



PART NUMBER	NOM. DIA.		A		C MAX.		D DIA.		E DIA. MAX.		F DRIVING FLATS		H MAX.		J DIA MAX.	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
PLT225-05-(-)	.1635	4,15	.250 .244	6,35 6,19	.268	6,81	.1645 .1625	4,18 4,12	.1620	4,12	.086 .081	2,19 2,05	.096	2,44	.244	6,20
PLT225-06-(-)	.1890	4,80	.312 .305	7,93 7,74	.303	7,70	.1900 .1880	4,83 4,77	.1875	4,77	.104 .099	2,65 2,51	.113	2,88	.300	7,62
PLT225-08-(-)	.2480	6,30	.375 .367	9,53 9,32	.354	9,00	.2490 .2470	6,33 6,27	.2465	6,27	.135 .130	3,43 3,30	.135	3,43	.384	9,75
PLT225-10-(-)	.3105	7,89	.437 .429	11,10 10,89	.423	10,75	.3115 .3095	7,92 7,86	.3090	7,85	.152 .147	3,87 3,73	.160	4,07	.427	10,85
PLT225-12-(-)	.3735	9,49	.500 .491	12,70 12,47	.510	12,96	.3745 .3725	9,52 9,46	.3720	9,45	.185 .180	4,70 4,57	.190	4,83	.516	13,11

PART NUMBER	K MAX.		N MIN.		R RAD.		HOLE SIZE		BREAK-OFF LIMITS		PREVAILING TORQUE MIN		DOUBLE SHEAR STRENGTH MIN		TENSILE STRENGTH MIN	
	INCH	mm	INCH	MM	INCH	mm	INCH	mm	INCH	mm	INCH-LBS	Nm	LBS	N	LBS	N
PLT225-05-(-)	.267	6,78	.272	6,90	.020 .010	0,51 0,25	.168 .165	4,27 4,19	+0,88 +0,00	+2,24 +0,00	1.0	0,11	3150	14012	900	4003
PLT225-06-(-)	.302	7,67	.340	8,63	.025 .015	0,64 0,38	.193 .190	4,90 4,82	+1,03 +0,15	+2,62 +0,38	1.5	0,16	4200	18683	1400	6228
PLT225-08-(-)	.346	8,79	.409	10,38	.025 .015	0,64 0,38	.252 .249	6,40 6,32	+1,30 +0,32	+3,31 +0,81	2.5	0,28	7200	32027	2100	7341
PLT225-10-(-)	.414	10,52	.479	12,16	.030 .015	0,77 0,38	.315 .312	8,00 7,92	+1,30 +0,27	+3,31 +0,68	3.5	0,39	11350	50487	3600	16014
PLT225-12-(-)	.470	11,94	.548	13,91	.030 .015	0,77 0,38	.378 .375	9,60 9,52	+1,30 +0,27	+3,31 +0,68	4.0	0,45	16450	73173	5600	24910

MONOGRAM AEROSPACE FASTENERS
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TITLE:
VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE HIGH TEMPERATURE (A-286 ALLOY) PROTRUDING HEX HEAD, SELF LOCKING FRACTIONAL DIAMETER

DRAWING NO:
PLT225(-)(-)(-)

DRAWN BY: G.MARTINEZ DRAWN DATE: 07-03-13

APPROVED BY: CHECKED DATE:

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14-0680
ECN DATE:
11/04/14

REV:
J
SHEET 1 OF 2



PROCUREMENT SPEC: ESCBB-2 CLASS II.

MATERIAL:

NUT, SCREW, & SLEEVE: CORROSION AND HEAT RESISTANT STEEL, TYPE A-286 PER AMS5731, AMS5732 OR AMS5737.

HEAT TREAT:

NUT & SCREW: SOLUTION HEAT TREATED AND AGED TO A CORE HARDNESS OF HRC 30 TO HRC 45. ALL CORE HARDNESS READINGS ARE TAKEN ON MOUNTED SPECIMEN, USING A BRALE PENETRATOR AND A 30 Kg LOAD (ROCKWELL 30N).

SLEEVE: SOLUTION TREATED.

FINISH: $\triangle 5$

NO CODE NUT, SCREW, & SLEEVE: PASSIVATE PER AMS2700

"A" CODE NUT, SCREW, & SLEEVE: PASSIVATE PER AMS2700. CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.

LUBRICANT: $\triangle 5$
LUBRICANTS LISTED BELOW MAY BE APPLIED TO ANY OR ALL COMPONENTS IF REQUIRED FOR PERFORMANCE.

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:
PLT225 A - 05 - 05

GRIP LENGTHS IN 1/16THS
NOMINAL BODY DIAMETER AS TABULATED
DESIGNATES SPECIAL FINISH CODE, SEE ESCBB-4
BASIC PART NUMBER, SELF LOCKING BLIND FASTENER

GENERAL NOTES:

- OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT BE GREATER THAN MAXIMUM "E" DIAMETER.
- FASTENERS SHALL BE FREE OF ALL LOOSE OR HANGING BURRS.
- $\triangle 3$ LOCKING FEATURE CONSISTS OF THREE (3) INDENTATIONS LOCATED 120° APART ON THE PERIPHERY OF THE NUT COMPONENT AND APPROXIMATELY .040" (1.02 mm) ABOVE THE INTERSECTION OF THE NUT NOSE ANGLE AND O.D. (MEAN GRIP OF FASTENER).
- HEAD MARKINGS ON NUT DEPRESSED .010" (0.26 mm) MAX.
- $\triangle 5$ STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.
- $\triangle 6$ 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).
- $\triangle 7$ HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.

EXAMPLE: PLT225-06-4.5 INDICATES A NOMINAL GRIP LENGTH OF 4.5 SIXTEENTHS (.281" = 7.14 mm). THE GRIP RANGE FOR THESE HALF-GRIP SIZES WILL BE NOMINAL GRIP +.031/-0.030 (+0.79/-0.76mm). THE BASIC "G" DIMENSION WILL BE NOMINAL GRIP +.031 (+0.79 mm) AND THE OVERALL SCREW LENGTH "L" DIMENSION MAY VARY AT THE MANUFACTURER'S OPTION.
- $\triangle 8$ 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.
- $\triangle 9$ THE PREVAILING TORQUE SHALL CONFORM TO THE VALUES AS TABULATED, WHEN TESTED IN ACCORDANCE WITH SPECIFICATION ESCBB-2. HOWEVER, PREVAILING TORQUES FOR THE PLT225-05-01 AND PLT225-06-01 SHALL BE RECORDED THRU A ROTATION OF ONLY 360° OF THE NUT.
- DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.
- $\triangle 11$ "G" TOLERANCES: FOR -05 & -06 SIZES +0.030/-0.010 (+0.77/-0.25 mm); FOR -08 & -10 SIZES +0.040/-0.10 (+1.02/-0.25 mm); FOR -12 SIZES +0.050/-0.10 (+1.27/-0.25 mm).

SECOND DASH NUMBER	$\triangle G$ GRIP		$\triangle \triangle$ GRIP RANGE						L REF.									
			MIN.		MAX.		-05-()		-06-()		-08-()		-10-()		-12-()			
	IN	mm	IN	mm	IN	mm	IN	mm	IN	mm	IN	mm	IN	mm	IN	mm		
-01	.093	2.39	.031	0.79	.093	2.36	.733	18.62	.874	22.20	-	-	-	-	-	-		
-02	.156	3.96	.094	2.39	.156	3.96	.795	20.19	.936	23.77	1.006	25.557	1.158	29.413	-	-		
-03	.219	5.56	.157	3.99	.219	5.56	.858	21.80	.999	25.37	1.069	27.153	1.221	31.013	1.367	34.722		
-04	.281	7.14	.220	5.59	.281	7.14	.920	23.37	1.061	26.949	1.131	28.727	1.283	32.588	1.429	36.230		
-05	.344	8.74	.282	7.16	.344	8.74	.983	24.97	1.124	28.550	1.194	30.328	1.346	34.188	1.492	36.897		
-06	.406	10.31	.345	8.76	.406	10.31	1.045	26.543	1.186	30.124	1.256	31.902	1.408	35.763	1.554	39.472		
-07	.469	11.91	.407	10.34	.469	11.91	1.108	28.143	1.249	31.725	1.319	33.503	1.471	37.363	1.617	41.072		
-08	.531	13.49	.470	11.94	.531	13.49	1.170	29.718	1.311	33.300	1.381	35.077	1.533	38.938	1.679	42.647		
-09	.594	15.11	.532	13.51	.594	15.11	1.233	31.318	1.374	34.900	1.444	36.678	1.596	40.538	1.742	44.247		
-10	.656	16.66	.595	15.11	.656	16.66	1.295	32.893	1.436	36.474	1.506	38.252	1.658	42.113	1.804	45.622		
-11	.719	18.26	.657	16.69	.719	18.26	1.358	34.493	1.499	38.075	1.569	39.853	1.721	43.713	1.867	47.422		
-12	.781	19.84	.720	18.29	.781	19.84	1.420	36.068	1.561	39.650	1.631	41.427	1.783	45.288	1.929	48.997		
-13	.844	21.44	.782	19.86	.844	21.44	1.483	37.668	1.624	41.250	1.694	43.028	1.846	46.888	1.992	50.597		
-14	.906	23.01	.845	21.46	.906	23.01	1.545	39.243	1.686	42.824	1.756	44.602	1.908	48.463	2.054	52.172		
-15	.969	24.61	.907	23.04	.969	24.61	1.608	40.843	1.749	44.425	1.819	46.203	1.971	50.063	2.117	53.772		
-16	1.031	26.19	.970	24.64	1.031	26.19	1.670	42.418	1.811	46.000	1.881	47.777	2.033	51.638	2.179	55.347		
-17	1.094	27.79	1.032	26.21	1.094	27.79				1.874	47.600	1.944	49.378	2.096	53.238	2.242	56.947	
-18	1.156	29.36	1.095	27.81	1.156	29.36				1.936	49.174	2.006	50.952	2.158	54.813	2.304	58.522	
-19	1.219	30.96	1.157	29.39	1.219	30.96				1.999	50.775	2.069	52.553	2.221	56.413	2.367	60.122	
-20	1.281	32.54	1.220	30.99	1.281	32.54				2.061	52.350	2.131	54.127	2.283	57.988	2.429	61.697	
-21	1.344	34.14	1.282	32.56	1.344	34.14				2.124	53.950	2.194	55.728	2.346	59.588	2.492	63.297	
-22	1.406	35.71	1.345	34.16	1.406	35.71				2.186	55.524	2.256	57.302	2.408	61.163	2.554	64.872	
-23	1.469	37.31	1.407	35.74	1.469	37.31				2.249	57.125	2.319	58.903	2.471	62.763	2.617	66.472	
-24	1.531	38.89	1.470	37.34	1.531	38.89				2.311	58.700	2.381	60.477	2.533	64.338	2.679	68.047	
-25	1.594	40.49	1.532	38.91	1.594	40.49				2.374	60.300	2.444	62.078	2.596	65.938	2.742	69.647	
-26	1.656	42.06	1.595	40.51	1.656	42.06				2.436	61.874	2.506	63.652	2.658	67.513	2.804	71.222	
-27	1.719	43.66	1.657	42.09	1.719	43.66				2.499	63.475	2.569	65.253	2.721	69.113	2.867	72.822	
-28	1.781	45.24	1.720	43.69	1.781	45.24				2.561	65.049	2.631	66.827	2.783	70.688	2.929	74.397	
-29	1.844	46.84	1.782	45.26	1.844	46.84				2.624	66.650	2.694	68.428	2.846	72.288	2.992	75.997	
-30	1.906	48.41	1.845	46.86	1.906	48.41				2.686	68.224	2.756	70.002	2.908	73.863	3.054	77.572	
-31	1.969	50.01	1.907	48.44	1.969	50.01				2.749	69.825	2.819	71.603	2.971	75.463	3.117	79.172	
-32	2.031	51.59	1.970	50.04	2.031	51.59				2.811	71.400	2.881	73.177	3.033	77.038	3.179	80.747	

NOT AVAILABLE IN -05 DIAMETER

3423 SOUTH GARFIELD AVENUE
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DRAWING NO: PLT225()-()-()	
DRAWN BY: G.MARTINEZ	DRAWN DATE: 07-03-13
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