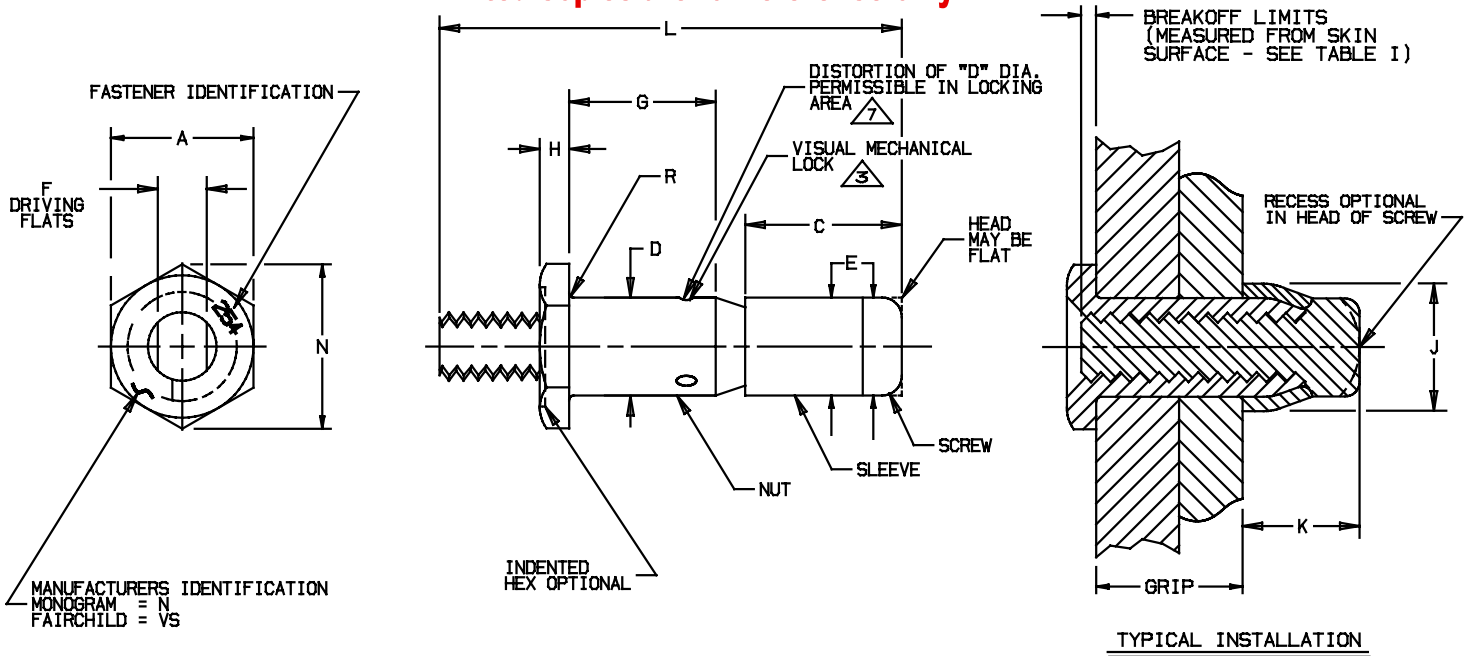


Printed copies are for reference only.



HEAD MARKINGS DEPRESSED .010 INCH (0,254 mm MAX.) (POSITION OPTIONAL)

TABLE I

PART NUMBER	NOM. DIA.		A		C MAX.		D DIA.		E DIA MAX.		F FLATS		H MAX.		J DIA. MAX.		K REF.	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
PLT254-5- ()	.1640	4,166	.250 .244	6,35 6,19	.285	7,24	.1645 .1635	4,179 4,152	.1615	4,11	.086 .081	2,19 2,05	.096	2,44	.244	6,20	.257	6,53
PLT254-6- ()	.2021	5,133	.312 .305	7,93 7,74	.320	8,13	.2026 .2016	5,147 5,120	.1995	5,07	.104 .099	2,65 2,51	.113	2,88	.300	7,62	.288	7,32
PLT254-8- ()	.2646	6,721	.375 .367	9,53 9,32	.355	9,02	.2651 .2641	6,734 6,708	.2621	6,66	.135 .130	3,43 3,30	.135	3,43	.384	9,76	.320	8,13
PLT254-10- ()	.3115	7,912	.437 .429	11,10 10,89	.440	11,18	.3120 .3110	7,925 7,899	.3090	7,85	.152 .147	3,87 3,73	.160	4,07	.427	10,85	.396	10,06
PLT254-12- ()	.3740	9,500	.500 .491	12,70 12,47	.525	13,34	.3745 .3735	9,513 9,486	.3715	9,44	.185 .180	4,70 4,57	.190	4,83	.516	13,11	.473	12,02

TABLE I (CONT.)

PART NUMBER	N MIN.		R RAD.		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	IN-LB	Nm	LBS.	daN	LBS.	daN
PLT254-5- ()	.272	6,90	.025 .020	0,64 0,50	+0,088 +0,000	+2,24 +0,00	.1680 .1650	4,267 4,191	1.0	0,11	4680	2080	1350	600
PLT254-6- ()	.340	8,63	.030 .025	0,77 0,63	+0,098 +0,010	+2,49 +0,25	.2060 .2030	5,232 5,157	1.5	0,16	6900	3060	2100	930
PLT254-8- ()	.409	10,38	.035 .030	0,89 0,76	+0,135 +0,047	+3,43 +1,19	.2685 .2655	6,819 6,744	2.5	0,28	11800	5240	3650	1620
PLT254-10- ()	.479	12,16	.045 .035	1,15 0,88	+0,146 +0,043	+3,71 +1,09	.3150 .3120	8,001 7,925	3.5	0,39	17000	7560	5200	2310
PLT254-12- ()	.548	13,91	.045 .035	1,15 0,88	+0,152 +0,049	+3,87 +1,24	.3780 .3750	9,601 9,525	4.0	0,45	24500	10890	7500	3330

Fairchild

CODE IDENT. NO.
5M902

U.S. PATENT NO. 3643544.

MONOGRAM

CODE IDENT. NO.
98524

APPROVED DATE
21 APRIL 1971

NOTICE: THIS DRAWING IS PART OF THE PROPRIETARY ARTICLE HEREIN DISCLOSED, OWNED BY MONOGRAM AEROSPACE FASTENERS, ANY PARTY BY ACCEPTING THIS DOCUMENT ASSUMES CUSTODY THEREOF AND AGREES:
 A. THE INFORMATION SET FORTH HEREIN IS GIVEN IN CONFIDENCE AND THIS DOCUMENT WILL NOT BE COPIED OR REPRODUCED IN WHOLE OR IN PART, NOR ITS CONTENTS REVEALED IN ANY MANNER TO ANY PERSON EXCEPT TO MEET THE PURPOSE FOR WHICH IT WAS DELIVERED.
 B. WITHOUT THE WRITTEN CONSENT OF MONOGRAM AEROSPACE FASTENERS, THIS DOCUMENT AND THE INFORMATION CONTAINED HEREIN UNDER NO CIRCUMSTANCES WILL BE USED IN THE MANUFACTURE OR REPRODUCTION OF THE ARTICLE DISCLOSED, AND DELIVERY OF THIS DOCUMENT SHALL NOT CONSTITUTE ANY RIGHT OR LICENSE TO DO SO.

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

STANDARD

PLT254

SHEET 1 OF 2



TABLE II

SECOND DASH NUMBER	GRIP RANGE \triangle \triangle				G GRIP (a)		L REF.									
	MIN.		MAX.				-5		-6		-8		-10		-12	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm		
-1	.031	0.79	.093	2.37	.093	2.37	.713	18.11	.850	21.59	.972	24.69	1.189	30.20		
-2	.094	2.38	.156	3.97	.156	3.96	.775	19.68	.912	23.16	.972	24.69	1.189	30.20		
-3	.157	3.98	.219	5.57	.219	5.56	.838	21.29	.975	24.76	1.035	26.29	1.252	31.80	1.324	33.63
-4	.220	5.58	.281	7.14	.281	7.14	.900	22.86	1.037	26.34	1.097	27.86	1.314	33.38	1.386	35.20
-5	.282	7.15	.344	8.74	.344	8.74	.963	24.46	1.100	27.94	1.160	29.46	1.377	34.98	1.449	36.80
-6	.345	8.75	.406	10.32	.406	10.31	1.025	26.04	1.162	29.51	1.222	31.04	1.439	36.55	1.511	38.38
-7	.407	10.33	.469	11.92	.469	11.91	1.088	27.64	1.225	31.12	1.285	32.64	1.502	38.15	1.574	39.98
-8	.470	11.93	.531	13.49	.531	13.49	1.150	29.21	1.287	32.69	1.347	34.21	1.564	39.73	1.636	41.55
-9	.532	13.50	.594	15.09	.594	15.09	1.213	30.81	1.350	34.29	1.410	34.81	1.627	41.33	1.699	43.15
-10	.595	15.10	.656	16.67	.656	16.66	1.275	32.38	1.412	35.86	1.472	37.39	1.689	42.90	1.761	44.73
-11	.657	16.68	.719	18.27	.719	18.26	1.338	33.99	1.475	37.46	1.535	38.99	1.752	44.50	1.824	46.33
-12	.720	18.28	.781	19.84	.781	19.84	1.400	35.56	1.537	39.04	1.597	40.56	1.814	46.06	1.886	47.90
-13	.782	19.85	.844	21.44	.844	21.44	1.463	37.16	1.600	40.64	1.660	42.16	1.877	47.68	1.949	49.50
-14	.845	21.45	.906	23.02	.906	23.01	1.525	38.74	1.662	42.21	1.722	43.74	1.939	49.25	2.011	51.08
-15	.907	23.03	.969	24.62	.969	24.61	1.588	40.34	1.725	43.82	1.785	45.34	2.002	50.85	2.074	52.68
-16	.970	24.63	1.031	26.19	1.031	26.19	1.650	41.91	1.787	45.39	1.847	46.91	2.064	52.43	2.136	54.25
-17	1.032	26.20	1.094	27.79	1.094	27.79			1.850	46.99	1.910	48.51	2.127	54.03	2.199	55.85
-18	1.095	27.80	1.156	29.37	1.156	29.36			1.912	48.56	1.972	50.09	2.189	55.60	2.261	57.43
-19	1.157	29.38	1.219	30.97	1.219	30.96			1.975	50.16	2.035	51.69	2.252	57.20	2.324	59.03
-20	1.220	30.98	1.281	32.54	1.281	32.54			2.037	51.74	2.097	53.26	2.314	58.78	2.386	60.60
-21	1.282	32.55	1.344	34.14	1.344	34.14			2.100	53.34	2.160	54.86	2.377	60.38	2.449	62.20
-22	1.345	34.15	1.406	35.72	1.406	35.71			2.162	54.91	2.222	56.44	2.439	61.95	2.511	63.78
-23	1.407	35.73	1.469	37.32	1.469	37.31			2.225	56.52	2.285	58.04	2.502	63.55	2.574	65.38
-24	1.470	37.33	1.531	38.89	1.531	38.89			2.287	58.09	2.347	59.61	2.564	65.13	2.636	66.95
-25	1.532	38.90	1.594	40.49	1.594	40.49			2.350	59.69	2.410	61.21	2.627	66.73	2.699	68.55
-26	1.595	40.50	1.656	42.07	1.656	42.06			2.412	61.26	2.472	62.79	2.689	68.30	2.761	70.13
-27	1.657	42.08	1.719	43.67	1.719	43.66			2.475	62.86	2.535	64.39	2.752	69.90	2.824	71.73
-28	1.720	43.68	1.781	45.24	1.781	45.24			2.537	64.44	2.597	65.96	2.814	71.48	2.886	73.30
-29	1.782	45.25	1.844	46.84	1.844	46.84			2.600	66.04	2.660	67.56	2.877	73.08	2.949	74.90
-30	1.845	46.85	1.906	48.42	1.906	48.41			2.662	67.61	2.722	69.14	2.939	74.65	3.011	76.47
-31	1.907	48.43	1.969	50.02	1.969	50.01			2.725	69.22	2.785	70.74	3.002	76.25	3.074	78.08
-32	1.970	50.03	2.031	51.59	2.031	51.59			2.787	70.79	2.847	72.31	3.064	77.83	3.136	79.65

(a) "G" TOLERANCES: FOR -5 & -6 SIZES $+0.030$ ($+0.762$); FOR -8 & -10 SIZES $+0.040$ ($+1.016$); FOR -12 SIZES $+0.050$ ($+1.270$)
 $-.010$ (-0.254); $-.010$ (-0.254); $-.010$ (-0.254)

PROCUREMENT SPECIFICATION: ESCBB-10.

MATERIAL: NUT, SCREW: 5% CHROME STEEL (H-11) PER AMS 6497.
 SLEEVE: UNS N07750 PER AMS 5667 OR AMS 5582, OR A-286 WITH CHEMISTRY PER AMS 5731 OR AMS 5734.

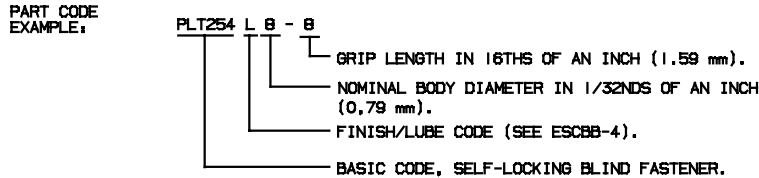
HEAT TREAT: NUT & SCREW: ROCKWELL "C" 48-53.
 SLEEVE: AS REQUIRED FOR PERFORMANCE.

FINISH: (-) NUT & SCREW: CADMIUM PLATE PER NAS672 (.0003 MIN THICKNESS) EXCEPT THERMAL INDICATOR MAY BE OMITTED.
 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.

LUBRICATION: LUBRICANTS LISTED BELOW MAY BE APPLIED TO ANY OR ALL COMPONENTS IF REQUIRED FOR PERFORMANCE: DRY FILM LUBE MoS₂ PER MIL-L-48010 (TYPE I OR TYPE III) OR EVERLUBE 812, PARAFFIN WAX, CETYL ALCOHOL PER MIL-L-87132, AND/OR W/M CARBO-WAX.



GENERAL NOTES:

- DIMENSIONS ARE EXCLUSIVE OF LUBRICATION. SI UNIT VALUES ARE REFERENCE CONVERSION VALUES ROUNDED TO ENCOMPASS THE LIMITING ENGLISH UNIT VALUES LISTED.
- FASTENERS SHALL BE FREE OF ALL LOOSE OR HANGING BURRS.
- 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).
- STANDARD FINISHES AND LUBRICANTS ARE SHOWN. SEE ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.
- 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.
- HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS EXAMPLE: PLT254-6-4.5 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 NOMINAL "G" DIMENSION WILL BE NOMINAL GRIP $+0.031$ ($+0.79$ mm) AND THE OVERALL SCREW LENGTH "L" DIMENSION MAY VARY AT THE MANUFACTURER'S OPTION
- 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)
- 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.

Fairchild
 CODE IDENT. NO.
5M902

U.S. PATENT NO. 3643544.

MONOGRAM
 CODE IDENT. NO.
98524

APPROVED DATE
 21 APRIL 1971

NOTICE: THIS DRAWING IS PART OF THE PROPRIETARY ARTICLE HEREIN DISCLOSED. OWNED BY MONOGRAM AEROSPACE FASTENERS, ANY PARTY BY ACCEPTING THIS DOCUMENT ASSUMES CUSTODY THEREOF AND AGREES A. THE INFORMATION SET FORTH HEREIN IS GIVEN IN CONFIDENCE AND THIS DOCUMENT WILL NOT BE COPIED OR REPRODUCED IN WHOLE OR IN PART, NOR ITS CONTENTS REVEALED IN ANY MANNER TO ANY PERSON EXCEPT TO MEET THE PURPOSE FOR WHICH IT WAS DELIVERED. B. WITHOUT THE WRITTEN CONSENT OF MONOGRAM AEROSPACE FASTENERS, THIS DOCUMENT AND THE INFORMATION CONTAINED HEREIN UNDER NO CIRCUMSTANCES WILL BE USED IN THE MANUFACTURE OR REPRODUCTION OF THE ARTICLE DISCLOSED, AND DELIVERY OF THIS DOCUMENT SHALL NOT CONSTITUTE ANY RIGHT OR LICENSE TO DO SO.

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

STANDARD
 PLT254
 SHEET 2 OF 2

REV. LETTER AND DATE
 ECN #1021
 "U" 03-27-01