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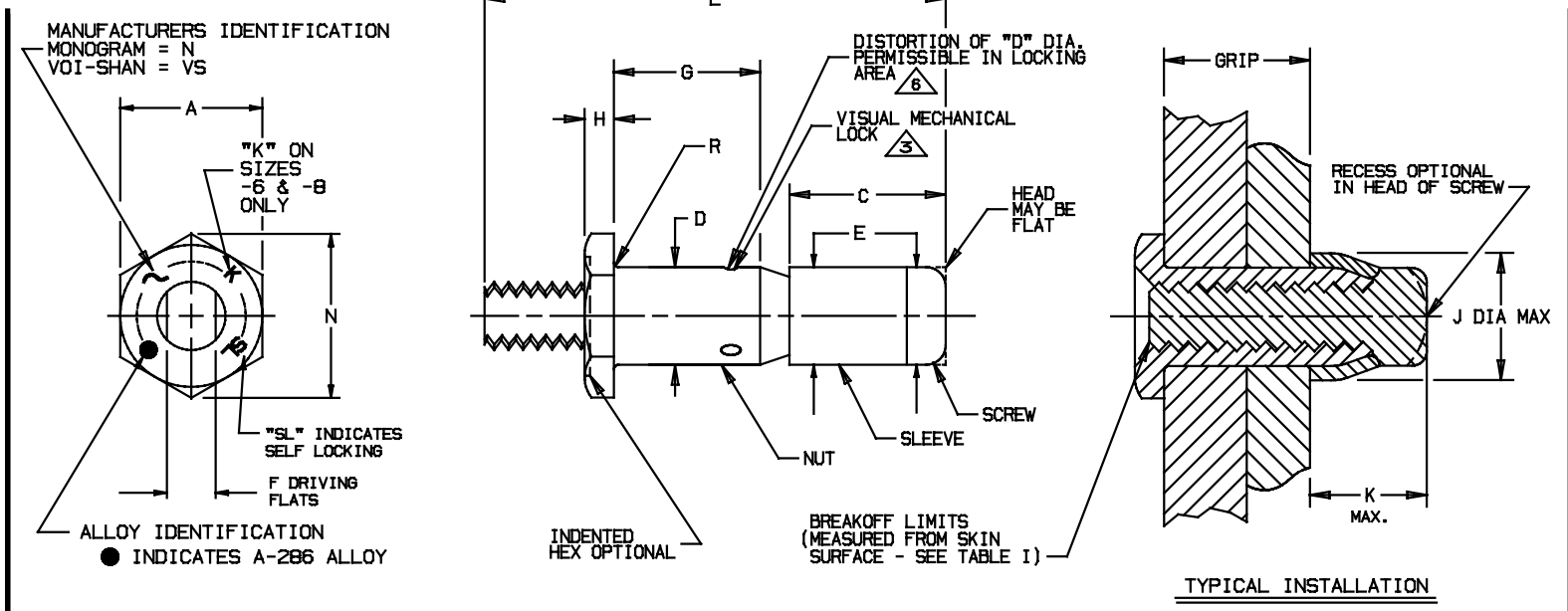


TABLE I

PART NUMBER	NOM. DIA.		A DIA.		C MAX.		D DIA.		E DIA. MAX.		F FLATS		H MAX.		J DIA. MAX.		K MAX.			
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm		
PLT225(**)-5-(*)	.1635	4,15	.250 .244	6,35 6,19			.268	6,81	.1645 .1625	4,18 4,12	.1620	4,12	.086 .081	2,19 2,05	.096	2,44	.244	6,20	.267	6,90
PLT225(**)-6-(*)	.1890	4,80	.312 .305	7,93 7,74			.303	7,70	.1900 .1880	4,83 4,77	.1875	4,77	.104 .099	2,65 2,51	.113	2,88	.300	7,62	.302	8,63
PLT225(**)-8-(*)	.2480	6,30	.375 .367	9,53 9,32			.354	9,00	.2490 .2470	6,33 6,27	.2465	6,27	.135 .130	3,43 3,30	.135	3,43	.384	9,76	.346	10,38
PLT225(**)-10-(*)	.3105	7,89	.437 .429	11,10 10,89			.423	10,75	.3115 .3095	7,92 7,86	.3090	7,85	.152 .147	3,87 3,73	.160	4,07	.427	10,85	.414	12,16
PLT225(**)-12-(*)	.3735	9,49	.500 .491	12,70 12,47			.510	12,96	.3745 .3725	9,52 9,46	.3720	9,45	.185 .180	4,70 4,57	.190	4,83	.516	13,11	.470	13,91

TABLE I (CONT.)

PART NUMBER	N MIN.		R RAD.						BREAK-OFF LIMITS		HOLE SIZE		PREVAILING TORQUE		DOUBLE SHEAR STRENGTH		TENSILE STRENGTH	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	IN-LBS	Nm	LBS.	daN	LBS.	daN
PLT225(**)-5-(*)	.272	6,90	.020 .010	0,51 0,25					+.088 +.000	+2,24 +0,00	.168 .165	4,27 4,19	1.0	0,11	3150	1400	900	400
PLT225(**)-6-(*)	.340	8,63	.025 .015	0,64 0,38					+.103 +.015	+2,62 +0,38	.193 .190	4,90 4,82	1.5	0,16	4200	1860	1400	620
PLT225(**)-8-(*)	.409	10,38	.025 .015	0,64 0,38					+.130 +.032	+3,31 +0,81	.252 .249	6,40 6,32	2.5	0,28	7200	3200	2100	930
PLT225(**)-10-(*)	.479	12,16	.030 .015	0,77 0,38					+.130 +.027	+3,31 +0,68	.315 .312	8,00 7,92	3.5	0,39	11350	5050	3600	1600
PLT225(**)-12-(*)	.548	13,91	.030 .015	0,77 0,38					+.130 +.027	+3,31 +0,68	.378 .375	9,60 9,52	4.0	0,45	16450	7320	5600	2490

(*) SEE TABLE II FOR SECOND DASH NUMBER AND APPROVED CALLOUT.
 (**) DESIGNATES FINISH. SEE PART CODE EXAMPLE AND FINISH CALLOUT.

PART CODE EXAMPLE:

PLT225 A - 8 - 8

- GRIP LENGTH IN 16THS (SEE TABLE II).
- NOMINAL BODY DIAMETER AS TABULATED.
- FINISH (SEE FINISH CALLOUT).
- BASIC CODE, SELF-LOCKING BLIND FASTENER.

U.S. PATENT NO. 3643544, OTHER PATENTS PENDING.

Fairchild
 CODE IDENT. NO.
92215

MONOGRAM
 CODE IDENT. NO.
98524

APPROVED DATE
 27 JANUARY 1972

REV. LETTER AND DATE
 ④ 04-07-94

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TITLE
VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE HIGH TEMPERATURE (A-286 ALLOY) PROTRUDING HEAD, SELF LOCKING FRACTIONAL DIAMETER

STANDARD
PLT 225
 SHEET 1 OF 2



TABLE II

SECOND DASH NUMBER	GRIP RANGE Δ				G GRIP (a)		L REF.									
	MIN.		MAX.		INCH	mm	-5		-6		-8		-10		-12	
	INCH	mm	INCH	mm			INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
-1	.031	0,79	.093	2,36	.093	2,39	.733	18,62	.874	22,20						
-2	.094	2,39	.156	3,96	.156	3,96	.795	20,19	.936	23,77	1.006	25,57	1.158	29,413		
-3	.157	3,99	.219	5,56	.219	5,56	.858	21,80	.999	25,37	1.069	27,153	1.221	31,013	1.367	34,722
-4	.220	5,59	.281	7,14	.281	7,14	.920	23,37	1.061	26,949	1.131	28,727	1.283	32,588	1.429	36,230
-5	.282	7,16	.344	8,74	.344	8,74	.983	24,97	1.124	28,550	1.194	30,328	1.346	34,188	1.492	36,897
-6	.345	8,76	.406	10,31	.406	10,31	1.045	26,543	1.186	30,124	1.256	31,902	1.408	35,763	1.554	39,472
-7	.407	10,34	.469	11,91	.469	11,91	1.108	28,143	1.249	31,725	1.319	33,503	1.471	37,363	1.617	41,072
-8	.470	11,94	.531	13,49	.531	13,49	1.170	29,718	1.311	33,300	1.381	35,077	1.533	38,938	1.679	42,647
-9	.532	13,51	.594	15,11	.594	15,11	1.233	31,318	1.374	34,900	1.444	36,678	1.596	40,538	1.742	44,247
-10	.595	15,11	.656	16,66	.656	16,66	1.295	32,893	1.436	36,474	1.506	38,252	1.658	42,113	1.804	45,822
-11	.657	16,69	.719	18,26	.719	18,26	1.358	34,493	1.499	38,075	1.569	39,853	1.721	43,713	1.867	47,422
-12	.720	18,29	.781	19,84	.781	19,84	1.420	36,068	1.561	39,650	1.631	41,427	1.783	45,288	1.929	48,997
-13	.782	19,86	.844	21,44	.844	21,44	1.483	37,668	1.524	41,250	1.694	43,028	1.846	46,888	1.992	50,597
-14	.845	21,46	.906	23,01	.906	23,01	1.545	39,243	1.686	42,824	1.756	44,602	1.908	48,463	2.054	52,172
-15	.907	23,04	.969	24,61	.969	24,61	1.608	40,843	1.749	44,425	1.819	46,203	1.971	50,063	2.117	53,772
-16	.970	24,64	1.031	26,19	1.031	26,19	1.670	42,418	1.811	46,000	1.881	47,777	2.033	51,638	2.179	55,347
-17	1.032	26,21	1.094	27,79	1.094	27,79			1.874	47,600	1.944	49,378	2.096	53,238	2.242	56,947
-18	1.095	27,81	1.156	29,36	1.156	29,36			1.936	49,174	2.006	50,952	2.158	54,813	2.304	58,522
-19	1.157	29,39	1.219	30,96	1.219	30,96			1.999	50,775	2.069	52,553	2.221	56,413	2.367	60,122
-20	1.220	30,99	1.281	32,54	1.281	32,54			2.061	52,350	2.131	54,127	2.283	57,988	2.429	61,697
-21	1.282	32,56	1.344	34,14	1.344	34,14			2.124	53,950	2.194	55,728	2.346	59,588	2.492	63,297
-22	1.345	34,16	1.406	35,71	1.406	35,71			2.186	55,524	2.256	57,302	2.408	61,163	2.554	64,872
-23	1.407	35,74	1.469	37,31	1.469	37,31			2.249	57,125	2.319	58,903	2.471	62,763	2.617	66,472
-24	1.470	37,34	1.531	38,89	1.531	38,89			2.311	58,700	2.381	60,477	2.533	64,338	2.679	68,047
-25	1.532	38,91	1.594	40,49	1.594	40,49			2.374	60,300	2.444	62,078	2.596	65,938	2.742	69,647
-26	1.595	40,51	1.656	42,06	1.656	42,06			2.436	61,874	2.506	63,652	2.658	67,513	2.804	71,222
-27	1.657	42,09	1.719	43,66	1.719	43,66			2.499	63,475	2.569	65,253	2.721	69,113	2.867	72,822
-28	1.720	43,69	1.781	45,24	1.781	45,24			2.561	65,049	2.631	66,827	2.783	70,688	2.929	74,397
-29	1.782	45,26	1.844	46,84	1.844	46,84			2.624	66,650	2.694	68,428	2.846	72,288	2.992	75,997
-30	1.845	46,86	1.906	48,41	1.906	48,41			2.686	68,224	2.756	70,002	2.908	73,863	3.054	77,572
-31	1.907	48,44	1.969	50,01	1.969	50,01			2.749	69,825	2.819	71,603	2.971	75,463	3.117	79,172
-32	1.970	50,04	2.031	51,59	2.031	51,59			2.811	71,400	2.881	73,177	3.033	77,038	3.179	80,747

(a) "G" TOLERANCES: FOR -5 & -6 SIZES $+0.030 (+0,77)$; FOR -8 & -10 SIZES $+0.040 (+1,02)$; FOR -12 SIZE $+0.050 (+1,27)$
 $-0.010 (-0,25)$; $-0.010 (-0,25)$; $-0.010 (-0,25)$

PROCUREMENT SPECIFICATION: ESCBB-2 CLASS 2, EXCEPT AS SPECIFIED HEREIN.

MATERIAL: NUT, SCREW & SLEEVE: CORROSION AND HEAT RESISTANT STEEL, TYPE A-286 PER AMS 5731, AMS 5732 AND AMS 5737

HEAT TREAT: NUT & SCREW: SOLUTION HEAT TREATED AND AGED TO A CORE HARDNESS OF Rc 30 TO Rc 45 ALL CORE HARDNESS READINGS ARE TAKEN ON MOUNTED SPECIMEN, USING A BRALE PENETRATOR AND A 30 Kg LOAD (ROCKWELL 30N)

SLEEVE: SOLUTION TREATED

FINISH: NO CODE NUT, SCREW & SLEEVE: PASSIVATED PER MIL-S-5002

"A" CODE NUT, SCREW & SLEEVE: PASSIVATED PER MIL-S-5002, CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2.

GENERAL NOTES: (CONTINUE)

4 HEAD MARKING ON NUT DEPRESSED .010 IN. (0,26 mm) MAXIMUM.

Δ STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. SEE ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.

Δ 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" + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS (22,23 NEWTONS)

Δ HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS EXAMPLE: PLT225-6-4,5 INDICATES A NOMINAL GRIP LENGTH OF 4.5 16THS (.281" = 7.14mm) THE GRIP RANGE FOR THESE HALF GRIP SIZES WILL BE NOMINAL GRIP +.031/-0.030 (+0,79/-0,76 mm), THE BASIC "G" DIMENSION WILL BE MAXIMUM GRIP +.031 (+ 0,79mm) AND THE OVERALL SCREW LENGTH "L" DIMENSION MAY VARY AT THE MANUFACTURER'S OPTION

Δ 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.

LUBRICATION: LUBRICANTS LISTED BELOW MAY BE APPLIED TO ANY OR ALL COMPONENTS IF REQUIRED FOR PERFORMANCE, DRY FILM LUBE MoS₂ PER MIL-L-46010 TYPE I OR MIL-L-81329, W/M CARBO-WAX, PARAFFIN WAX AND/OR CETYL ALCOHOL PER MIL-L-87132.

Δ THE PREVAILING TORQUE SHALL CONFORM TO THE VALUES AS TABULATED, WHEN TESTED IN ACCORDANCE WITH SPECIFICATION ESCBB-2. HOWEVER, PREVAILING TORQUES FOR THE PLT225-5-1 AND PLT225-6-1 SHALL BE RECORDED THRU A ROTATION OF ONLY 360° OF THE NUT.

10. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.

GENERAL NOTES:

1 OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT BE GREATER THAN MAXIMUM "E" DIAMETER.

2 FASTENERS SHALL BE FREE OF ALL LOOSE OR HANGING BURRS.

Δ 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).

Fairchild
 CODE IDENT. NO.
92215

MONOGRAM
 CODE IDENT. NO.
98524

U.S. PATENT NO. 3643544, OTHER PATENTS PENDING.

APPROVED DATE
 13 NOVEMBER 1970

REV. LETTER AND DATE
 ① 04-07-94

TITLE
VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE HIGH TEMPERATURE (A-286 ALLOY) PROTRUDING HEAD, SELF LOCKING FRACTIONAL DIAMETER

STANDARD
PLT 225
SHEET 2 OF 2