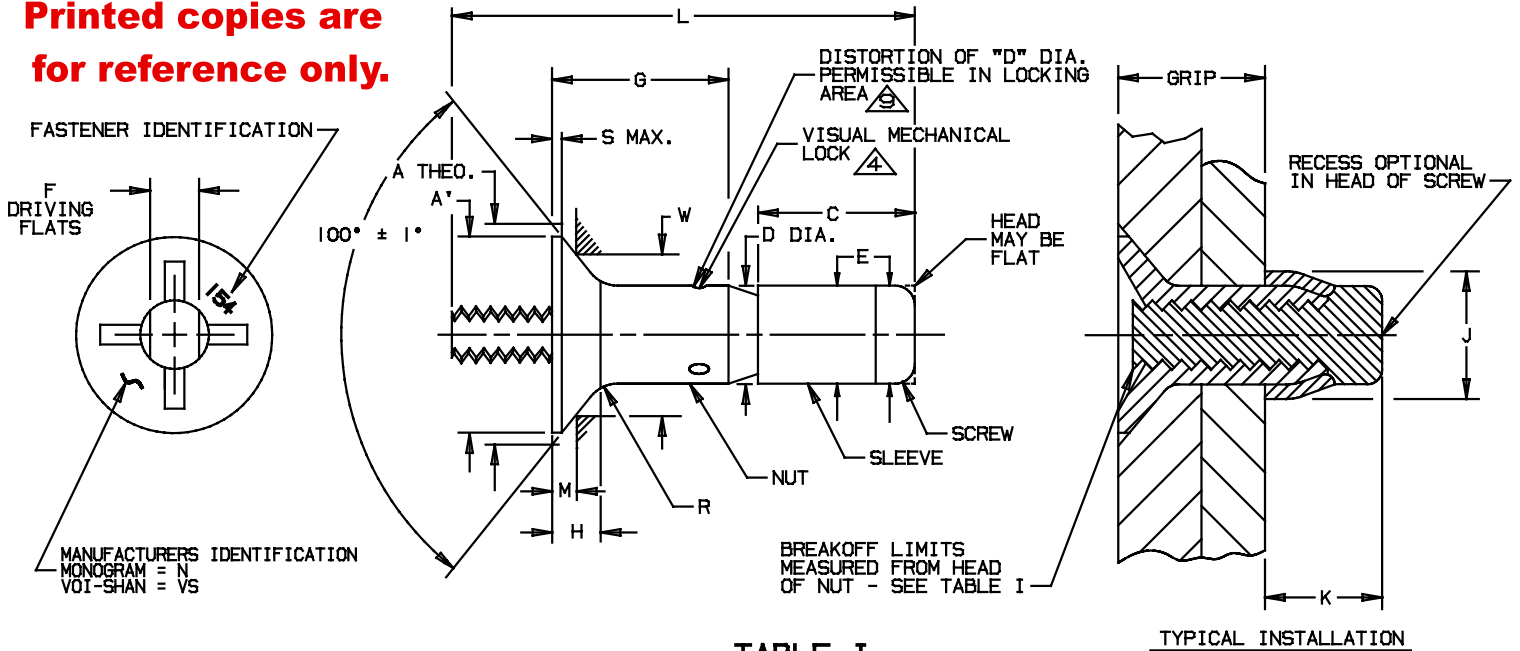


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HEAD MARKING ON NUT DEPRESSED .010 IN. (0.26 mm) MAXIMUM.

TABLE I

TYPICAL INSTALLATION

PART NUMBER	NOM. DIA.		A DIA. Δ THEO.		A' DIA. Δ MIN.		C MAX.		D DIA.		E DIA. MAX.		F FLATS		H REF. Δ		J DIA. MAX.		K REF.	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
PLT154-5-()	.1640	4,166	.332 .325	8,44 8,25	.296	7,52	.285	7,24	.1645 .1635	4,179 4,152	.1615	4,10	.086 .081	2,19 2,05	.069	1,75	.244	6,20	.257	6,53
PLT154-6-()	.2021	5,133	.385 .378	9,78 9,60	.342	8,69	.320	8,13	.2026 .2016	5,146 5,120	.1995	5,07	.104 .099	2,65 2,51	.077	1,96	.300	7,62	.288	7,31
PLT154-8-()	.2646	6,721	.507 .499	12,88 12,67	.463	11,76	.355	9,02	.2651 .2641	6,734 6,708	.2621	6,66	.135 .130	3,43 3,30	.102	2,59	.384	9,75	.320	8,13
PLT154-10-()	.3115	7,912	.635 .626	16,13 15,90	.577	14,66	.440	11,18	.3120 .3110	7,925 7,899	.3090	7,85	.152 .147	3,87 3,73	.134	3,40	.427	10,85	.396	10,06
PLT154-12-()	.3740	9,500	.762 .752	19,36 19,10	.696	17,68	.525	13,34	.3745 .3735	9,513 9,486	.3715	9,44	.185 .180	4,70 4,57	.160	4,06	.516	13,11	.473	12,01
PLT154-14-()	.4365	11,087	.890 .878	22,61 22,30	.815	20,70	.545	13,85	.4370 .4360	11,100 11,074	.4340	11,02	.255 .250	6,48 6,35	.190	4,83	.580	14,74	.518	13,16
PLT154-16-()	.4990	12,675	1.017 1.002	25,84 25,45	.929	23,59	.645	16,39	.4995 .4985	12,688 12,661	.4965	12,61	.255 .250	6,48 6,35	.215	5,46	.655	16,64	.613	15,58

TABLE I (CONT.)

PART NUMBER	M GAGE PROT.		R RAD.		S MAX.		W GAGE DIA.		BREAK-OFF LIMITS Δ		HOLE SIZE Δ		PREVAILING TORQUE MIN. Δ		DOUBLE SHEAR STRENGTH MIN.		TENSILE STRENGTH MIN.	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	IN-LBS	Nm	LBS.	daN	LBS.	daN
PLT154-5-()	.0276 .0239	0,701 0,607	.040 .035	1,02 0,88	.012	0,30	.2671 .2669	6,785 6,779	+.020 -.068	+0,51 -1,73	.1680 .1650	4,27 4,19	1.0	0,11	4680	2080	1350	600
PLT154-6-()	.0250 .0190	0,635 0,482	.050 .045	1,27 1,14	.015	0,38	.3272 .3270	8,311 8,305	+.015 -.073	+0,38 -1,85	.2060 .2030	5,23 5,15	1.5	0,16	6900	3060	2100	930
PLT154-8-()	.0327 .0263	0,831 0,668	.060 .055	1,53 1,39	.015	0,38	.4320 .4318	10,973 10,967	+.010 -.078	+0,25 -1,98	.2685 .2655	6,82 6,74	2.5	0,28	11800	5240	3650	1620
PLT154-10-()	.0390 .0320	0,991 0,812	.070 .060	1,78 1,52	.020	0,51	.5451 .5449	13,846 13,840	+.010 -.083	+0,25 -2,11	.3150 .3120	8,00 7,92	3.5	0,39	17000	7560	5200	2310
PLT154-12-()	.0452 .0378	1,148 0,960	.070 .060	1,78 1,52	.023	0,58	.6582 .6580	16,719 16,713	+.010 -.093	+0,25 -2,36	.3780 .3750	9,60 9,52	4.0	0,45	24500	10890	7500	3330
PLT154-14-()	.0477 .0412	1,212 1,046	.080 .070	2,03 1,78	.026	0,67	.7784 .7782	19,771 19,766	+.010 -.100	+0,25 -2,54	.4400 .4370	11,18 11,10	7.0	0,79	33500	14901	10150	4514
PLT154-16-()	.0542 .0462	1,377 1,173	.090 .080	2,29 2,03	.030	0,77	.8902 .8900	22,611 22,606	+.010 -.110	+0,26 -2,79	.5030 .5000	12,78 12,70	10.0	1,13	43800	19483	13500	6005

Fairchild

CODE IDENT. NO.
5M902

U.S. PATENT NO. 3643544.

MONOGRAM

CODE IDENT. NO.
98524

APPROVED DATE
21 APRIL 1971

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TITLE
VISU-LOK, FASTENER, BLIND
INTERNALLY THREADED, EXTERNAL SLEEVE
5% CHROME STEEL (H-11)
HIGH STRENGTH, FLUSH HEAD, SELF-LOCKING
GROUND SHANK

STANDARD

PLT154

SHEET 1 OF 2



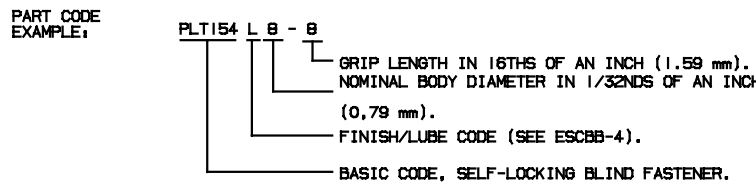
TABLE II

SECOND DASH NUMBER	GRIP RANGE Δ Δ				G GRIP (a)		L REF.													
	MIN.		MAX.				-5		-6		-8		-10		-12		-14		-16	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
-2	.094	2.38	.156	3.97	.156	3.96	.713	18.11	.829	21.06										
-3	.157	3.98	.219	5.57	.219	5.56	.776	19.71	.892	22.66	.910	23.11								
-4	.220	5.58	.291	7.14	.291	7.14	.838	21.29	.954	24.23	.972	24.69	1.189	30.20	1.261	32.03				
-5	.282	7.15	.344	8.74	.344	8.74	.901	22.89	1.017	25.83	1.035	26.29	1.252	31.80	1.324	33.63	1.390	35.31		
-6	.345	8.75	.406	10.32	.406	10.31	.963	24.46	1.079	27.41	1.097	27.86	1.314	33.38	1.386	35.20	1.452	36.88	1.657	42.09
-7	.407	10.33	.469	11.92	.469	11.91	1.026	26.06	1.142	29.01	1.160	29.46	1.377	34.98	1.449	36.80	1.515	38.48	1.720	43.69
-8	.470	11.93	.531	13.49	.531	13.49	1.088	27.64	1.204	30.59	1.222	31.04	1.439	36.55	1.511	38.38	1.577	40.06	1.782	45.26
-9	.532	13.50	.594	15.09	.594	15.09	1.151	29.24	1.267	32.18	1.285	32.64	1.502	38.15	1.574	39.98	1.640	41.66	1.845	46.86
-10	.595	15.10	.656	16.67	.656	16.66	1.213	30.81	1.329	33.76	1.347	34.21	1.564	39.73	1.636	41.55	1.702	43.23	1.907	48.44
-11	.657	16.68	.719	18.27	.719	18.26	1.276	32.41	1.392	35.36	1.410	35.81	1.627	41.33	1.699	43.15	1.765	44.83	1.970	50.04
-12	.720	18.28	.781	19.84	.781	19.84	1.338	33.99	1.454	36.93	1.472	37.39	1.689	42.90	1.761	44.73	1.827	46.41	2.032	51.61
-13	.782	19.85	.844	21.44	.844	21.44	1.401	35.59	1.517	38.53	1.535	38.99	1.752	44.50	1.824	46.33	1.890	48.01	2.095	53.21
-14	.845	21.45	.906	23.02	.906	23.01	1.463	37.16	1.579	40.11	1.597	40.56	1.814	46.08	1.886	47.90	1.952	49.58	2.157	54.79
-15	.907	23.03	.969	24.62	.969	24.61	1.526	38.76	1.642	41.71	1.660	42.16	1.877	47.68	1.949	49.50	2.015	51.18	2.220	56.39
-16	.970	24.63	1.031	26.19	1.031	26.19	1.588	40.34	1.704	43.28	1.722	43.74	1.939	49.25	2.011	51.08	2.077	52.76	2.282	57.97
-17	1.032	26.20	1.094	27.79	1.094	27.79			1.767	44.88	1.785	45.34	2.002	50.85	2.074	52.68	2.140	54.36	2.345	59.56
-18	1.095	27.80	1.156	29.37	1.156	29.36			1.829	46.46	1.847	46.91	2.064	52.43	2.136	54.25	2.202	55.93	2.407	61.14
-19	1.157	29.38	1.219	30.97	1.219	30.96			1.892	48.06	1.910	48.51	2.127	54.03	2.199	55.85	2.265	57.53	2.470	62.74
-20	1.220	30.98	1.281	32.54	1.281	32.54			1.954	49.63	1.972	50.09	2.189	55.60	2.261	57.43	2.327	59.11	2.532	64.31
-21	1.282	32.55	1.344	34.14	1.344	34.14			2.017	51.23	2.035	51.69	2.252	57.20	2.324	59.03	2.390	60.71	2.595	65.91
-22	1.345	34.15	1.406	35.72	1.406	35.71			2.079	52.81	2.097	53.26	2.314	58.78	2.386	60.60	2.452	62.28	2.657	67.49
-23	1.407	35.73	1.469	37.32	1.469	37.31			2.142	54.41	2.160	54.86	2.377	60.38	2.449	62.20	2.515	63.88	2.720	69.09
-24	1.470	37.33	1.531	38.89	1.531	38.89			2.204	55.98	2.222	56.44	2.439	61.95	2.511	63.78	2.577	65.46	2.782	70.66
-25	1.532	38.90	1.594	40.49	1.594	40.49			2.267	57.58	2.285	58.04	2.502	63.55	2.574	65.38	2.640	67.06	2.845	72.26
-26	1.595	40.50	1.656	42.07	1.656	42.06			2.329	59.16	2.347	59.61	2.564	65.13	2.636	66.95	2.702	68.63	2.907	73.84
-27	1.657	42.08	1.719	43.67	1.719	43.66			2.392	60.76	2.410	61.21	2.627	66.73	2.699	68.55	2.765	70.23	2.970	75.44
-28	1.720	43.68	1.781	45.24	1.781	45.24			2.454	62.33	2.472	62.79	2.689	68.30	2.761	70.13	2.827	71.81	3.032	77.01
-29	1.782	45.25	1.844	46.84	1.844	46.84			2.517	63.93	2.535	64.39	2.752	69.90	2.824	71.73	2.890	73.41	3.095	78.61
-30	1.845	46.85	1.906	48.42	1.906	48.41			2.579	65.51	2.597	65.96	2.814	71.48	2.886	73.30	2.952	74.98	3.157	80.19
-31	1.907	48.43	1.969	50.02	1.969	50.01			2.642	67.11	2.660	67.56	2.877	73.08	2.949	74.90	3.015	76.58	3.220	81.79
-32	1.970	50.03	2.031	51.59	2.031	51.59			2.704	68.68	2.722	69.14	2.939	74.65	3.011	76.47	3.077	78.16	3.282	83.36

(a) "G" TOLERANCES: FOR -5 & -6 SIZES $+0.030$ ($+0.762$); FOR -8 & -10 SIZES $+0.040$ ($+1.016$); FOR -12 SIZES $+0.050$ ($+1.270$)
 -0.010 (-0.254); -0.010 (-0.254); -0.010 (-0.254)

PROCUREMENT SPECIFICATION: ESCBB-10.
 MATERIAL: NUT, SCREW: 5% CHROME STEEL (H-11) PER AMS6487.
 SLEEVE: INCONEL X-750 PER AMS5667 OR AMS5582;
 OR A-286 PER AMS5731, AMS5732 OR AMS5737.
 HEAT TREAT: NUT & SCREW: ROCKWELL "C" 48-53.
 SLEEVE: AS REQUIRED FOR PERFORMANCE.
 FINISH: (-) NUT & SCREW: CADMIUM PLATE PER NAS672 (.0003 MIN THICKNESS)
 EXCEPT THERMAL INDICATOR MAY BE OMITTED.
 SUPPLEMENTARY CHROMATE TREATMENT PER QQ-P-416
 AFTER BAKE, COLOR NUT RED.
 SLEEVE: CADMIUM PLATE PER QQ-P-416, TYPE I OR TYPE II,
 CLASS 2 OR CLASS 3.
 L NUT & SLEEVE: ALUMINUM COAT PER NAS 4006.
 SCREW: CADMIUM PLATE PER NAS672 (.0003 MIN THICKNESS)
 EXCEPT THERMAL INDICATOR MAY BE OMITTED.
 SUPPLEMENTARY CHROMATE TREATMENT PER QQ-P-416
 AFTER BAKE.
 LUBRICATION: LUBRICANTS LISTED BELOW MAY BE APPLIED TO ANY OR ALL
 COMPONENTS IF REQUIRED FOR PERFORMANCE. DRY FILM LUBE
 PER MIL-L-46010 TYPE I OR EVERLUBE 812 PER MIL-L-81329,
 PARAFFIN WAX, CETYL ALCOHOL PER MIL-L-87132, AND/OR
 W/M CARBO-WAX.

GENERAL NOTES:
 1 OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE
 SHALL NOT BE GREATER THAN MAXIMUM "D" DIAMETER.
 2 CONCENTRICITY OF NUT HEAD CONICAL SURFACE TO "D" DIAMETER SHALL BE WITHIN
 .005 IN. (0.13 mm) T.I.R., EXCEPT OVER INDENTATIONS.
 3 FASTENERS SHALL BE FREE OF ALL LOOSE OR HANGING BURRS.
 4 LOCKING FEATURE CONSISTS OF THREE (3) INDENTATIONS LOCATED 120° APART
 ON THE PERIPHERY OF THE NUT COMPONENT AND APPROXIMATELY .040 IN. (1.02 mm)
 ABOVE THE INTERSECTION OF THE NUT NOSE ANGLE AND O.D. (MEAN GRIP OF
 FASTENER).
 5 STANDARD GRIP LENGTHS ARE SHOWN IN TABLE II, SHORTER OR LONGER GRIPS THAN
 THOSE LISTED MAY BE AVAILABLE AS SPECIALS. ON GRIP LENGTHS SHORTER THAN
 THOSE LISTED, THE BREAKOFF LIMITS AND PREVAILING TORQUE VALUES SHOWN IN
 TABLE I DO NOT APPLY.
 6 STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. SEE ESCBB-4 FOR SPECIAL
 FINISHES AND/OR LUBRICANTS, IF REQUIRED.
 7 HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS
 EXAMPLE: PLT154-6-4.5 INDICATES A NOMINAL GRIP LENGTH OF 4.5 16THS
 (.281" = 7.14mm) THE GRIP RANGE FOR THESE HALF GRIP SIZES
 WILL BE NOMINAL GRIP $+0.031/-0.030$ ($+0.79/-0.79$ mm); THE BASIC
 "G" DIMENSION WILL BE MAXIMUM GRIP ± 0.031 (± 0.79 mm) AND THE
 OVERALL SCREW LENGTH "L" DIMENSION MAY VARY AT THE
 MANUFACTURER'S OPTION
 8 GROUND SHANK VISU-LOK BLIND FASTENERS SHOULD NOT BE USED EXCEPT WITH
 CONSIDERABLE CAUTION IN APPLICATIONS WHICH EXCEED APPROXIMATELY
 .0005 INTERFERENCE FIT. GROUND SHANK VISU-LOK BLIND FASTENERS WILL
 PERFORM SATISFACTORILY WHEN INSTALLED IN THE TABULATED HOLE SIZES.
 9 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 MAXIMUM "D" $\pm .001$ " FORCE FOR INSERTION
 SHALL NOT EXCEED FIVE (5) POUNDS (22.23 NEWTONS)
 10 DIMENSIONS "A", "A'" AND "H" ARE FOR ENGINEERING REFERENCE PURPOSES ONLY
 AND ARE NOT TO BE USED FOR INSPECTION PURPOSES. THESE DIMENSIONS
 ARE THEORETICAL VALUES DERIVED FROM "D", "S", "M", "W" AND HEAD
 ANGLE DIMENSIONS.
 11 DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.



Fairchild
 CODE IDENT. NO.
5M902

U.S. PATENT NO. 3643544.

MONOGRAM
 CODE IDENT. NO.
98524

APPROVED DATE
 21 APRIL 1971
 REV. LETTER AND DATE
 ECN #1021
 "Z" 03-27-01

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TITLE
 VISU-LOK, FASTENER, BLIND
 INTERNALLY THREADED, EXTERNAL SLEEVE
 5% CHROME STEEL (H-11)
 HIGH STRENGTH, FLUSH HEAD, SELF-LOCKING
 GROUND SHANK

STANDARD
PLT154
SHEET 2 OF 2