

TABLE I

PART NUMBER	Ø NOM		Ø A THEO		Ø A' MIN		C MAX		Ø D		F WRENCH FLATS		(H)		Ø J MAX		K MAX		R. R		S MAX	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
PLT5180-05-()	.1635	4,153	.332 .325	8,43 8,25	.296	7,52	.285	7,24	.1645 .1625	4,178 4,128	.086 .081	2,18 2,06	.069	1,75	.244	6,20	.257	6,53	.030 .010	0,76 0,25	.012	0,30
PLT5180-05-()X	.1790	4,547	.332 .325	8,43 8,25	.296	7,52	.315	8,00	.1800 .1780	4,572 4,521	.086 .081	2,18 2,06	.063	1,60	.244	6,20	.300	7,62	.030 .010	0,76 0,25	.012	0,30
PLT5180-06-()	.1980	5,029	.385 .378	9,78 9,60	.342	8,69	.320	8,13	.1990 .1970	5,055 5,004	.104 .099	2,64 2,51	.077	1,96	.300	7,62	.288	7,32	.030 .015	0,76 0,38	.015	0,38
PLT5180-06-()X	.2140	5,436	.385 .378	9,78 9,60	.342	8,69	.350	8,89	.2150 .2130	5,461 5,410	.104 .099	2,64 2,51	.070	1,78	.300	7,62	.333	8,46	.030 .015	0,76 0,38	.015	0,38
PLT5180-06-()Y	.2290	5,817	.385 .378	9,78 9,60	.342	8,69	.360	9,14	.2300 .2280	5,842 5,791	.104 .099	2,64 2,51	.063	1,60	.315	8,00	.338	8,59	.030 .015	0,76 0,38	.015	0,38
PLT5180-08-()	.2590	6,579	.507 .499	12,88 12,67	.463	11,76	.375	9,52	.2600 .2580	6,604 6,553	.135 .130	3,43 3,30	.102	2,59	.384	9,75	.320	8,13	.030 .015	0,76 0,38	.015	0,38
PLT5180-08-()X	.2750	6,985	.507 .499	12,88 12,67	.463	11,76	.385	9,78	.2760 .2740	7,011 6,959	.135 .130	3,43 3,30	.096	2,44	.384	9,75	.366	9,30	.030 .015	0,76 0,38	.015	0,38
PLT5180-08-()Y	.2900	7,366	.507 .499	12,88 12,67	.463	11,76	.404	10,26	.2910 .2890	7,391 7,341	.135 .130	3,43 3,30	.087	2,21	.401	10,18	.363	9,22	.030 .015	0,76 0,38	.015	0,38
PLT5180-10-()	.3105	7,887	.635 .626	16,13 15,90	.577	14,66	.440	11,18	.3115 .3095	7,912 7,861	.152 .147	3,86 3,73	.134	3,40	.427	10,85	.396	10,06	.040 .020	1,02 0,51	.020	0,51
PLT5180-10-()X	.3260	8,280	.635 .626	16,13 15,90	.577	14,66	.470	11,94	.3270 .3250	8,306 8,255	.152 .147	3,86 3,73	.120	3,25	.427	10,85	.447	11,36	.040 .020	1,02 0,51	.020	0,51
PLT5180-10-()Y	.3415	8,674	.635 .626	16,13 15,90	.577	14,66	.493	12,52	.3425 .3405	8,699 8,649	.152 .147	3,86 3,73	.118	3,00	.442	11,23	.434	11,02	.040 .020	1,02 0,51	.020	0,51
PLT5180-12-()	.3735	9,487	.762 .752	19,35 19,10	.696	17,68	.525	13,34	.3745 .3725	9,512 9,462	.185 .180	4,70 4,57	.160	4,06	.516	13,11	.473	12,01	.040 .020	1,02 0,51	.023	0,58

TABLE I (CONTINUED)

PART NUMBER	V (GAGE PROTRUSION)		Ø W (GAGE)		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	IN-LBS	Nm	LBS	N	LBS	N
PLT5180-05-()	.0276 .0239	0,701 0,607	.2671 .2669	6,784 6,779	+0,20 -0,68	+0,51 -1,73	-02	.1680 .1650	4,267 4,191	1.0	0,113	4680	20820	1350	6000
PLT5180-05-()X	.0276 .0238	0,701 0,604	.2671 .2669	6,784 6,779	+0,20 -0,68	+0,51 -1,73	-02	.1830 .1800	4,648 4,572	1.0	0,113	4680	20820	1350	6000
PLT5180-06-()	.0250 .0190	0,635 0,483	.3272 .3270	8,311 8,306	+0,15 -0,73	+0,38 -1,85	-02	.2060 .2030	5,232 5,156	1.5	0,170	6900	30700	2100	9340
PLT5180-06-()X	.0250 .0190	0,635 0,483	.3272 .3270	8,311 8,306	+0,15 -0,73	+0,38 -1,85	-02	.2180 .2150	5,537 5,461	1.5	0,170	6900	30700	2100	9340
PLT5180-06-()Y	.0250 .0190	0,635 0,483	.3272 .3270	8,311 8,306	+0,15 -0,73	+0,38 -1,85	-02	.2330 .2300	5,928 5,842	1.5	0,170	6900	30700	2100	9340
PLT5180-08-()	.0327 .0263	0,831 0,668	.4320 .4318	10,973 10,968	+0,10 -0,78	+0,25 -1,98	-03	.2685 .2655	6,820 6,744	2.5	0,282	11800	52500	3650	16240
PLT5180-08-()X	.0327 .0263	0,831 0,668	.4320 .4318	10,973 10,968	+0,10 -0,78	+0,25 -1,98	-03	.2790 .2760	7,087 7,010	2.5	0,282	11800	52500	3650	16240
PLT5180-08-()Y	.0327 .0263	0,831 0,668	.4320 .4318	10,973 10,968	+0,10 -0,78	+0,25 -1,98	-03	.2940 .2910	7,468 7,391	2.5	0,282	11800	52500	3650	16240
PLT5180-10-()	.0390 .0320	0,991 0,813	.5451 .5449	13,846 13,840	+0,10 -0,88	+0,25 -2,24	-04	.3150 .3120	8,001 7,925	3.5	0,395	17000	75620	5200	23130
PLT5180-10-()X	.0390 .0320	0,991 0,813	.5451 .5449	13,846 13,840	+0,10 -0,88	+0,25 -2,24	-04	.3300 .3270	8,382 8,306	3.5	0,395	17000	75620	5200	23130
PLT5180-10-()Y	.0390 .0320	0,991 0,813	.5451 .5449	13,846 13,840	+0,10 -0,88	+0,25 -2,24	-04	.3460 .3430	8,788 8,712	3.5	0,395	17000	75620	5200	23130
PLT5180-12-()	.0466 .0407	1,184 1,034	.6532 .6528	16,591 16,581	+0,10 -0,93	+0,25 -2,36	-04	.3780 .3750	9,601 9,525	4.0	0,452	24500	109000	7500	33360



TITLE: VISU-LOK® II, FASTENER, BLIND, 100° FLUSH TENSION HEAD, 112 KSI SHEAR, UNS N07718

DRAWING NO: PLT5180(-)(-)(-)
 DRAWN BY: A PEREZ
 DRAWN DATE: 01/11/2014
 APPROVED BY:
 CHECKED DATE:

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Alcoa CAGE CODE: 5M902
 MONOGRAM CAGE CODE: 98524
 ECN NO: 14-0781
 ECN DATE: 11/16/14
 REV: P
 SHEET 1 OF 2



APPLICABLE SPECIFICATIONS:
 PROCUREMENT SPECIFICATION: PLT5000, CLASS 7, TYPE I
 PART NUMBER ASSIGNMENT: PLT5001
 INSTALLATION AND REMOVAL: PLT5002
 SPECIAL LUBE AND FINISH: PLT5003

MATERIAL:

NUT AND SCREW: UNS N07718 PER AMS5662.
 SLEEVE: CRES A286 WITH CHEMISTRY PER AMS5731 OR UNS N07750 PER AMS5667 OR AMS5582.
 DRIVE NUT: MILD STEEL.

HEAT TREAT:

NUT AND SCREW: AS REQUIRED FOR PERFORMANCE.
 SLEEVE: AS REQUIRED FOR PERFORMANCE.
 DRIVE NUT: AS REQUIRED FOR PERFORMANCE.

FINISH:

NUT AND SCREW: PASSIVATE PER AMS2700.
 SLEEVE: PASSIVATE PER AMS2700.
 DRIVE NUT: CORROSION RESISTANT COATING, COLOR BLACK.

LUBRICATION:

NO CODE (): SOLID DRY FILM LUBRICANT PER THE CHEMICAL REQUIREMENTS OF AS5272 TYPE I OR III OR EVERLUBE 812 PER MIL-PRF-81329, PARAFFIN WAX, CARBO-WAX, AND/OR CETYL ALCOHOL PER AS87132 MAY BE APPLIED TO ANY OR ALL COMPONENTS AS REQUIRED FOR PERFORMANCE. (SEE PLT5003 FOR SPECIAL LUBRICANTS AND FINISHES).

EXAMPLE PART NUMBER:

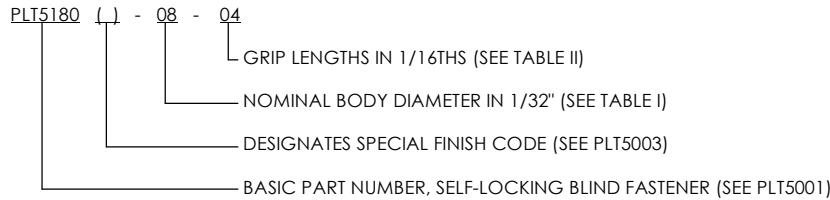


TABLE II				
2ND DASH NO. 3	GRIP RANGE			
	GRIP MIN		GRIP MAX	
	INCH	mm	INCH	mm
-02	.094	2.39	.156	3.96
-03	.157	3.99	.219	5.56
-04	.220	5.59	.281	7.14
-05	.282	7.16	.344	8.74
-06	.345	8.76	.406	10.31
-07	.407	10.34	.469	11.91
-08	.470	11.94	.531	13.49
-09	.532	13.51	.594	15.09
-10	.595	15.11	.656	16.66
-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	29.39	1.219	30.96
-20	1.220	30.99	1.281	32.54
-21	1.282	32.56	1.344	34.14
-22	1.345	34.16	1.406	35.71
-23	1.407	35.74	1.469	37.31
-24	1.470	37.34	1.531	38.89
-25	1.532	38.91	1.594	40.49
-26	1.595	40.51	1.656	42.06
-27	1.657	42.09	1.719	43.66
-28	1.720	43.69	1.781	45.24
-29	1.782	45.26	1.844	46.84
-30	1.845	46.86	1.906	48.41
-31	1.907	48.44	1.969	50.01
-32	1.970	50.04	2.031	51.59

GENERAL NOTES:

1. DIMENSIONS LISTED IN SI UNITS ARE REFERENCE CONVERSION VALUES ROUNDED TO ENCOMPASS THE LIMITING ENGLISH UNIT DIMENSIONS LISTED.
2. LOCKING FEATURE CONSISTS OF THREE (3) INDENTATIONS LOCATED 120 ° APART ON THE PERIPHERY OF THE NUT COMPONENT.
3. HALF GRIP SIZES MAY BE ORDERED BY ADDING ".5" TO THE GRIP DASH NUMBER.
 EXAMPLE: PLT5180-06-4.5 INDICATES A NOMINAL GRIP LENGTH OF 4.5 SIXTEENTHS = .281" [7.14 mm] AND A GRIP RANGE OF .250" [6.35 mm] THRU .312" [7.92 mm].
4. DISTORTION OF "ØD" PERMISSIBLE IN LOCKING AREA. DISTORTION OF "ØD" SHALL NOT PREVENT INSERTION OF THE FASTENER INTO A RING GAUGE OF LENGTH EQUAL TO ONE DIAMETER AND DIAMETER EQUAL TO MAXIMUM "ØD" + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS [22.23 N].
5. PLT5180-05-() GRIP LENGTH AVAILABILITY LIMITED TO -02 THRU -16.
6. DIMENSIONS "ØA THEO", "ØA" AND "H" ARE FOR ENGINEERING REFERENCE PURPOSES ONLY AND ARE NOT TO BE USED FOR INSPECTION PURPOSES. THESE DIMENSIONS ARE THEORETICAL VALUES DERIVED FROM "ØD", "S", "V", "ØW" AND HEAD ANGLE DIMENSIONS.
7. ALTERNATE HEAD MARKING:
 1ST OVERSIZE: "5180 X" OR "5181"
 2ND OVERSIZE: "5180 Y"
8. HEAD MARKINGS ON NUT DEPRESSED .010 INCH [0.254 mm] MAXIMUM. POSITION OPTIONAL.
9. DRIVE NUT NOT SHOWN FOR CLARITY OF HEAD MARKINGS.

MONOGRAM AEROSPACE FASTENERS
 a TriMas company
 3423 SOUTH GARFIELD AVENUE
 COMMERCE, CALIFORNIA 90040
 (323) 722-4760 FAX (323) 727-1029

TITLE:
 VISU-LOK® II, FASTENER, BLIND,
 100° FLUSH TENSION HEAD,
 112 KSI SHEAR, UNS N07718

DRAWING NO: PLT5180()-()-()	
DRAWN BY: A PEREZ	DRAWN DATE: 01/11/2014
APPROVED BY:	CHECKED DATE:

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Alcoa CAGE CODE: 5M902	MONOGRAM CAGE CODE: 98524	ECN NO: 14-0781	REV: P
		ECN DATE: 11/16/14	SHEET 2 OF 2