

TABLE I

PART NUMBER	Ø NOM		Ø A THEO		Ø A' MIN		C MAX		Ø D		Ø E MAX		F WRENCH FLATS		(H)		Ø J MAX		(K)		R RAD.		S MAX	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
PLT5414-05-(-)	.1635	4,153	.2612 .2564	6,63 6,51	.241	6,12	.268	6,81	.1645 .1635	4,178 4,153	.1615	4,102	.086 .081	2,18 2,06	.040	1,02	.244	6,20	.246	6,25	.030 .010	0,76 0,25	.010	0,25
PLT5414-06-(-)	.1980	5,029	.3016 .2966	7,66 7,53	.270	6,86	.303	7,70	.2026 .2016	5,146 5,121	.1995	5,067	.104 .099	2,64 2,51	.047	1,19	.300	7,62	.281	7,14	.030 .015	0,76 0,38	.015	0,38
PLT5414-08-(-)	.2590	6,579	.3948 .3898	10,03 9,90	.363	9,22	.354	8,99	.2651 .2641	6,734 6,708	.2625	6,668	.135 .130	3,43 3,30	.061	1,55	.384	9,75	.325	8,26	.030 .015	0,76 0,38	.015	0,38
PLT5414-10-(-)	.3105	7,887	.4739 .4689	12,04 11,91	.442	11,23	.423	10,74	.3120 .3110	7,925 7,899	.3090	7,849	.152 .147	3,86 3,73	.068	1,73	.427	10,85	.390	9,91	.040 .020	1,02 0,51	.015	0,38
PLT5414-12-(-)	.3735	9,487	.5604 .5554	14,23 14,11	.529	13,44	.510	12,95	.3745 .3735	9,512 9,487	.3715	9,436	.185 .180	4,70 4,57	.077	1,96	.516	13,11	.470	11,94	.040 .020	1,02 0,51	.015	0,38

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
PLT5414-05-(-)	.0265 .0237	0,673 0,602	.1992 .1990	5,060 5,055	+0,88 -0,00	+2,24 -0,00	-02	.1680 .1650	4,267 4,191	1.0	0,113	3355	14900	900	4003
PLT5414-06-(-)	.0246 .0218	0,625 0,554	.2440 .2438	6,198 6,193	+0,88 -0,00	+2,24 -0,00	-02	.2060 .2030	5,232 5,156	1.5	0,170	5240	23300	1400	6227
PLT5414-08-(-)	.0271 .0242	0,688 0,615	.3314 .3312	8,418 8,412	+0,98 -0,00	+2,49 -0,00	-03	.2685 .2655	6,820 6,744	2.5	0,282	9000	40000	2100	9341
PLT5414-10-(-)	.0296 .0266	0,752 0,676	.4047 .4045	10,279 10,274	+1,03 -0,00	+2,62 -0,00	-03	.3150 .3120	8,001 7,925	3.5	0,400	12000	53400	3600	16013
PLT5414-12-(-)	.0321 .0290	0,815 0,737	.4854 .4852	12,329 12,324	+1,03 -0,00	+2,62 -0,00	-04	.3780 .3750	9,601 9,525	4.0	0,452	19500	86700	5600	24909



APPLICABLE SPECIFICATIONS:

PROCUREMENT SPECIFICATION: PLT5000, CLASS 1, TYPE III
 PART NUMBER ASSIGNMENT: PLT5001
 INSTALLATION AND REMOVAL: PLT5002
 SPECIAL LUBE AND FINISH: PLT5003

MATERIAL:

NUT AND SCREW: ALLOY STEEL 4130 PER AMS-S-6758, ALLOY STEEL 4140 PER AMS6382 OR AMS6349 OR ALLOY STEEL 8740 PER AMS6322.
 SLEEVE: CRES 303 PER AMS5639 OR CRES 304 PER AMS5641.
 DRIVE NUT: MILD STEEL.

HEAT TREAT:

NUT AND SCREW: HEAT TREAT TO 39-43 HRC PER AMS2759.
 SLEEVE: AS REQUIRED FOR PERFORMANCE.
 DRIVE NUT: AS REQUIRED FOR PERFORMANCE.

FINISH:

NUT AND SCREW: CADMIUM PLATED 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 PLATED PER AMS-QQ-P-416, TYPE I, CLASS 3.
 DRIVE NUT: CORROSION RESISTANT COATING, COLOR GOLD.

LUBRICATION:

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 AS87132MAY BE APPLIED TO ANY OR ALL COMPONENTS AS REQUIRED FOR PERFORMANCE. (SEE PLT5003 FOR SPECIAL LUBRICANTS AND FINISHES).

EXAMPLE PART NUMBER:

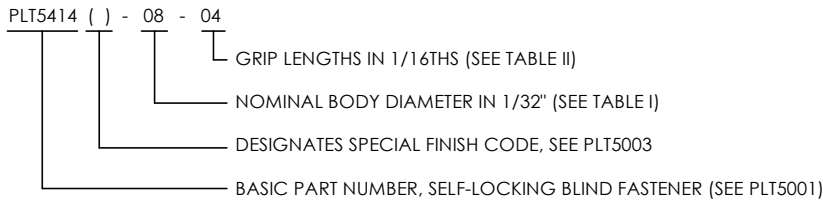


TABLE II

2ND DASH NO.	GRIP RANGE			
	GRIP MIN		GRIP MAX	
	INCH	mm	INCH	mm
2				
-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: PLT5414-06-4.5 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. 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 MINIMUM RECOMMENDED HOLE SIZE. FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS [22.23 N].
4. GROUND SHANK VISU-LOK II, BLIND FASTENERS SHOULD NOT BE USED EXCEPT WITH CONSIDERABLE CAUTION IN APPLICATIONS WHICH EXCEED APPROXIMATELY .0005" INTERFERENCE FIT. GROUND SHANK VISU-LOK II BLIND FASTENERS WILL PERFORM SATISFACTORILY WHEN INSTALLED IN THE TABULATED HOLE SIZES.
5. PLT5414-05-() GRIP LENGTH AVAILABILITY LIMITED TO -02 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.



TITLE:
 VISU-LOK® II, FASTENER, BLIND,
 100° REDUCED FLUSH SHEAR HEAD,
 GROUND SHANK,
 NOMINAL DIAMETER, ALLOY STEEL

DRAWING NO: PLT5414()-()-()	
DRAWN BY: A PEREZ	DRAWN DATE: 01/04/2014
APPROVED BY:	CHECKED DATE:

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SHEET 2 OF 2