

PART NUMBER	NOM DIA.		A HEX.		C MAX.		D DIA.		E DIA. MAX		F FLATS		H HEAD HEIGHT		J DIA. MAX.		K MAX.		N MIN.	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
PLT5225-05-(-)	.1635	4,153	.250 .244	6,35 6,20	.268	6,81	.1645 .1625	4,178 4,128	.1620	4,12	.086 .081	2,18 2,06	.096	2,44	.244	6,20	.246	6,25	.272	6,90
PLT5225-06-(-)	.1890	4,800	.312 .305	7,92 7,75	.303	7,70	.1900 .1880	4,826 4,775	.1875	4,77	.104 .099	2,64 2,52	.113	2,88	.300	7,62	.281	7,14	.340	8,63
PLT5225-08-(-)	.2480	6,299	.375 .367	9,52 9,32	.354	9,00	.2490 .2470	6,325 6,274	.2465	6,27	.135 .130	3,43 3,30	.135	3,43	.384	9,75	.325	8,26	.409	10,38
PLT5225-10-(-)	.3105	7,887	.437 .429	11,10 10,90	.423	10,75	.3115 .3095	7,912 7,861	.3090	7,85	.152 .147	3,86 3,73	.160	4,07	.427	10,85	.390	9,91	.479	12,16
PLT5225-12-(-)	.3735	9,487	.500 .491	12,70 12,47	.510	12,96	.3745 .3725	9,512 9,462	.3720	9,45	.185 .180	4,70 4,57	.190	4,83	.516	13,11	.470	11,94	.548	13,91

PART NUMBER	R RAD.		W REF. DRIVE NUT		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	IN-LB	Nm	LBS.	N	LBS.	N
PLT5225-05-(-)	.020 .010	0,51 0,25	.375	9,52	+0,88 +0,00	+2,24 +0,00	-01	.168 .165	4,27 4,19	1.0	0,113	3150	14010	900	4000
PLT5225-06-(-)	.025 .015	0,63 0,38	.375	9,52	+1,03 +0,15	+2,62 +0,38	-01	.193 .190	4,90 4,82	1.5	0,170	4200	18680	1400	6200
PLT5225-08-(-)	.025 .015	0,63 0,38	.375	9,52	+1,30 +0,32	+3,31 +0,81	-02	.252 .249	6,40 6,32	2.5	0,282	7200	32020	2100	9300
PLT5225-10-(-)	.030 .015	0,76 0,38	.500	12,70	+1,30 +0,27	+3,31 +0,68	-02	.315 .312	8,00 7,92	3.5	0,400	11350	50480	3600	16000
PLT5225-12-(-)	.030 .015	0,76 0,38	.500	12,70	+1,30 +0,27	+3,31 +0,68	-03	.378 .375	9,60 9,52	4.0	0,452	16450	73170	5600	24900



TITLE:
VISU-LOK® II, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE, FRACTIONAL DIAMETER PROTRUDING HEAD, SELF-LOCKING HIGH TEMPERATURE (A286 ALLOY)

DRAWING NO: PLT5225()-()-()	
DRAWN BY: G.MARTINEZ	DRAWN DATE: 08-17-13
APPROVED BY:	CHECKED DATE:
Alcoa CAGE CODE: 5M902	MONOGRAM CAGE CODE: 98524
ECN NO: 14-0790	REV: J
ECN DATE: 11/17/14	SHEET 1 OF 2

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2ND DASH NO.	GRIP RANGE			
	GRIP MIN.		GRIP MAX.	
	INCH	mm	INCH	mm
-01	.032	0,81	.093	2,36
-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			
	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 = PLT5000, CLASS 2, TYPE V
 PART NUMBER ASSIGNMENT = PLT5001
 INSTALLATION AND REMOVAL = PLT5002
 SPECIAL LUBE AND FINISH = PLT5003

MATERIAL:

NUT, SCREW, & SLEEVE: CORROSION AND HEAT RESISTANT STEEL TYPE A286 PER AMS5731, AMS5732, OR AMS5737.
 DRIVE NUT: MILD STEEL.

HEAT TREAT:

NUT & SCREW: SOLUTION HEAT TREATED AND AGED TO A CORE HARDNESS OF HRC 30-45. ALL CORE HARDNESS READINGS ARE TAKEN ON MOUNTED SPECIMEN, USING A BRALE PENETRATOR AND 30 KG LOAD (ROCKWELL 30N).
 SLEEVE: SOLUTION TREATED.
 DRIVE NUT: AS REQUIRED FOR PERFORMANCE.

FINISH:

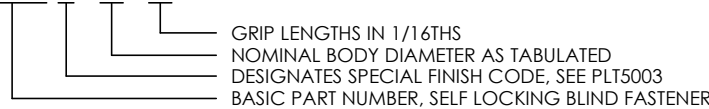
" - " NUT, SCREW, & SLEEVE: PASSIVATE PER AMS2700.
 DRIVE NUT: CORROSION RESISTANT COATING. COLOR BLACK.
 "A" NUT, SCREW, & SLEEVE: PASSIVATE PER AMS2700 AND CADMIUM PLATE PER AMS-QQ-P-416 TYPE II, CLASS 3.
 DRIVE NUT: CORROSION RESISTANT COATING. COLOR BLACK.

LUBRICANT:

SOLID DRY FILM LUBE PER THE CHEMICAL REQUIREMENTS OF AS5272 TYPE I, 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:

PLT5225 A - 08 - 08



GENERAL NOTES:

1. LOCKING FEATURE CONSISTS OF THREE (3) INDENTATIONS LOCATED 120° APART ON THE PERIPHERY OF THE NUT COMPONENT.
2. 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).
3. HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.
 EXAMPLE: PLT5225-06-4.5 INDICATES 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).
4. SECOND DASH NUMBER (GRIP RANGE) -17 THROUGH -32 NOT AVAILABLE IN -05 DIAMETER.
5. HEAD MARKINGS DEPRESSED .010" (0.254mm MAX.), POSITION OPTIONAL.

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

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