

TABLE I

PART NUMBER	Ø NOM		A HEX		C MAX		ØD		ØE MAX		F WRENCH FLATS		H		ØJ MAX		K MAX		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
PLT6018-05-(-)	.1832	4,653	.250 .244	6,35 6,20	.315	8,00	.1835 .1830	4,661 4,648	.180	4,57	.086 .081	2,18 2,06	.096 .070	2,44 1,78	.244	6,20	.300	7,62	.020 .010	0,51 0,25	.375	9,52
PLT6018-06-(-)	.2182	5,542	.312 .305	7,92 7,75	.350	8,89	.2185 .2180	5,550 5,537	.215	5,46	.104 .099	2,64 2,51	.113 .074	2,87 1,88	.300	7,62	.333	8,46	.025 .015	0,63 0,38	.375	9,52
PLT6018-08-(-)	.2792	7,092	.375 .367	9,52 9,32	.385	9,78	.2795 .2790	7,099 7,087	.276	7,01	.135 .130	3,43 3,30	.135 .084	3,43 2,13	.384	9,75	.366	9,30	.025 .015	0,63 0,38	.375	9,52
PLT6018-10-(-)	.3302	8,387	.437 .429	11,10 10,90	.470	11,94	.3305 .3300	8,395 8,382	.327	8,31	.152 .147	3,86 3,73	.160 .106	4,06 2,69	.427	10,85	.447	11,35	.030 .015	0,76 0,38	.500	12,70
PLT6018-12-(-)	.3932	9,987	.500 .491	12,70 12,47	.555	14,10	.3935 .3930	9,995 9,982	.390	9,91	.185 .180	4,70 4,57	.190 .127	4,83 3,22	.516	13,11	.527	13,39	.030 .015	0,76 0,38	.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		N MIN		(L1)		L3 MAX	
	INCH	mm		INCH	mm	IN-LBS	Nm	LBS	N	LBS	N	INCH	mm	INCH	mm	INCH	mm
PLT6018-05-(-)	+0,088 +0,000	+2,24 +0,00	-01	.187 .184	4,75 4,67	1.0	0,113	3150	14010	900	4000	.272	6,91	.380	9,65	.880	22,35
PLT6018-06-(-)	+0,098 +0,010	+2,49 +0,25	-01	.222 .219	5,64 5,56	1.5	0,170	4600	20460	1400	6230	.340	8,64	.430	10,92	.931	23,65
PLT6018-08-(-)	+0,135 +0,047	+3,43 +1,19	-02	.283 .280	7,19 7,11	2.5	0,282	7900	35140	2100	9340	.409	10,39	.577	14,66	1,155	29,34
PLT6018-10-(-)	+0,146 +0,043	+3,71 +1,09	-02	.334 .331	8,48 8,41	3.5	0,400	11350	50480	3600	16010	.479	12,17	.605	15,37	1,407	35,74
PLT6018-12-(-)	+0,152 +0,049	+3,86 +1,24	-03	.397 .394	9,83 9,75	4.0	0,452	16450	73170	5600	24910	.548	13,92	.710	18,03	1,476	37,49

MONOGRAM AEROSPACE FASTENERS
a TriMas company
3423 SOUTH GARFIELD AVENUE
COMMERCE, CALIFORNIA 90040
(323) 722-4760 FAX (323) 727-1029

TITLE:
**VISU-LOK® II, FASTENER, BLIND,
HEXAGONAL PROTRUDING HEAD,
GROUND SHANK, TITANIUM ALLOY
1/64" OVERSIZE**

DRAWING NO:
PLT6018(-)(-)(-)

DRAWN BY: A PEREZ
APPROVED BY:

DRAWN DATE: 02/16/2014
CHECKED DATE:

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Alcoa CAGE CODE: 5M902
MONOGRAM CAGE CODE: 98524
ECN NO: 14-0826
ECN DATE: 11/23/14
REV: J
SHEET 1 OF 2



APPLICABLE SPECIFICATIONS:
 PROCUREMENT SPECIFICATION: PLT5000, CLASS 5, TYPE V
 PART NUMBER ASSIGNMENT: PLT5001
 INSTALLATION AND REMOVAL: PLT5002
 SPECIAL LUBE AND FINISH: PLT5003

MATERIAL:
 NUT AND SCREW: 6AL-4V TITANIUM ALLOY PER AMS4928 OR AMS4967.
 SLEEVE: CRES 304 OR CRES A286.
 DRIVE NUT: MILD STEEL.

HEAT TREAT:
 NUT AND SCREW: HEAT TREAT TO 95 KSI ULTIMATE SHEAR STRENGTH.
 SLEEVE: AS REQUIRED FOR PERFORMANCE.
 DRIVE NUT: AS REQUIRED FOR PERFORMANCE.

FINISH:
 NUT AND SCREW: NONE.
 SLEEVE: PASSIVATE PER AMS2700.
 DRIVE NUT: CORROSION RESISTANT COATING, COLOR GRAY.

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).
 CODE (AA): SAME AS NO CODE () EXCEPT: COMPLETE TOP SURFACE OF HEAD OF NUT SHALL BE POWDER BLASTED TO PRODUCE A SURFACE FINISH OF RA 50-80 MICRO-INCHES AFTER ALL MANUFACTURING OPERATIONS.

EXAMPLE PART NUMBER:

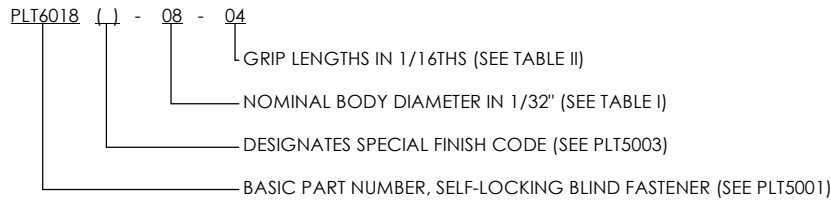


TABLE II

2ND DASH NO. △2	GRIP RANGE					
	GRIP MIN		GRIP MAX		G ₃	
	INCH	mm	INCH	mm	INCH	mm
-01	.032	0.81	.093	2.36	.093	2.36
-02	.094	2.39	.156	3.96	.156	3.96
-03	.157	3.99	.219	5.56	.219	5.56
-04	.220	5.59	.281	7.14	.281	7.14
-05	.282	7.16	.344	8.74	.344	8.74
-06	.345	8.76	.406	10.31	.406	10.31
-07	.407	10.34	.469	11.91	.469	11.91
-08	.470	11.94	.531	13.49	.531	13.49
-09	.532	13.51	.594	15.09	.595	15.11
-10	.595	15.11	.656	16.66	.656	16.66
-11	.657	16.69	.719	18.26	.719	18.26
-12	.720	18.29	.781	19.84	.781	19.84
-13	.782	19.86	.844	21.44	.844	21.44
-14	.845	21.46	.906	23.01	.906	23.01
-15	.907	23.04	.969	24.61	.969	24.61
-16	.970	24.64	1.031	26.19	1.031	26.19
-17	1.032	26.21	1.094	27.79	1.094	27.79
-18	1.095	27.81	1.156	29.36	1.156	29.36
-19	1.157	29.39	1.219	30.96	1.219	30.96
-20	1.220	30.99	1.281	32.54	1.281	32.54
-21	1.282	32.56	1.344	34.14	1.344	34.14
-22	1.345	34.16	1.406	35.71	1.406	35.71
-23	1.407	35.74	1.469	37.31	1.469	37.31
-24	1.470	37.34	1.531	38.89	1.531	38.89
-25	1.532	38.91	1.594	40.49	1.594	40.49
-26	1.595	40.51	1.656	42.06	1.656	42.06
-27	1.657	42.09	1.719	43.66	1.719	43.66
-28	1.720	43.69	1.781	45.24	1.781	45.24
-29	1.782	45.26	1.844	46.84	1.844	46.84
-30	1.845	46.86	1.906	48.41	1.906	48.41
-31	1.907	48.44	1.969	50.01	1.969	50.01
-32	1.970	50.04	2.031	51.59	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: PLT6018-06-4.5 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. "G" TOLERANCES: FOR -05 AND -06 SIZES; +.030/-010 [+0.762 mm/-0.254 mm]. FOR -08 AND -10 SIZES; +.040/-010 [+1.016 mm/-0.254 mm]. FOR -12 SIZE; +.050/-010 [+1.270 mm/-0.254 mm].
4. PLT6018-05- () GRIP LENGTH AVAILABILITY LIMITED TO -01 THRU -16.
5. 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].
6. DIMENSIONS "Ø J" AND "K" ARE FOR DESIGN PURPOSES ONLY AND ARE NOT FOR INSPECTION IN ACTUAL APPLICATION
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.



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