64" O/S to PLT5221

STANDARD
PLT 5222
(EQUIV. PLT1055)
SHEET 2 OF 2