

**TABLE I**

| PART NUMBER    | Ø NOM |       | A HEX        |                | C MAX |       | Ø D            |                | F WRENCH FLATS |              | H            |              | Ø J MAX |       | (K)  |       | R. R         |              | W HEX |       |
|----------------|-------|-------|--------------|----------------|-------|-------|----------------|----------------|----------------|--------------|--------------|--------------|---------|-------|------|-------|--------------|--------------|-------|-------|
|                | INCH  | mm    | INCH         | mm             | INCH  | mm    | INCH           | mm             | INCH           | mm           | INCH         | mm           | INCH    | mm    | INCH | mm    | INCH         | mm           | INCH  | mm    |
| PLT5250-05-( ) | .1635 | 4,153 | .250<br>.244 | 6,35<br>6,20   | .285  | 7,24  | .1645<br>.1625 | 4,178<br>4,128 | .086<br>.081   | 2,18<br>2,06 | .096<br>.070 | 2,44<br>1,78 | .244    | 6,20  | .257 | 6,53  | .025<br>.020 | 0,63<br>0,51 | .375  | 9,52  |
| PLT5250-06-( ) | .1980 | 5,029 | .312<br>.305 | 7,92<br>7,75   | .320  | 8,13  | .1990<br>.1970 | 5,055<br>5,004 | .104<br>.099   | 2,64<br>2,51 | .113<br>.074 | 2,87<br>1,88 | .300    | 7,62  | .288 | 7,31  | .030<br>.025 | 0,76<br>0,63 | .375  | 9,52  |
| PLT5250-08-( ) | .2590 | 6,579 | .375<br>.367 | 9,52<br>9,32   | .355  | 9,02  | .2600<br>.2580 | 6,604<br>6,553 | .135<br>.130   | 3,43<br>3,30 | .135<br>.084 | 3,43<br>2,13 | .384    | 9,75  | .320 | 8,13  | .035<br>.030 | 0,89<br>0,76 | .375  | 9,52  |
| PLT5250-10-( ) | .3105 | 7,887 | .437<br>.429 | 11,10<br>10,90 | .440  | 11,18 | .3115<br>.3095 | 7,912<br>7,861 | .152<br>.147   | 3,86<br>3,73 | .160<br>.106 | 4,06<br>2,69 | .427    | 10,85 | .396 | 10,06 | .045<br>.035 | 1,14<br>0,89 | .500  | 12,70 |
| PLT5250-12-( ) | .3735 | 9,487 | .500<br>.491 | 12,70<br>12,47 | .525  | 13,34 | .3745<br>.3725 | 9,512<br>9,462 | .185<br>.180   | 4,70<br>4,57 | .190<br>.127 | 4,83<br>3,22 | .516    | 13,11 | .473 | 12,01 | .045<br>.035 | 1,14<br>0,89 | .500  | 12,70 |

**TABLE I (CONTINUED)**

| PART NUMBER    | 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           | IN-LBS                | Nm    | LBS                       | N      | LBS                  | N     |
| PLT5250-05-( ) | +0,088<br>-0,000 | +2,23<br>+0,00 | -01                                      | .168<br>.165 | 4,27<br>4,19 | 1.0                   | 0,113 | 4680                      | 20820  | 1350                 | 6000  |
| PLT5250-06-( ) | +0,098<br>+0,10  | +2,49<br>+0,25 | -01                                      | .202<br>.199 | 5,13<br>5,05 | 1.5                   | 0,170 | 6900                      | 30700  | 2100                 | 9340  |
| PLT5250-08-( ) | +0,135<br>+0,047 | +3,43<br>+1,19 | -02                                      | .263<br>.260 | 6,68<br>6,60 | 2.5                   | 0,282 | 11800                     | 52500  | 3650                 | 16240 |
| PLT5250-10-( ) | +0,146<br>+0,043 | +3,71<br>+1,09 | -02                                      | .315<br>.312 | 8,00<br>7,92 | 3.5                   | 0,400 | 17000                     | 75620  | 5200                 | 23130 |
| PLT5250-12-( ) | +0,152<br>+0,049 | +3,86<br>+1,24 | -03                                      | .378<br>.375 | 9,60<br>9,52 | 4.0                   | 0,452 | 24500                     | 109000 | 7500                 | 33360 |



APPLICABLE SPECIFICATIONS:  
 PROCUREMENT SPECIFICATION: PLT5000, CLASS 4, TYPE V  
 PART NUMBER ASSIGNMENT: PLT5001  
 INSTALLATION AND REMOVAL: PLT5002  
 SPECIAL LUBE AND FINISH: PLT5003

**MATERIAL:**  
 NUT AND SCREW: 5% CHROME STEEL (H-11) PER AMS6487.  
 SLEEVE: CRES A286 PER AMS5731, AMS5732 OR AMS5737 OR INCONEL X-750 PER AMS5667 OR AMS5582.  
 DRIVE NUT: MILD STEEL.

**HEAT TREAT:**  
 NUT AND SCREW: HEAT TREAT TO 48-53 HRC.  
 SLEEVE: AS REQUIRED FOR PERFORMANCE.  
 DRIVE NUT: AS REQUIRED FOR PERFORMANCE.

**FINISH:**  
 NUT AND SCREW: CADMIUM PLATED PER NAS672, .0003" MINIMUM THICKNESS (EXCEPT THERMAL INDICATOR MAY BE OMITTED) FOLLOWED BY A DICHROMATE POST TREATMENT PER AMS-QQ-P-416, NUT COLOR BLACK.  
 SLEEVE: PASSIVATE PER AMS2700, CADMIUM PLATED PER AMS-QQ-P-416, TYPE I OR TYPE II, CLASS 2 OR CLASS 3.  
 DRIVE NUT: CORROSION RESISTANT COATING, COLOR RED.

**LUBRICATION:**  
 NO CODE ( ) : SOLID DRY FILM LUBRICANT PER THE CHEMICAL REQUIREMENTS OF AS5272 TYPE I OR EVERLUBE 812 PER MIL-PRF-81329, PARAFFIN 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:**

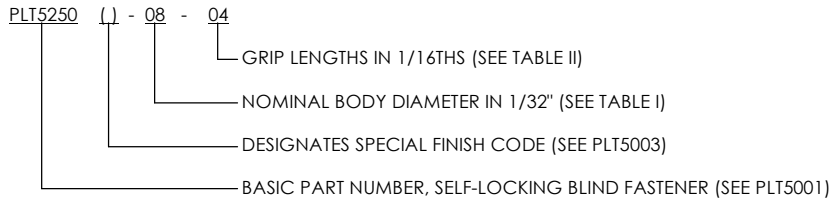


TABLE II

| 2ND DASH NO.<br>△ | GRIP RANGE |       |          |       |
|-------------------|------------|-------|----------|-------|
|                   | GRIP MIN   |       | GRIP MAX |       |
|                   | INCH       | mm    | INCH     | mm    |
| -01               | .032       | 0.81  | .093     | 2.36  |
| -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. 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: PLT5250-06-4.5 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].
3. ALTERNATE HEAD MARKING: "N" (OR "VS"), "250".
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. PLT5250-05-( ) GRIP LENGTH AVAILABILITY LIMITED TO -01 THRU -16.
6. HEAD MARKINGS ON NUT DEPRESSED .010 INCH [0,254 mm] MAXIMUM. POSITION OPTIONAL.
7. DRIVE NUT NOT SHOWN FOR CLARITY OF HEAD MARKINGS.
8. RECESS OR INDENTED HEX IN HEAD OF NUT OPTIONAL.



TITLE:  
 VISU-LOK® II, FASTENER, BLIND,  
 HEXAGONAL PROTRUDING HEAD,  
 NOMINAL DIAMETER,  
 5% CHROME STEEL ALLOY (H-11)

|                                   |                           |
|-----------------------------------|---------------------------|
| DRAWING NO:<br>PLT5250( )-( )-( ) |                           |
| DRAWN BY:<br>A PEREZ              | DRAWN DATE:<br>01/11/2014 |
| APPROVED BY:                      | CHECKED DATE:             |

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|                              |                                 |                       |              |
|------------------------------|---------------------------------|-----------------------|--------------|
| Alcoa<br>CAGE CODE:<br>5M902 | MONOGRAM<br>CAGE CODE:<br>98524 | ECN NO:<br>14-0797    | REV:<br>H    |
|                              |                                 | ECN DATE:<br>11/18/14 | SHEET 2 OF 2 |