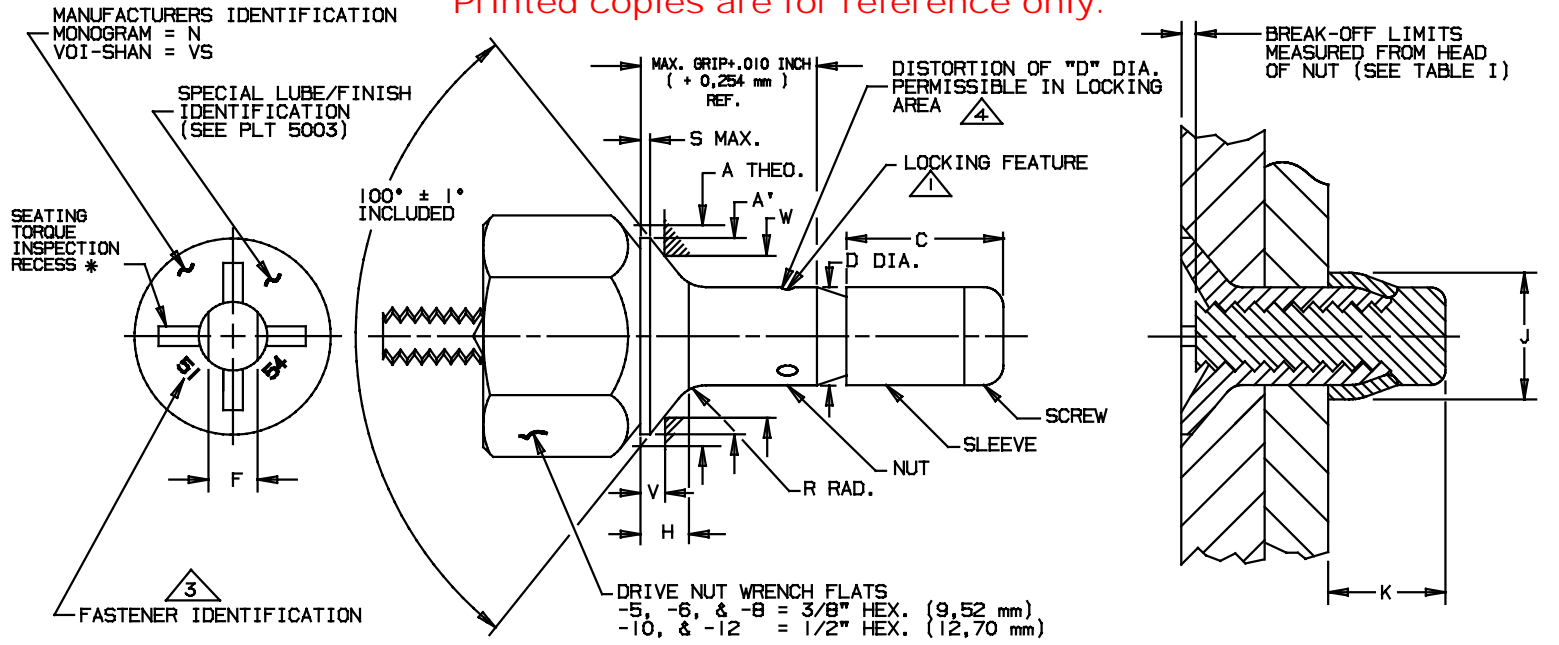


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HEAD MARKINGS DEPRESSED .010 INCH ( 0,254 mm MAX.) (POSITION OPTIONAL)  
 \* DRIVE-NUT NOT SHOWN FOR CLARITY OF HEAD MARKINGS.

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 5154-5-()	.1640	4,166	.332 .325	8,43 8,25	.296	7,52	.285	7,24	.1645 .1635	4,18 4,15	.086 .081	2,18 2,06	.069	1,75	.244	6,20	.257	6,53	.040 .035	1,02 0,89
PLT 5154-6-()	.2021	5,134	.385 .378	9,78 9,60	.342	8,69	.320	8,13	.2026 .2016	5,15 5,12	.104 .099	2,64 2,52	.077	1,96	.300	7,62	.288	7,32	.050 .045	1,27 1,14
PLT 5154-8-()	.2645	6,719	.507 .499	12,88 12,67	.463	11,76	.355	9,02	.2651 .2641	6,73 6,71	.135 .130	3,43 3,30	.102	2,59	.384	9,75	.320	8,13	.060 .055	1,52 1,40
PLT 5154-10-()	.3115	7,913	.635 .626	16,31 15,90	.577	14,66	.440	11,77	.3120 .3110	7,93 7,90	.152 .147	3,86 3,73	.134	3,40	.427	10,85	.396	10,06	.070 .060	1,78 1,52
PLT 5154-12-()	.3740	9,500	.762 .752	19,35 19,10	.696	17,68	.525	13,34	.3745 .3735	9,51 9,49	.185 .180	4,70 4,57	.160	4,06	.516	13,11	.473	12,02	.070 .060	1,78 1,52

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 5154-5-()	.012	0,31	.0276 .0239	0,701 0,607	.2671 .2669	6,784 6,779	+.020 -.068	+0,51 -1,73	-2	.1680 .1650	4,27 4,19	1.0	0,113	4680	20820	1350	6000
PLT 5154-6-()	.015	0,38	.0250 .0190	0,635 0,483	.3272 .3270	8,311 8,306	+.015 -.073	+0,38 -1,85	-2	.2060 .2030	5,23 5,16	1.5	0,170	6900	30700	2100	9340
PLT 5154-8-()	.015	0,38	.0327 .0263	0,831 0,668	.4320 .4318	10,973 10,968	+.010 -.078	+0,25 -1,98	-3	.2685 .2655	6,82 6,74	2.5	0,282	11800	52500	3650	16240
PLT 5154-10-()	.020	0,51	.0390 .0320	0,991 0,813	.5451 .5449	13,846 13,840	+.010 -.083	+0,25 -2,11	-4	.3150 .3120	8,00 7,92	3.5	0,400	17000	75620	5200	23130
PLT 5154-12-()	.023	0,58	.0452 .0378	1,148 0,960	.6582 .6580	16,718 16,713	+.010 -.093	+0,25 -2,36	-4	.3780 .3750	9,60 9,52	4.0	0,452	24500	109000	7500	33360

**Fairchild**  
 CODE IDENT. NO.  
**5M902**

U.S. PATENT NO. 3643544 & 4747202  
 EUROPEAN PATENT NO. 0216980

**MONOGRAM**  
 CODE IDENT. NO.  
**98524**

APPROVED DATE  
 4-10-86 ECN 4088

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

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TITLE  
**VISU-LOK® II FASTENER, BLIND  
 100° FLUSH TENSION HEAD  
 NOMINAL DIAMETER GROUND SHANK  
 5% CHROME STEEL ALLOY (H-11)**

**STANDARD**  
**PLT 5154**  
**SHEET 1 OF 2**

APPLICABLE SPECIFICATIONS:

PROCUREMENT SPECIFICATION = PLT 5000, CLASS 4, TYPE I  
 PART NUMBER ASSIGNMENT = PLT 5001  
 INSTALLATION AND REMOVAL = PLT 5002  
 SPECIAL LUBE AND FINISH = PLT 5003

MATERIAL: NUT & SCREW: 5% CHROME STEEL (H-11) PER AMS 6487  
 SLEEVE: A-286 PER AMS 5731, AMS 5732 OR AMS 5737,  
 OR INCONEL X-750 PER AMS 5667 OR AMS 5582  
 DRIVE NUT: MILD STEEL

HEAT TREAT: NUT & SCREW: HEAT TREAT TO RC 48-53  
 SLEEVE: AS REQUIRED FOR PERFORMANCE  
 DRIVE NUT: AS REQUIRED FOR PERFORMANCE

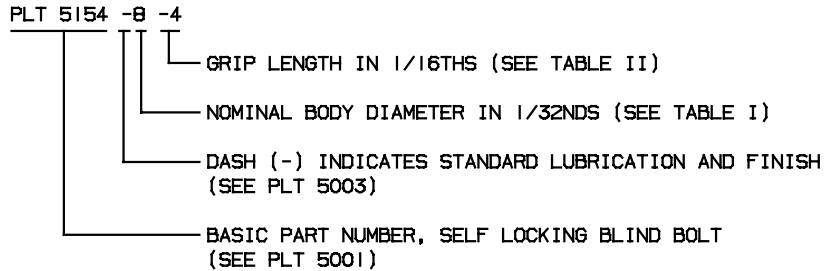
FINISH: NUT & SCREW: CADMIUM PLATED PER NAS 672, .0003" MINIMUM THICKNESS  
 (EXCEPT THERMAL INDICATOR MAY BE OMITTED) FOLLOWED BY A  
 DICHROMATE POST TREATMENT PER QQ-P-416, NUT COLOR RED

SLEEVE: PASSIVATE PER MIL-S-5002. CADMIUM PLATED PER QQ-P-416,  
 TYPE I OR TYPE II, CLASS 2 OR CLASS 3.

DRIVE NUT: CORROSION RESISTANT COATING. COLOR RED

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:



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 5154-6-4.5 HAS A NOMINAL GRIP LENGTH OF 4-1/2 16THS  
 (.281" = 7.14mm) AND A GRIP RANGE OF .250" THRU .312"  
 (6.35mm THRU 7.92mm)
- 3 ALTERNATE HEAD MARKING: "N" (OR VS), "154"
- 4 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)
- 5 GROUND SHANK VISU-LOK II BLIND FASTENERS SHOULD NOT BE USED EXCEPT WITH CONSIDERABLE CAUTION IN APPLICATIONS WHICH EXCEED APPROXIMATELY .0005 INTERFERENCE FIT. GROUND SHANK VISU-LOK II BLIND FASTENERS WILL PERFORM SATISFACTORILY WHEN INSTALLED IN THE TABULATED HOLE SIZES
- 6 SECOND DASH NUMBER (GRIP RANGE) -17 THROUGH -32 NOT AVAILABLE IN -5 DIAMETER

TABLE II

2ND DASH NO. 5	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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**STANDARD**

PLT 5154  
 SHEET 2 OF 2