

TABLE I

PART NUMBER	Ø NOM		A HEX		C MAX		Ø D		Ø E MAX		F WRENCH FLATS		H		Ø J MAX		(K)		R. R		(W) HEX	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
PLT5254-05-(-)	.1640	4,166	.250 .244	6,35 6,20	.285	7,24	.1645 .1635	4,178 4,153	.1615	4,11	.086 .081	2,18 2,06	.096 .070	2,44 1,78	.244	6,20	.257	6,53	.025 .020	0,63 0,51	.375	9,52
PLT5254-06-(-)	.2021	5,134	.312 .305	7,92 7,75	.320	8,13	.2026 .2016	5,146 5,121	.1995	5,07	.104 .099	2,64 2,51	.113 .074	2,87 1,88	.300	7,62	.288	7,32	.030 .025	0,76 0,63	.375	9,52
PLT5254-08-(-)	.2645	6,719	.375 .367	9,52 9,32	.355	9,02	.2651 .2641	6,733 6,708	.2621	6,66	.135 .130	3,43 3,30	.135 .084	3,43 2,13	.384	9,75	.320	8,13	.035 .030	0,89 0,76	.375	9,52
PLT5254-10-(-)	.3115	7,913	.437 .429	11,10 10,90	.440	11,18	.3120 .3110	7,925 7,899	.3090	7,85	.152 .147	3,86 3,73	.160 .106	4,06 2,69	.427	10,85	.396	10,06	.045 .035	1,14 0,89	.500	12,70
PLT5254-12-(-)	.3740	9,500	.500 .491	12,70 12,47	.525	13,34	.3745 .3735	9,512 9,487	.3715	9,44	.185 .180	4,70 4,57	.190 .127	4,83 3,22	.516	13,11	.473	12,01	.045 .035	1,14 0,89	.500	12,70

TABLE I (CONTINUED)

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
PLT5254-05-(-)	+0,088 -0,000	+2,24 +0,00	-01	.1680 .1650	4,267 4,191	1.0	0,113	4680	20820	1350	6000
PLT5254-06-(-)	+0,098 +0,10	+2,49 +0,25	-01	.2060 .2030	5,232 5,156	1.5	0,170	6900	30700	2100	9340
PLT5254-08-(-)	+0,135 +0,047	+3,43 +1,19	-02	.2685 .2655	6,820 6,734	2.5	0,282	11800	52500	3650	16240
PLT5254-10-(-)	+0,146 +0,043	+3,71 +1,09	-02	.3150 .3120	8,001 7,925	3.5	0,400	17000	75620	5200	23130
PLT5254-12-(-)	+0,152 +0,049	+3,86 +1,24	-03	.3780 .3750	9,601 9,525	4.0	0,452	24500	109000	7500	33360



APPLICABLE SPECIFICATIONS:
 PROCUREMENT SPECIFICATION: PLT5000, CLASS 4, TYPE V
 PART NUMBER ASSIGNMENT: PLT5001
 INSTALLATION AND REMOVAL: PLT5002
 SPECIAL LUBE AND FINISH: PLT5003

MATERIAL:
 NUT AND SCREW: 5% CHROME STEEL (H-11) PER AMS6487.
 SLEEVE: CRES A286 PER AMS5731, AMS5732 OR AMS5737 OR INCONEL X-750 PER AMS5667 OR AMS5582.
 DRIVE NUT: MILD STEEL.

HEAT TREAT:
 NUT AND SCREW: HEAT TREAT TO 48-53 HRC.
 SLEEVE: AS REQUIRED FOR PERFORMANCE.
 DRIVE NUT: AS REQUIRED FOR PERFORMANCE.

FINISH:
 NUT AND SCREW: CADMIUM PLATED PER NAS672, .0003" MINIMUM THICKNESS (EXCEPT THERMAL INDICATOR MAY BE OMITTED) FOLLOWED BY A DICHROMATE POST TREATMENT PER AMS-QQ-P-416, NUT COLOR RED.
 SLEEVE: PASSIVATE PER AMS2700. CADMIUM PLATED PER AMS-QQ-P-416, TYPE I CLASS 3 OR TYPE II CLASS 2.
 DRIVE NUT: CORROSION RESISTANT COATING, COLOR RED.

LUBRICATION:
 NO CODE () : SOLID DRY FILM LUBRICANT PER THE CHEMICAL REQUIREMENTS OF AS5272 TYPE I OR EVERLUBE 812 PER MIL-PRF-81329, 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:

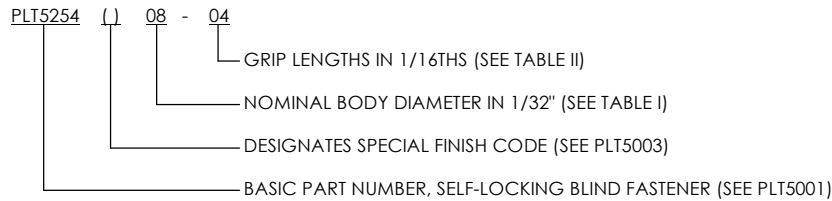


TABLE II

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
-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: PLT5254-06-4.5 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. ALTERNATE HEAD MARKING: "N" (OR "VS"), "254".
4. 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 MAXIMUM "ØD" + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS [22.23 N].
5. GROUND SHANK VISU-LOK II, BLIND FASTENERS SHOULD NOT BE USED EXCEPT WITH CONSIDERABLE CAUTION IN APPLICATIONS WHICH EXCEED APPROXIMATELY .0005" INTERFERENCE FIT. GROUND SHANK VISU-LOK II BLIND FASTENERS WILL PERFORM SATISFACTORILY WHEN INSTALLED IN THE TABULATED HOLE SIZES.
6. PLT5254-05-() GRIP LENGTH AVAILABILITY LIMITED TO -01 THRU -16.
7. HEAD MARKINGS ON NUT DEPRESSED .010 INCH [0.254 mm] MAXIMUM. POSITION OPTIONAL.
8. DRIVE NUT NOT SHOWN FOR CLARITY OF HEAD MARKINGS.
9. RECESS OR INDENTED HEX IN HEAD OF NUT OPTIONAL.



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

TITLE:

VISU-LOK® II, FASTENER, BLIND,
 HEXAGONAL PROTRUDING HEAD,
 NOMINAL DIAMETER, GROUND SHANK,
 5% CHROME STEEL ALLOY (H-11)

DRAWING NO:

PLT5254()-()-()

DRAWN BY:

A PEREZ

DRAWN DATE:

01/13/2014

APPROVED BY:

CHECKED DATE:

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

ECN NO: 14-0800
 ECN DATE: 11/18/14

REV: K
 SHEET 2 OF 2