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TABLE I

TYPICAL INSTALLATION

PART NUMBER	NOM. DIA.	A	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 210-5-(*)	.1635	.250 .244	.268	.1645 .1625	.086 .081	.096	.244	.246	.272	.020 .010	.168 .165	+0.088 +0.000	1.0	3355	900
PLT 210-6-(*)	.1980	.312 .305	.303	.1990 .1970	.104 .099	.113	.300	.281	.340	.025 .015	.202 .199	+0.098 +0.010	1.5	5240	1400
PLT 210-8-(*)	.2590	.375 .367	.354	.2600 .2580	.135 .130	.135	.384	.325	.409	.025 .015	.263 .260	+1.135 +0.047	2.5	9000	2100
PLT 210-10-(*)	.3105	.437 .429	.423	.3115 .3095	.152 .147	.160	.427	.390	.479	.030 .015	.315 .312	+1.146 +0.043	3.5	12000	3600
PLT 210-12-(*)	.3735	.500 .491	.510	.3745 .3725	.185 .180	.190	.516	.470	.548	.030 .015	.378 .375	+1.152 +0.049	4.0	19500	5600

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

TABLE II

SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF.					SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF.				
		MIN.	MAX.	PLT 210							MIN.	MAX.	PLT 210				
				-5-(*)	-6-(*)	-8-(*)	-10-(*)	-12-(*)					-5-(*)	-6-(*)	-8-(*)	-10-(*)	-12-(*)
-1	.093	.031	.093	.733	.874	-	-	-	-17	1.094	1.032	1.094	NOT AVAILABLE IN -5 DIAMETER	1.874	1.944	2.096	2.179
-2	.156	.094	.156	.795	.936	1.006	1.158	-	-18	1.156	1.095	1.156		1.936	2.006	2.158	2.242
-3	.219	.157	.219	.858	.999	1.069	1.221	1.304	-19	1.219	1.157	1.219		1.999	2.069	2.221	2.304
-4	.281	.220	.281	.920	1.061	1.131	1.283	1.367	-20	1.281	1.220	1.281		2.061	2.131	2.283	2.367
-5	.344	.282	.344	.983	1.124	1.194	1.346	1.429	-21	1.344	1.282	1.344		2.124	2.194	2.346	2.429
-6	.406	.345	.406	1.045	1.186	1.256	1.408	1.492	-22	1.406	1.345	1.406		2.186	2.256	2.408	2.492
-7	.469	.407	.469	1.108	1.249	1.319	1.471	1.554	-23	1.469	1.407	1.469		2.249	2.319	2.471	2.554
-8	.531	.470	.531	1.170	1.311	1.381	1.533	1.617	-24	1.531	1.470	1.531		2.311	2.381	2.533	2.617
-9	.594	.532	.594	1.233	1.374	1.444	1.596	1.679	-25	1.594	1.532	1.594		2.374	2.444	2.596	2.679
-10	.656	.595	.656	1.295	1.436	1.506	1.658	1.742	-26	1.656	1.595	1.656		2.436	2.506	2.658	2.742
-11	.719	.657	.719	1.358	1.499	1.569	1.721	1.804	-27	1.719	1.657	1.719		2.499	2.569	2.721	2.804
-12	.781	.720	.781	1.420	1.561	1.631	1.783	1.867	-28	1.781	1.720	1.781		2.561	2.631	2.783	2.867
-13	.844	.782	.844	1.483	1.624	1.694	1.846	1.929	-29	1.844	1.782	1.844		2.624	2.694	2.846	2.929
-14	.906	.845	.906	1.545	1.686	1.756	1.908	1.992	-30	1.906	1.845	1.906		2.686	2.756	2.908	2.992
-15	.969	.907	.969	1.608	1.749	1.819	1.971	2.054	-31	1.969	1.907	1.969		2.749	2.819	2.971	3.054
-16	1.031	.970	1.031	1.670	1.811	1.881	2.033	2.117	-32	2.031	1.970	2.031		2.811	2.881	3.033	3.117

Fairchild
 CODE IDENT. NO.
92215

▲ "G" TOLERANCES: FOR -5 & -6 SIZES +.030/-0.010; FOR -8 & -10 SIZES +.040/-0.010; FOR -12 SIZE +.050/-0.010.

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

MONOGRAM
 CODE IDENT. NO.
98524

APPROVED DATE
 13 NOVEMBER 1970

REV. LETTER AND DATE
 (H) 04-01-84

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TITLE
VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE ALLOY STEEL PROTRUDING HEX HEAD, SELF LOCKING

STANDARD
PLT 210
SHEET 1 OF 2

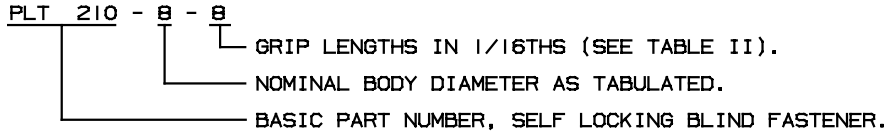
PROCUREMENT SPEC. : ESCBB2 CLASS 1.

MATERIAL : NUT & SCREW : ALLOY STEEL: 4130 PER MIL-S-6758, 4140 PER MIL-S-5626 OR B740 PER MIL-S-6049.
 SLEEVE : CORROSION RESISTANT STEEL: 303 OR 304 PER QQ-S-763, AMS 5639 OR AMS 5641.
 HEAT TREAT : NUT & SCREW : HEAT TREAT PER MIL-H-6875. APPROXIMATELY 180,000-200,000 PSI TENSILE (Rc 39-43).
 SLEEVE : AS REQUIRED FOR PERFORMANCE.

△ FINISH : NUT & SCREW : CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2. CADMIUM PLATE PER NAS 672 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 TYPE I 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 PREVAILING TORQUE SHALL CONFORM TO THE VALUES AS TABULATED, WHEN TESTED IN ACCORDANCE WITH SPECIFICATION ESCBB-2. HOWEVER, PREVAILING TORQUES FOR THE PLT210-5-1 AND PLT210-6-1 SHALL BE RECORDED THRU A ROTATION OF ONLY 360° OF THE NUT.
- △ 5.) MANUFACTURER'S IDENTIFICATION: (REFER TO NOTE 7 FOR INTERIM IDENTIFICATION) LETTER "N" DESIGNATES MONOGRAM AEROSPACE FASTENERS. LETTERS "VS" DESIGNATE VOI-SHAN.
- 6.) HEAD MARKINGS ON NUT DEPRESSED .010 MAX.
- △ 7.) THE PRODUCT DESCRIBED BY THIS DRAWING IS "EQUIVALENT TO" AND "INTERCHANGEABLE WITH" THE MANUFACTURER'S PRODUCT LISTED BELOW EXCEPT FOR THE HEAD IDENTIFICATION MARKING. WHEN THESE EQUIVALENT FASTENERS ARE SUPPLIED, THE HEAD IDENTIFICATION MAY BE AS SHOWN BELOW:
 MONOGRAM... : PL164-PL375 SERIES (MARKING: "□" AND "N" OVERSTAMPED "L" OR "SL").
 VOI-SHAN... : VA 401 SERIES (MARKING: "VS", "□", "E" AND "SL").
- △ 8.) STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.
- △ 9.) HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.
 EXAMPLE: PLT 210-6-4.5 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.
- △ 10.) 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.
- △ 11.) 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.
12. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.

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

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SHEET 2 OF 2

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