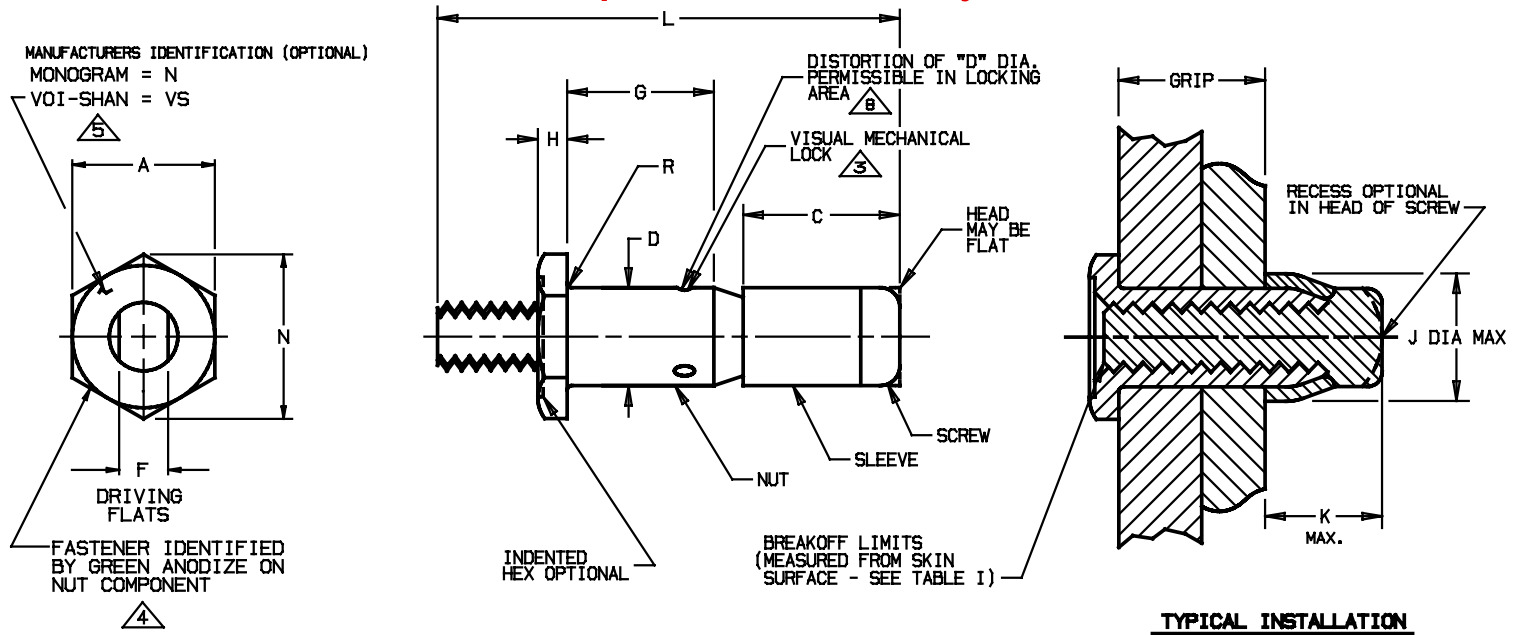


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TYPICAL INSTALLATION

TABLE I

PART NUMBER	NOM. DIA.	A DIA.	C MAX.	D DIA.	F DRIVING FLATS	H MAX.	J DIA. MAX.	K MAX.	N MIN.	R RAD.	HOLE SIZE	BREAK-OFF LIMITS	PREVAILING TORQUE [IN. - LBS.] MIN.	DOUBLE SHEAR STRENGTH [LBS.] MIN.	TENSILE STRENGTH [LBS.] MIN.
PLT 231-5-(*)	.179	.283 .277	.293	.180 .178	.086 .081	.096	.244	.272	.307	.020 .010	.183 .180	+ .088 + .000	.75	1920	750
PLT 231-6-(*)	.214	.346 .332	.328	.215 .213	.104 .099	.113	.300	.312	.372	.025 .015	.218 .215	+ .103 + .015	1.00	3100	950
PLT 231-8-(*)	.275	.472 .458	.379	.276 .274	.135 .130	.135	.384	.351	.511	.025 .015	.279 .276	+ .135 + .047	1.50	5300	1500

(*) SEE TABLE II FOR SECOND DASH NUMBER AND APPROVED CALLOUT.

TABLE II

SECOND DASH NUMBER	GRIP RANGE		G	L REF.		
	MIN.	MAX.		PLT 231		
				-5-(*)	-6-(*)	-8-(*)
-1	.031	.093	.093	.733	.874	
-2	.094	.156	.156	.795	.936	1.006
-3	.157	.219	.219	.858	.999	1.069
-4	.220	.281	.281	.920	1.061	1.131
-5	.282	.344	.344	.983	1.124	1.194
-6	.345	.406	.406	1.045	1.186	1.256
-7	.407	.469	.469	1.108	1.249	1.319
-8	.470	.531	.531	1.170	1.311	1.381
-9	.532	.594	.594	1.233	1.374	1.444
-10	.595	.656	.656	1.295	1.436	1.506
-11	.657	.719	.719	1.358	1.499	1.569
-12	.720	.781	.781	1.420	1.561	1.631
-13	.782	.844	.844	1.483	1.624	1.694
-14	.845	.906	.906	1.545	1.686	1.756
-15	.907	.969	.969	1.608	1.749	1.819
-16	.970	1.031	1.031	1.670	1.811	1.881
-17	1.032	1.094	1.094			
-18	1.095	1.156	1.156			
-19	1.157	1.219	1.219			
-20	1.220	1.281	1.281			
-21	1.282	1.344	1.344			
-22	1.345	1.406	1.406			
-23	1.407	1.469	1.469			
-24	1.470	1.531	1.531			
-25	1.532	1.594	1.594			
-26	1.595	1.656	1.656			
-27	1.657	1.719	1.719			
-28	1.720	1.781	1.781			
-29	1.782	1.844	1.844			
-30	1.845	1.906	1.906			
-31	1.907	1.969	1.969			
-32	1.970	2.031	2.031			

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▲ "G" TOLERANCES: FOR -5 & -6 SIZES +.030/-.010; FOR -8 SIZE +.040/-.010.
 U.S. PATENT NO. 3643544, OTHER PATENTS PENDING.

MONOGRAM
 CODE IDENT. NO.
98524

APPROVED DATE
 06 OCTOBER 1971
 REV. LETTER AND DATE
 04-15-94

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TITLE
VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE LIGHTWEIGHT PROTRUDING HEAD, SELF LOCKING 1/64" OVERSIZE

STANDARD
PLT 231
 SHEET 1 OF 2



PROCUREMENT SPEC. : ESCBB-2, CLASS 3, EXCEPT AS SPECIFIED HEREIN.

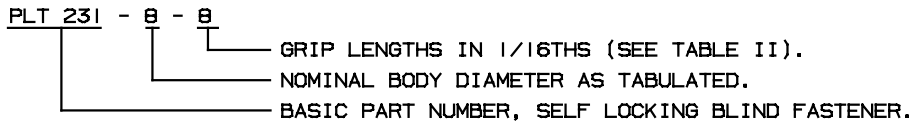
MATERIAL : NUT : ALUMINUM ALLOY 7075 PER QQ-A-225/9.
 SCREW : ALLOY STEEL PER MIL-S-5626, MIL-S-6049 OR MIL-S-6758.
 SLEEVE : CORROSION RESISTANT STEEL: 303 OR 304 PER QQ-S-763, AMS 5639 OR AMS5641.

HEAT TREAT : NUT : HEAT TREAT MACHINED PARTS PER MIL-H-6088 AND HEAT TREAT HEADED OR FORGED PARTS PER AMS2770.
 SCREW : HEAT TREAT PER MIL-H-6875, APPROXIMATELY 180,000 TO 200,000 PSI TENSILE (Rc 39-43).
 SLEEVE : AS REQUIRED FOR PERFORMANCE.

△ FINISH : NUT : ANODIZE PER MIL-A-8625, TYPE II (GREEN).
 SCREW : CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2. CADMIUM PLATE PER NAS672 IS PERMISSIBLE PROVIDED IT IS FOLLOWED BY A DICHROMATE POST TREATMENT PER QQ-P-416.
 SLEEVE : PASSIVATE PER MIL-S-5002. CADMIUM PLATE PER QQ-P-416, TYPE I, CLASS 3.

△ LUBRICANT: LUBRICANTS LISTED BELOW MAY BE APPLIED TO ANY OR ALL COMPONENTS IF REQUIRED FOR FASTENER PERFORMANCE:
 NUT : WWM CARBO-WAX, PARAFFIN WAX AND/OR CETYL ALCOHOL PER MIL-L-87132.
 SCREW & SLEEVE : DRY FILM LUBE MoS₂, PER MIL-L-46010 OR MIL-L-81329, WWM CARBO-WAX, PARAFFIN WAX AND/OR CETYL ALCOHOL PER MIL-L-87132.

PART CODE & EXAMPLE :



- GENERAL NOTES :
- 1.) OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT BE GREATER THAN MAXIMUM "D" DIAMETER.
 - 2.) REMOVE ALL LOOSE OR HANGING BURRS.
 - △ 3. LOCKING FEATURE CONSISTS OF THREE (3) INDENTATIONS LOCATED 120° APART ON THE PERIPHERY OF THE NUT COMPONENT AND APPROXIMATELY .040 ABOVE THE INTERSECTION OF THE NUT NOSE ANGLE AND O.D. (MEAN GRIP OF FASTENER).
 - △ 4. THE PRODUCT DESCRIBED BY THIS DRAWING IS "EQUIVALENT TO" AND "INTERCHANGEABLE WITH" THE MANUFACTURER'S PRODUCT LISTED BELOW EXCEPT FOR THE HEAD IDENTIFICATION MARKINGS, COLOR, AND SELF-LOCKING FEATURE. EXISTING STOCK MAY BE REWORKED TO INCORPORATE THE LOCK. WHEN THESE REWORKED FASTENERS ARE SUPPLIED, THE HEAD IDENTIFICATION MAY BE AS SHOWN BELOW :
 MONOGRAM...: PPA0164-PPA0260 SERIES (MARKING: "L" OR "SL"; NUT COLOR: RED).
 VOI-SHAN...: BDRVH SERIES (MARKING: "VS", "DV" AND "SL"; NUT COLOR BLUE).
 - △ 5. MANUFACTURER'S IDENTIFICATION: (OPTIONAL) DEPRESSED .010" MAX. LETTER "N" DESIGNATES MONOGRAM/AEROSPACE FASTENERS. LETTERS "VS" DESIGNATE VOI-SHAN.
 - △ 6. STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION 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: PLT 231-6-4.5 INDICATES A NOMINAL GRIP LENGTH OF 4.5 SIXTEENTHS = .281. THE GRIP RANGE FOR THESE HALF-GRIP SIZES WILL BE NOMINAL GRIP + .031/- .030. THE BASIC "G" DIMENSION WILL BE NOMINAL GRIP + .031 AND THE OVERALL SCREW LENGTH "L" DIMENSION MAY VARY AT MANUFACTURER'S OPTION.
 - △ 8. 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" + .002". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS.
 - △ 9. 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 TORQUES SHOWN IN TABLE I DO NOT APPLY.
 - △ 10. THE PREVAILING TORQUE SHALL CONFORM TO THE VALUES AS TABULATED, WHEN TESTED IN ACCORDANCE WITH SPECIFICATION ESCBB-2. HOWEVER, PREVAILING TORQUES FOR THE PLT231-5-1 AND PLT231-6-1 SHALL BE RECORDED THRU A ROTATION OF ONLY 360° OF THE NUT.

11. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.

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

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TITLE
VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE LIGHTWEIGHT PROTRUDING HEAD, SELF LOCKING 1/8" OVERSIZE

STANDARD
PLT 231
SHEET 2 OF 2

REV. LETTER AND DATE
 ⓐ 04-15-94