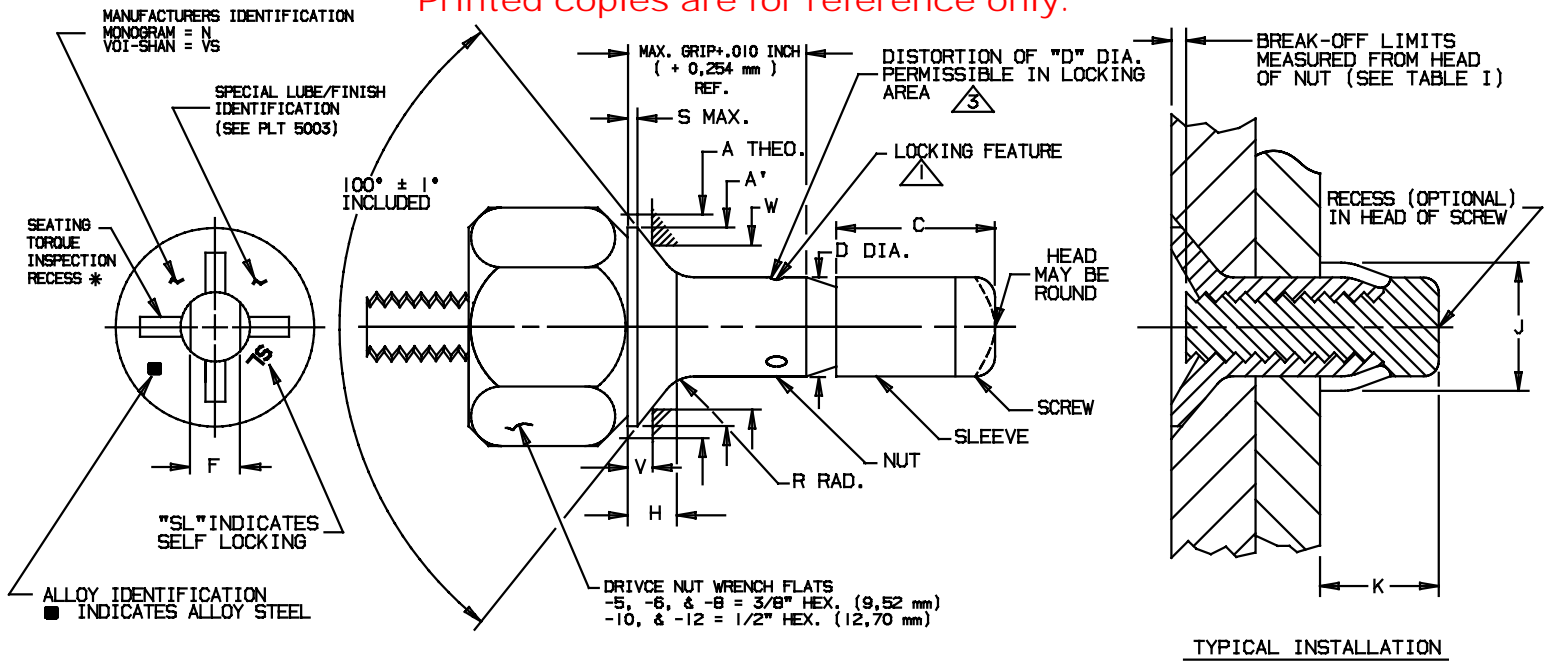


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TYPICAL INSTALLATION

HEAD MARKING DEPRESSED .010 INCH (0,254 mm MAX.) (POSITION OPTIONAL)
 * DRIVE-NUT NOT SHOWN FOR CLARITY OF HEAD MARKINGS.

TABLE I

PART NUMBER	NOM. DIA.		A DIA. THEO.		A' DIA. MIN.		C MAX.		D DIA.		F FLATS		H REF.		J DIA. MAX.		K REF.		R RAD.			
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm		
PLT 5110-5-()	.1635	4,153	.332 .325	8,43 8,25	.296	7,52	.268	6,81	.1645 .1625	4,178 4,128	.086 .081	2,18 2,06	.069	1,75	.244	6,20	.246	6,25			.030 .010	0,76 0,25
PLT 5110-6-()	.1980	5,029	.385 .378	9,78 9,60	.342	8,69	.303	7,70	.1990 .1970	5,055 5,004	.104 .099	2,64 2,52	.077	1,96	.300	7,62	.281	7,14			.030 .015	0,76 0,38
PLT 5110-8-()	.2590	6,579	.507 .499	12,88 12,67	.463	11,76	.354	8,99	.2600 .2580	6,604 6,553	.135 .130	3,43 3,30	.102	2,59	.384	9,75	.325	8,25			.030 .015	0,76 0,38
PLT 5110-10-()	.3105	7,887	.635 .626	16,13 15,95	.577	14,66	.423	10,74	.3115 .3095	7,912 7,861	.152 .147	3,86 3,73	.134	3,40	.427	10,85	.390	9,91			.040 .020	1,02 0,51
PLT 5110-12-()	.3735	9,487	.762 .752	19,35 19,10	.696	17,68	.510	12,95	.3745 .3725	9,512 9,462	.185 .180	4,70 4,57	.160	4,06	.516	13,11	.470	11,94			.040 .020	1,02 0,51

TABLE I (CONT.)

PART NUMBER	S MAX.		V GAGE PROT.		W GAGE DIA.		BREAK-OFF LIMITS		MINIMUM AVAILABLE GRIP LENGTH (TABLE II)	HOLE SIZE		PREVAILING TORQUE MIN.		DOUBLE SHEAR STRENGTH MIN.		TENSILE STRENGTH MIN.	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm		INCH	mm	IN-LB	Nm	LBS.	N	LBS.	N
PLT 5110-5-()	.012	0,30	.0276 .0238	0,701 0,604	.2671 .2667	6,784 6,774	+.020 -.068	+0,51 -1,73	-2	.168 .165	4,27 4,19	1.0	0,113	3355	14900	900	4000
PLT 5110-6-()	.015	0,38	.0299 .0259	0,759 0,658	.3147 .3143	7,993 7,983	+.015 -.073	+0,38 -1,85	-2	.202 .199	5,13 5,05	1.5	0,170	5240	23300	1400	6230
PLT 5110-8-()	.015	0,38	.0353 .0307	0,897 0,780	.4245 .4241	10,782 10,772	+.010 -.078	+0,25 -1,98	-3	.263 .260	6,68 6,60	2.5	0,282	9000	40000	2100	9340
PLT 5110-10-()	.020	0,51	.0409 .0357	1,039 0,907	.5389 .5385	13,688 13,678	+.010 -.083	+0,25 -2,11	-3	.315 .312	8,00 7,92	3.5	0,400	12000	53400	3600	16010
PLT 5110-12-()	.023	0,58	.0466 .0407	1,184 1,034	.6532 .6528	16,591 16,581	+.010 -.093	+0,25 -2,36	-4	.378 .375	9,60 9,52	4.0	0,452	19500	86700	5600	24910

VOI-SHAN

CODE IDENT. NO.
5M902

U.S. PATENT NO. 3643544, 4747202, AND 4967463
 EUROPEAN PATENT NO. 0152531 AND 0216980

MONOGRAM

CODE IDENT. NO.
98524

APPROVED DATE

11-27-85 ECN 4345

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TITLE

**VISU-LOK® II FASTENER, BLIND
 100° FLUSH TENSION HEAD NOMINAL DIAMETER
 ALLOY STEEL**

STANDARD

PLT 5110

SHEET 1 OF 2

REV. LETTER AND DATE

ECN #3347

"J" 08-18-05



APPLICABLE SPECIFICATIONS:

PROCUREMENT SPECIFICATION = PLT 5000 CLASS I, TYPE I
 PART NUMBER ASSIGNMENT = PLT 5001
 INSTALLATION AND REMOVAL = PLT 5002
 SPECIAL LUBE AND FINISH = PLT 5003

MATERIAL: NUT & SCREW: ALLOY STEEL; 4130 PER MIL-S-6758, 4140 PER MIL-S-5626 OR 8740 PER MIL-S-6049
 SLEEVE: CORROSION RESISTANT STEEL; 303 PER AMS 5639 OR 304 PER 5641
 DRIVE NUT: MILD STEEL

HEAT TREAT: NUT & SCREW: HEAT TREAT PER MIL-H-6875 TO RC 39-43
 SLEEVE: AS REQUIRED FOR PERFORMANCE
 DRIVE NUT: AS REQUIRED FOR PERFORMANCE

FINISH: NUT & SCREW: CADMIUM PLATE PER QQ-P-416 TYPE II, CL. 2
 CADMIUM PLATE PER NAS 672 IS PERMISSIBLE PROVIDED IT IS FOLLOWED BY A DICHROMATE POST TREATMENT PER QQ-P-416

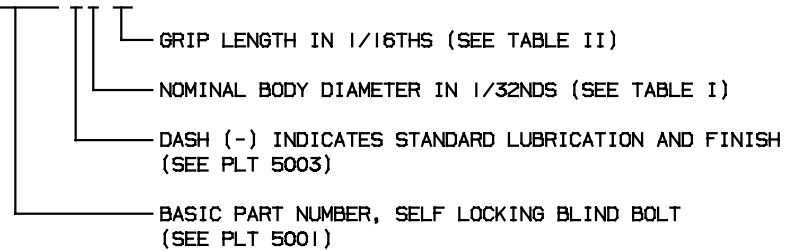
SLEEVE: PASSIVATED PER MIL-S-5002 AND CADMIUM PLATED PER QQ-P-416 TYPE I CLASS 3.

DRIVE NUT: CORROSION RESISTANT COATING, COLOR GOLD.

LUBRICATION: SOLID DRY FILM LUBRICANT PER THE CHEMICAL REQUIREMENTS OF MIL-L-46010 TYPE I, OR EVERLUBE 812 PER MIL-L-81329, PARAFFIN WAX OR CETYL ALCOHOL PER MIL-L-87132 MAY BE APPLIED TO ANY OR ALL COMPONENTS AS REQUIRED FOR PERFORMANCE, (SEE PLT 5003 FOR SPECIAL LUBRICANTS AND FINISHES)

PART CODE & EXAMPLE:

PLT 5110 -8 -4



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: PLT 5110-6-4.5 HAS A NOMINAL GRIP LENGTH OF 4-1/2 16THS (.281" = 7.14 mm) AND A GRIP RANGE OF .250" THRU .312" (6.35 mm THRU 7.92 mm)
- ③ 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 MAX. "D" + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS (22.23 NEWTONS)
- ④ SECOND DASH NUMBER (GRIP RANGE) -17 THROUGH -32 NOT AVAILABLE IN -5 DIAMETER
- 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 TORQUES SHOWN IN TABLE I DO NOT APPLY.

TABLE II

2ND DASH NO. ④	GRIP RANGE ②			
	MIN. GRIP		MAX. GRIP	
	INCH	mm	INCH	mm
-2	.094	2,39	.156	3,96
-3	.157	3,99	.219	5,56
-4	.220	5,59	.281	7,14
-5	.282	7,16	.344	8,74
-6	.345	8,76	.406	10,31
-7	.407	10,34	.469	11,91
-8	.470	11,94	.531	13,49
-9	.532	13,51	.594	15,09
-10	.595	15,11	.656	16,66
-11	.657	16,69	.719	18,26
-12	.720	18,29	.781	19,84
-13	.782	19,86	.844	21,44
-14	.845	21,46	.906	23,01
-15	.907	23,04	.969	24,61
-16	.970	24,64	1,031	26,19
-17	1,032	26,21	1,094	27,79
-18	1,095	27,81	1,156	29,36
-19	1,157	29,38	1,219	30,97
-20	1,220	30,98	1,281	32,54
-21	1,282	32,55	1,344	34,14
-22	1,345	34,15	1,406	35,72
-23	1,407	35,73	1,469	37,32
-24	1,470	37,33	1,531	38,89
-25	1,532	38,90	1,594	40,49
-26	1,595	40,50	1,656	42,07
-27	1,657	42,08	1,719	43,67
-28	1,720	43,68	1,781	45,24
-29	1,782	45,25	1,844	46,84
-30	1,845	46,85	1,906	48,42
-31	1,907	48,43	1,969	50,02
-32	1,970	50,03	2,031	51,59

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