



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
PLT210-05-()	.1635	.250 .244	.268	.1645 .1625	.086 .081	.096	.244	.246	.272	.020 .010	.168 .165	+088 +000	1.0	3355	900
PLT210-06-()	.1980	.312 .305	.303	.1990 .1970	.104 .099	.113	.300	.281	.340	.025 .015	.202 .199	+098 +010	1.5	5240	1400
PLT210-08-()	.2590	.375 .367	.354	.2600 .2580	.135 .130	.135	.384	.325	.409	.025 .015	.263 .260	+135 +047	2.5	9000	2100
PLT210-10-()	.3105	.437 .429	.423	.3115 .3095	.152 .147	.160	.427	.390	.479	.030 .015	.315 .312	+146 +043	3.5	12000	3600
PLT210-12-()	.3735	.500 .491	.510	.3745 .3725	.185 .180	.190	.516	.470	.548	.030 .015	.378 .375	+152 +049	4.0	19500	5600

SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF.				
		MIN	MAX	PLT210				
				-05-()	-06-()	-08-()	-10-()	-12-()
-01	.093	.031	.093	.733	.874	-	-	-
-02	.156	.094	.156	.795	.936	1.006	1.158	-
-03	.219	.157	.219	.858	.999	1.069	1.221	1.304
-04	.281	.220	.281	.920	1.061	1.131	1.283	1.367
-05	.344	.282	.344	.983	1.124	1.194	1.346	1.429
-06	.406	.345	.406	1.045	1.186	1.256	1.408	1.492
-07	.469	.407	.469	1.108	1.249	1.319	1.471	1.554
-08	.531	.470	.531	1.170	1.311	1.381	1.533	1.617
-09	.594	.532	.594	1.233	1.374	1.444	1.596	1.679
-10	.656	.595	.656	1.295	1.436	1.506	1.658	1.742
-11	.719	.657	.719	1.358	1.499	1.569	1.721	1.804
-12	.781	.720	.781	1.420	1.561	1.631	1.783	1.867
-13	.844	.782	.844	1.483	1.624	1.694	1.846	1.929
-14	.906	.845	.906	1.545	1.686	1.756	1.908	1.992
-15	.969	.907	.969	1.608	1.749	1.819	1.971	2.054
-16	1.031	.970	1.031	1.670	1.811	1.881	2.033	2.117

SECOND DASH NUMBER	G GRIP	GRIP RANGE		L REF.				
		MIN	MAX	PLT210				
				-05-()	-06-()	-08-()	-10-()	-12-()
-17	1.094	1.032	1.094	1.874	1.944	2.096	2.179	
-18	1.156	1.095	1.156	1.936	2.006	2.158	2.242	
-19	1.219	1.157	1.219	1.999	2.069	2.221	2.304	
-20	1.281	1.220	1.281	2.061	2.131	2.283	2.367	
-21	1.344	1.282	1.344	2.124	2.194	2.346	2.429	
-22	1.406	1.345	1.406	2.186	2.256	2.408	2.492	
-23	1.469	1.407	1.469	2.249	2.319	2.471	2.554	
-24	1.531	1.470	1.531	2.311	2.381	2.533	2.617	
-25	1.594	1.532	1.594	2.374	2.444	2.596	2.679	
-26	1.656	1.595	1.656	2.436	2.506	2.658	2.742	
-27	1.719	1.657	1.719	2.499	2.569	2.721	2.804	
-28	1.781	1.720	1.781	2.561	2.631	2.783	2.867	
-29	1.844	1.782	1.844	2.624	2.694	2.846	2.929	
-30	1.906	1.845	1.906	2.686	2.756	2.908	2.992	
-31	1.969	1.907	1.969	2.749	2.819	2.971	3.054	
-32	2.031	1.970	2.031	2.811	2.881	3.033	3.117	

"G" TOLERANCE: FOR -05 AND -06 SIZES +.030/-010; FOR -08 & -10 SIZES +.040/-010; FOR -12 SIZES +.050/- .010.

a TriMas company
3423 SOUTH GARFIELD AVENUE
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(323) 722-4760 FAX (323) 727-1029

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

DRAWING NO:
PLT210-()-()

DRAWN BY: M. DOMINGUEZ
DRAWN DATE: 06-20-13

APPROVED BY: _____
CHECKED DATE: _____

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Alcoa CAGE CODE: 5M902

MONOGRAM CAGE CODE: 98524

ECN NO: 15-0309
ECN DATE: 10/15/15

REV: L

SHEET 1 OF 2



PROCUREMENT SPEC: ESCBB-2 CLASS I.

MATERIAL: NUT & SCREW: ALLOY STEEL: 4130 PER AMS-S-6758, 4140 PER AMS6382 OR AMS6349 OR 8740 PER AMS6322.
 SLEEVE: CORROSION RESISTANT STEEL: 303 OR 304 PER AMS-QQ-S-763, AMS5639 OR AMS5641

HEAT TREAT: NUT & SCREW: HEAT TREAT PER AMS2759. APPROXIMATELY 180,000-200,000 PSI TENSILE (HRC 39-43).
 SLEEVE: AS REQUIRED FOR PERFORMANCE.

FINISH: NUT & SCREW: CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2. CADMIUM PLATE PER NAS672 IS PERMISSIBLE PROVIDED IT IS FOLLOWED BY A DICHROMATE POST TREATMENT PER AMS-QQ-P-416.
 SLEEVE: PASSIVATE PER AMS2700. CADMIUM PLATE PER AMS-QQ-P-416, TYPE I, CLASS 3.

LUBRICANT: LUBRICANTS LISTED BELOW MAY BE APPLIED TO ANY OR ALL COMPONENTS IF REQUIRED FOR PERFORMANCE.
 NUT: WWM CARBO-WAX, PARAFFIN WAX, AND/OR CETYL ALCOHOL PER AS87132.
 SCREW & SLEEVE: DRY FILM LUBE PER AS5272 TYPE I OR MIL-PRF-81329, WWM CARBO-WAX, PARAFFIN WAX, AND/OR CETYL ALCOHOL PER AS87132.

PART CODE & EXAMPLE: PLT210 - 05 - 05
 GRIP LENGTHS IN 1/16THS
 NOMINAL BODY DIAMETER AS TABULATED
 BASIC PART NUMBER, SELF LOCKING BLIND FASTENER

GENERAL NOTES:

1. OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT EXCEED 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 PLT210-05-01 AND PLT210-06-01 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 THE HEAD IDENTIFICATION MAY BE AS SHOWN BELOW:
 MONOGRAM...: PL164-PL375 SERIES (MARKING: "□" AND "N" OVERSTAMPED "L" OR "SL").
 VOI-SHAN...: VA401 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: PLT210-06-4.5 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 AS TABULATED, 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 AS TABULATED DO NOT APPLY.
12. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.

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TITLE:
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 INTERNALLY THREADED, EXTERNAL SLEEVE
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