



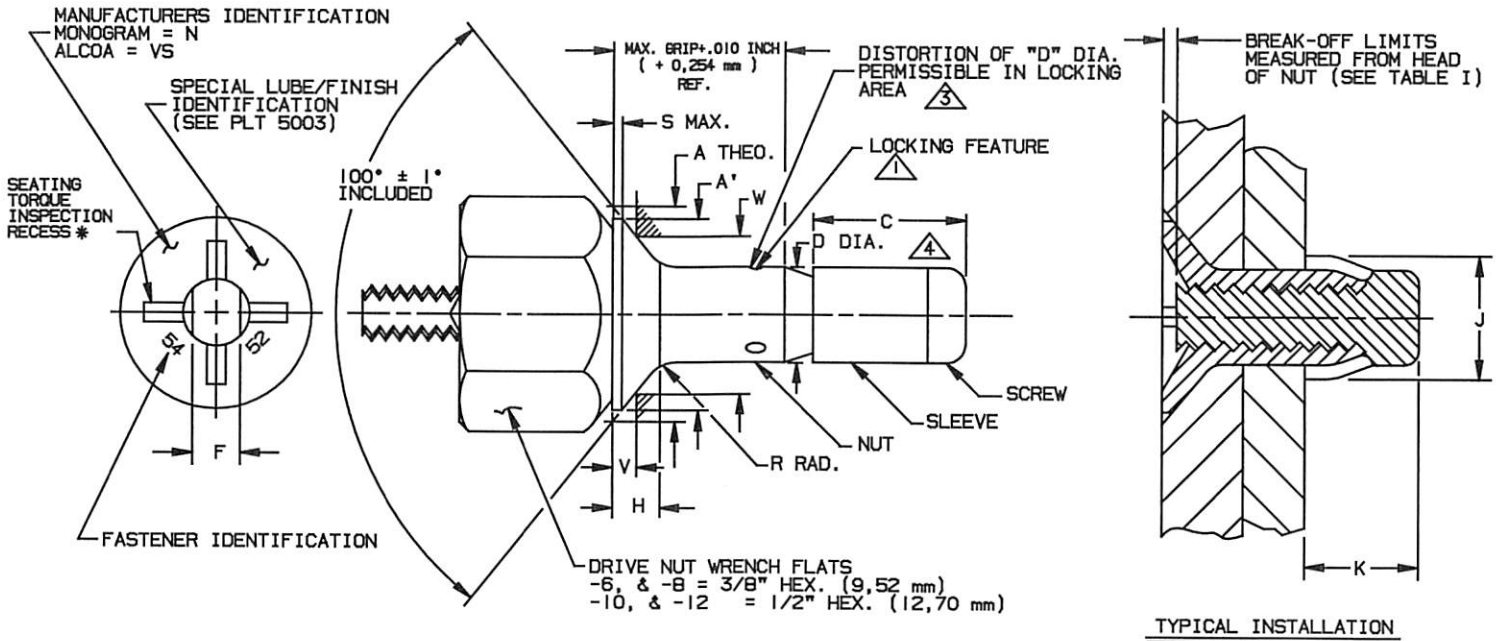
ALCOA

Alcoa Fastening Systems

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



MONOGRAM  
AEROSPACE  
FASTENERS



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 MAX.		R RAD.	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
PLT 5452-6-()	.2290	5,817	.343 .338	8,71 8,59	.311	7,90	.360	9,14	.2300 .2280	5,84 5,79	.104 .099	2,64 2,52	.047	1,19	.315	8,00	.333	8,46	.050 .045	1,27 1,14
PLT 5452-8-()	.2900	7,866	.437 .432	11,10 10,97	.405	10,29	.404	10,26	.2910 .2890	7,39 7,34	.135 .130	3,43 3,30	.061	1,55	.401	10,19	.366	9,30	.060 .055	1,52 1,40
PLT 5452-10-()	.3415	8,674	.505 .500	12,83 12,70	.473	12,01	.493	12,52	.3425 .3405	8,70 8,65	.152 .147	3,86 3,73	.068	1,73	.442	11,23	.447	11,35	.070 .060	1,78 1,52
PLT 5452-12-()	.4045	10,273	.592 .587	15,04 14,91	.560	14,22	.583	14,80	.4055 .4035	10,30 10,25	.185 .180	4,70 4,57	.078	1,98	.531	13,49	.527	13,39	.070 .060	1,78 1,52

TABLE I (CONT.)

PART NUMBER	S MAX.		V GAGE PROT.		W GAGE DIA.		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	INCH	mm	INCH	mm		INCH	mm	IN-LB	Nm	LBS.	kN	LBS.	kN
PLT 5452-6-()	.015	0,38	.0324 .0293	0,823 0,744	.2671 .2669	6,784 6,779	+.088 -.000	+2,24 -0,00	-2	.233 .231	5,92 5,86	1.5	0,170	9200	41.0	2100	9.3
PLT 5452-8-()	.015	0,38	.0273 .0244	0,693 0,620	.3731 .3729	9,477 9,472	+.098 -.000	+2,49 -0,00	-3	.294 .292	7,47 7,41	2.5	0,282	14800	65.7	3650	16.2
PLT 5452-10-()	.015	0,38	.0312 .0281	0,792 0,714	.4320 .4318	10,973 10,967	+.103 -.000	+2,62 -0,00	-3	.346 .343	8,79 8,71	3.5	0,400	20500	91.4	5200	23.1
PLT 5452-12-()	.015	0,38	.0456 .0420	1,158 1,067	.4854 .4852	12,329 12,324	+.103 -.000	+2,62 -0,00	-4	.409 .406	10,39 10,32	4.0	0,452	28700	127.7	7500	33.4

ALCOA

CODE IDENT. NO.  
5M902

MONOGRAM

CODE IDENT. NO.  
98524

APPROVED DATE  
5-28-85 ECN 4154

REV. LETTER AND DATE  
ECN #5848  
09-27-11

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TITLE  
VISU-LOK® II FASTENER, BLIND  
100° REDUCED FLUSH SHEAR HEAD,  
1/32" OVERSIZE DIAMETER  
5% CHROME STEEL ALLOY (H-11)

STANDARD

PLT 5452

SHEET 1 OF 2



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APPLICABLE SPECIFICATIONS:

PROCUREMENT SPECIFICATION = PLT 5000 CLASS 4, TYPE II
PART NUMBER ASSIGNMENT = PLT 5001
INSTALLATION AND REMOVAL = PLT 5002
SPECIAL LUBE AND FINISH = PLT 5003

MATERIAL: NUT & SCREW: 5% CHROME STEEL (H-11) PER AMS 6487
SLEEVE: A-286 PER AMS 5731, AMS 5732, AMS 5737, OR INCONEL X-750 PER AMS 5667 OR AMS 5582
DRIVE NUT: MILD STEEL

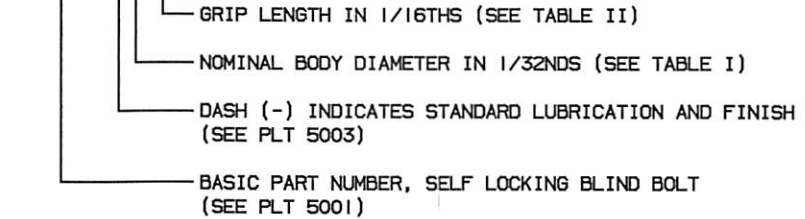
HEAT TREAT: NUT & SCREW: HEAT TREAT TO RC 48-53
SLEEVE: AS REQUIRED FOR PERFORMANCE
DRIVE NUT: AS REQUIRED FOR PERFORMANCE

FINISH: NUT & SCREW: CADMIUM PLATE PER NAS 672, .0003" MINIMUM THICKNESS (EXCEPT THERMAL INDICATOR MAY BE OMITTED) FOLLOWED BY A DICHROMATE POST TREATMENT PER QQ-P-416
SLEEVE: PASSIVATE PER AMS2700. CADMIUM PLATE PER QQ-P-416, TYPE I, CLASS 3
DRIVE NUT: CORROSION RESISTANT COATING. COLOR RED

LUBRICATION: SOLID DRY FILM LUBRICANT PER THE CHEMICAL REQUIREMENTS OF AS5272 TYPE I OR EVERLUBE 812 PER MIL-L-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:

PLT 5452 -8 -4



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 5452-6-4.5 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 2 columns: 2ND DASH NO. and GRIP RANGE (MIN. GRIP, MAX. GRIP) in INCH and mm. Rows range from -2 to -32.

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STANDARD
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SHEET 2 OF 2