



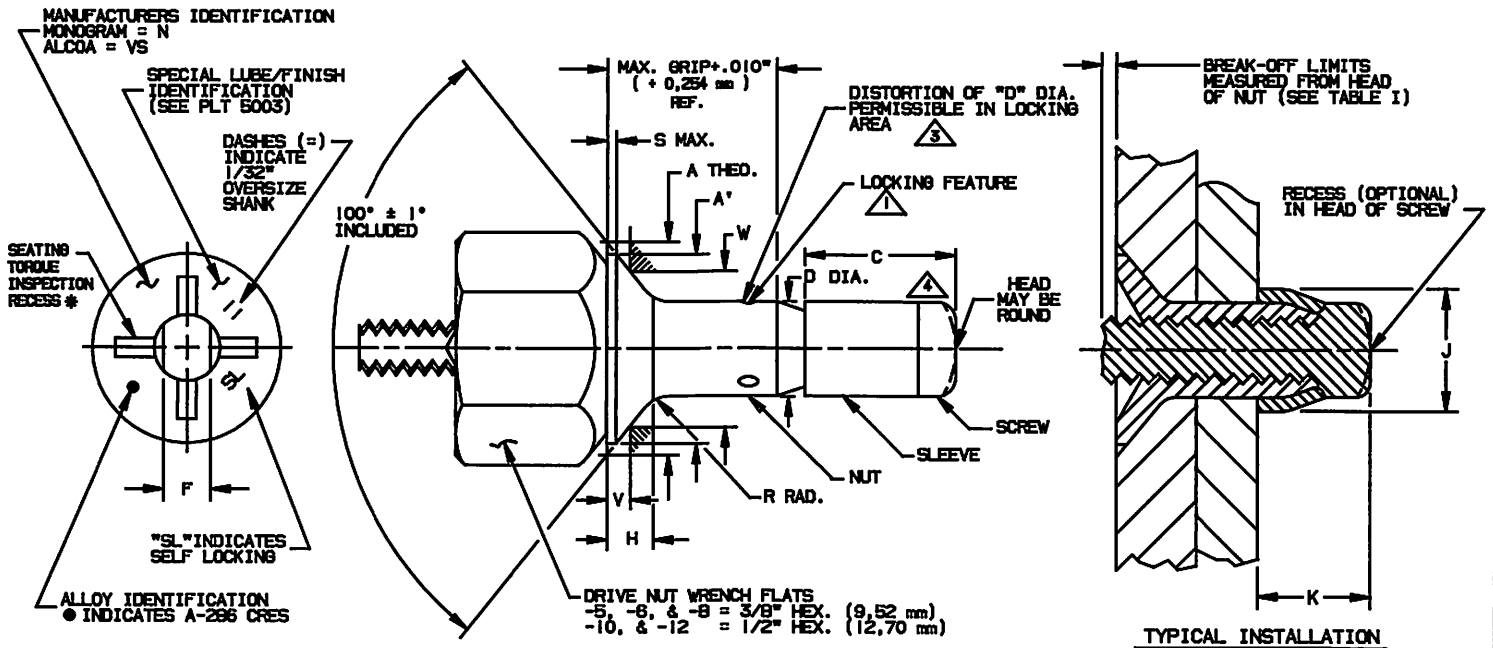
ALCOA

Alcoa Fastening Systems

CUSTODIAN: ENGINEERING STANDARD COMMITTEE FOR BLIND BOLTS
3423 SOUTH GARFIELD AVENUE
LOS ANGELES, CALIFORNIA 90040



MONOGRAM
AEROSPACE
FASTENERS



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 MAX		R RAD.	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
PLT 5122-6-()	.2290	5,817	.385 .378	9,78 9,60	.342	8,69	.360	9,14	.2300 .2280	5,84 5,79	.104 2,64	2,64 2,52	.063	1,70	.315	8,00	.333	8,46	.030 .015	0,76 0,38
PLT 5122-8-()	.2900	7,866	.507 .499	12,88 12,67	.463	11,76	.404	10,26	.2910 .2890	7,39 7,34	.135 3,43	3,43 3,30	.087	2,21	.401	10,19	.366	9,30	.030 .015	0,76 0,38
PLT 5122-10-()	.3415	8,674	.635 .626	16,13 15,90	.577	14,66	.493	12,52	.3425 .3405	8,70 8,65	.152 3,86	3,86 3,73	.118	3,00	.442	11,23	.447	11,35	.040 .020	1,02 0,51
PLT 5122-12-()	.4045	10,273	.762 .752	19,35 19,10	.696	17,68	.583	14,80	.4055 .4035	10,30 10,25	.185 4,70	4,70 4,57	.144	3,66	.531	13,49	.527	13,39	.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 5122-6-()	.015	0,38	.0299 .0259	0,759 0,658	.3147 .3143	7,993 7,983	+.072 -0,16	+1,83 -0,41	-2	.233 .230	5,92 5,84	1.5	0,170	4600	20460	1400	6230
PLT 5122-8-()	.015	0,38	.0353 .0307	0,897 0,780	.4245 .4241	10,782 10,772	+.072 -0,26	+1,83 -0,66	-3	.294 .291	7,47 7,39	2.5	0,282	7900	35140	2100	9340
PLT 5122-10-()	.020	0,51	.0409 .0357	1,039 0,907	.5389 .5385	13,688 13,678	+.072 -0,31	+1,83 -0,79	-4	.346 .343	8,79 8,71	3.5	0,400	11350	50480	3600	16010
PLT 5122-12-()	.023	0,58	.0466 .0407	1,184 1,034	.6532 .6528	16,581 16,581	+.072 -0,31	+1,83 -0,79	-4	.409 .406	10,39 10,32	4.0	0,452	16450	73170	5600	24910

ALCOA

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

4-10-86 ECN 4068

TITLE
VISU-LOK® II FASTENER, BLIND
INTERNALLY THREADED, EXTERNAL SLEEVE
A-286 CRES - 1200°F
100° FLUSH HEAD, SELF LOCKING

1/32" O/S to PLT5120, 1/64" O/S to PLT5121

STANDARD

PLT 5122
(EDU. PLT1058)

SHEET 1 OF 2



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APPLICABLE SPECIFICATIONS:

PROCUREMENT SPECIFICATION = PLT 5000, CLASS 2, TYPE I
PART NUMBER ASSIGNMENT = PLT 5001
INSTALLATION AND REMOVAL = PLT 5002
SPECIAL LUBE AND FINISH = PLT 5003

MATERIAL: NUT, SCREW & SLEEVE: CORROSION AND HEAT RESISTANT STEEL, A-286 PER AMS 5731, AMS 5732 OR AMS 5737
DRIVE NUT: MILD STEEL

HEAT TREAT: NUT & SCREW: HEAT TREAT TO A CORE HARDNESS OF RC 30-45
SLEEVE: AS REQUIRED FOR PERFORMANCE
DRIVE NUT: AS REQUIRED FOR PERFORMANCE

FINISH: NUT, SCREW & SLEEVE: PASSIVATE PER MIL-S-5002
DRIVE NUT: CORROSION RESISTANT COATING. COLOR BLACK

LUBRICATION: SOLID DRY FILM LUBRICANT PER THE CHEMICAL REQUIREMENTS OF AS5272 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 5122 -6 -6

GRIP LENGTH IN 1/16THS (SEE TABLE II)
NOMINAL BODY DIAMETER IN 1/32NDS (SEE TABLE I)
DASH (-) INDICATES STANDARD LUBRICATION AND FINISH (SEE PLT 5003)
BASIC PART NUMBER, SELF LOCKING BLIND BOLT (SEE PLT 5001)

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 5122-6-4.5 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 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 MINIMUM RECOMMENDED HOLE SIZE. FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS (22.23 NEWTONS)
4 OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT BE GREATER THAN MAXIMUM "D" DIAMETER.
5. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.

TABLE II

Table with 5 columns: 2ND DASH NO., MIN. GRIP INCH, MIN. GRIP mm, MAX. GRIP INCH, MAX. GRIP mm. Rows range from -2 to -32.

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CODE IDENT. NO.
5M902

APPROVED DATE
4-10-85 ECN 4088

REV. LETTER AND DATE
ECN #4924
01-12-08

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

TITLE
VISU-LOK® II FASTENER, BLIND
INTERNALLY THREADED, EXTERNAL SLEEVE
A-286 CRES - 1200°F
100° FLUSH HEAD, SELF LOCKING
1/32" O/S to PLT5120, 1/64" O/S to PLT5121

MONOGRAM

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STANDARD

PLT 5122
(EQUIV. PLT1058)
SHEET 2 OF 2