



TYPICAL INSTALLATION

PART NUMBER	Ø NOM		A HEX		C MAX		Ø D		F WRENCH FLATS		H MAX		Ø J MAX		(K)		R. R	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
PLT5230-05-()	.1635	4,153	.283 .277	7,12 7,04	.268	6,81	.1645 .1625	4,178 4,128	.086 .081	2,18 2,06	.096	2,44	.244	6,20	.246	6,25	.020 .010	0,51 0,25
PLT5230-06-()	.1980	5,029	.346 .332	8,79 8,43	.303	7,70	.1990 .1970	5,055 5,004	.104 .099	2,64 2,51	.113	2,87	.300	7,62	.281	7,14	.025 .015	0,63 0,38
PLT5230-08-()	.2590	6,579	.472 .458	12,00 11,63	.354	8,99	.2600 .2580	6,604 6,553	.135 .130	3,43 3,30	.135	3,43	.384	9,75	.325	8,25	.025 .015	0,63 0,38

PART NUMBER	BREAK-OFF LIMITS		MINIMUM AVAILABLE GRIP LENGTH (TABLE II)	HOLE SIZE		PREVAILING TORQUE MIN		DOUBLE SHEAR STRENGTH MIN		TENSILE STRENGTH MIN	
	INCH	mm		INCH	mm	IN-LBS	Nm	LBS	N	LBS	N
PLT5230-05-()	+0,088 +0,000	+2,23 +0,00	-01	.168 .165	4,27 4,19	0,75	0,085	1920	8540	750	3340
PLT5230-06-()	+0,103 +0,015	+2,62 +0,38	-01	.202 .199	5,13 5,05	1,00	0,113	3100	13790	950	4230
PLT5230-08-()	+0,135 +0,047	+3,43 +1,19	-02	.263 .260	6,68 6,60	1,50	0,170	5300	23570	1500	6670



APPLICABLE SPECIFICATIONS:
 PROCUREMENT SPECIFICATION: PLT5000, CLASS 3, TYPE V
 PART NUMBER ASSIGNMENT: PLT5001
 INSTALLATION AND REMOVAL: PLT5002
 SPECIAL LUBE AND FINISH: PLT5003



MATERIAL:
 NUT: ALUMINUM ALLOY 7075-T6 PER AMS-QQ-A-225/9.
 SCREW: ALLOY STEEL 4130 PER AMS-S-6758, ALLOY STEEL 4140 PER AMS6382 OR AMS6349 OR ALLOY STEEL 8740 PER AMS6322.
 SLEEVE: CRES 303 PER AMS5639 OR CRES 304 PER AMS5641.
 DRIVE NUT: MILD STEEL.

HEAT TREAT:
 NUT: NONE.
 SCREW: HEAT TREAT TO 39-43 HRC PER AMS2759.
 SLEEVE: AS REQUIRED FOR PERFORMANCE.
 DRIVE NUT: AS REQUIRED FOR PERFORMANCE.

FINISH:
 NUT: ANODIZE PER MIL-A-8625, TYPE II (CLEAR)
 SCREW: CADMIUM PLATED PER AMS-QQ-P-416 TYPE II, CLASS 2. CADMIUM PLATE PER NAS672 IS PERMISSIBLE PROVIDED IT IS FOLLOWED BY A DICHROMATE POST TREATMENT PER AMS-QQ-P-416.
 SLEEVE: PASSIVATE PER AMS2700. CADMIUM PLATED PER AMS-QQ-P-416, TYPE I, CLASS 3.
 DRIVE NUT: CORROSION RESISTANT COATING, COLOR BLUE.

LUBRICATION:
 NO CODE (): SOLID DRY FILM LUBRICANT PER THE CHEMICAL REQUIREMENTS OF AS5272 TYPE I OR EVERLUBE 812 PER MIL-PRF-81329, WWM CARBO-WAX, PARAFFIN WAX AND/OR CETYL ALCOHOL PER AS87132 MAY BE APPLIED TO ANY OR ALL COMPONENTS AS REQUIRED FOR PERFORMANCE. (SEE PLT5003 FOR SPECIAL LUBRICANTS AND FINISHES).

EXAMPLE PART NUMBER:
 PLT5230 () - 08 - 04
 GRIP LENGTHS IN 1/16THS (SEE TABLE II)
 NOMINAL BODY DIAMETER IN 1/32" (SEE TABLE I)
 DESIGNATES SPECIAL FINISH CODE (SEE PLT5003)
 BASIC PART NUMBER, SELF-LOCKING BLIND FASTENER (SEE PLT5001)

TABLE II

2ND DASH NO. △2	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
-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	32.56	1.344	34.14
-22	1.345	34.16	1.406	35.71
-23	1.407	35.74	1.469	37.31
-24	1.470	37.34	1.531	38.89
-25	1.532	38.91	1.594	40.49
-26	1.595	40.51	1.656	42.06
-27	1.657	42.09	1.719	43.66
-28	1.720	43.69	1.781	45.24
-29	1.782	45.26	1.844	46.84
-30	1.845	46.86	1.906	48.41
-31	1.907	48.44	1.969	50.01
-32	1.970	50.04	2.031	51.59

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: PLT5230-06-4.5 INDICATES A NOMINAL GRIP LENGTH OF 4.5 SIXTEENTHS = .281" [7,14 mm] AND A GRIP RANGE OF .250" [6,35 mm] THRU .312" [7,92 mm].
3. DISTORTION OF "ØD" PERMISSIBLE IN LOCKING AREA. DISTORTION OF "ØD" 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 N].
4. PLT5230-05-() GRIP LENGTH AVAILABILITY LIMITED TO -01 THRU -16.
5. HEAD MARKINGS ON NUT DEPRESSED .010 INCH [0,254 mm] MAXIMUM. POSITION OPTIONAL.
6. DRIVE NUT NOT SHOWN FOR CLARITY OF HEAD MARKINGS.
7. NOTCH ON HEX INDICATES VSI MFG (OPTIONAL).



TITLE:
 VISU-LOK® II, FASTENER, BLIND,
 HEXAGONAL PROTRUDING HEAD,
 NOMINAL DIAMETER,
 ALUMINUM NUT WITH ALLOY STEEL SCREW

DRAWING NO: PLT5230 ()-()-()	
DRAWN BY: A PEREZ	DRAWN DATE: 01/21/2014
APPROVED BY:	CHECKED DATE:
ECN NO: 14-0791	REV: F
ECN DATE: 11/17/14	SHEET 2 OF 2

PROPRIETARY AND CONFIDENTIAL:
 NOTICE: THIS DRAWING IS PART OF THE PROPRIETARY ARTICLE HEREIN DISCLOSED, OWNED BY MONOGRAM AEROSPACE FASTENERS. ANY PARTY BY ACCEPTING THIS DOCUMENT ASSUME CUSTODY THEREOF AND AGREES:
 A: THE INFORMATION SET FORTH HEREIN IS GIVEN IN CONFIDENCE AND THIS DOCUMENT WILL NOT BE COPIED OR REPRODUCED IN WHOLE OR IN PART, NOR ITS CONTENTS REVEALED IN ANY MANNER TO ANY PERSON EXCEPT TO MEET THE PURPOSE FOR WHICH IT WAS DELIVERED.
 B: WITHOUT THE WRITTEN CONSENT OF MONOGRAM AEROSPACE FASTENERS, THIS DOCUMENT AND THE INFORMATION CONTAINED HEREIN UNDER NO CIRCUMSTANCES WILL BE USED IN THE MANUFACTURE OR REPRODUCTION OF THE ARTICLE DISCLOSED, AND THE DELIVERY OF THIS DOCUMENT SHALL NOT CONSTITUTE ANY RIGHT OR LICENSE TO DO SO.

Alcoa
 CAGE CODE:
 5M902

MONOGRAM
 CAGE CODE:
 98524