

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 MAX		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
PLT6021-06-(-)	.2332	5.92	.343 .338	8.71 8.59	.311	7.90	.364	9.25	.2335 .2330	5.93 5.92	.2300	5.84	.104 .099	2.64 2.52	.045	1.14	.315	8.00	.333	8.46	.030 .015	0.76 0.38	.015	0.38
PLT6021-08-(-)	.2942	7.47	.437 .432	11.10 10.97	.405	10.29	.398	10.11	.2945 .2940	7.48 7.47	.2910	7.39	.135 .130	3.43 3.30	.059	1.50	.401	10.19	.366	9.30	.030 .015	0.76 0.38	.015	0.38
PLT6021-10-(-)	.3457	8.78	.505 .500	12.83 12.70	.473	12.01	.482	12.24	.3460 .3455	8.79 8.78	.3425	8.70	.152 .147	3.86 3.73	.066	1.68	.442	11.23	.447	11.35	.040 .020	1.02 0.51	.015	0.38
PLT6021-12-(-)	.4087	10.38	.592 .587	15.04 14.91	.560	14.22	.567	14.40	.4090 .4085	10.39 10.38	.4055	10.30	.185 .180	4.70 4.57	.076	1.93	.531	13.49	.527	13.39	.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		(L1)		L2 MAX	
	INCH	mm	INCH	mm	INCH	mm		IN-LBS	Nm	LBS	N	LBS	N	INCH	mm	INCH	mm		
PLT6021-06-(-)	.0324 .0293	0.823 0.744	.2671 .2669	6.784 6.779	+0.088 -0.000	+2.24 -0.00	-02	.237 .234	6.02 5.94	1.5	0.170	4600	20460	1250	5560	.444	11.28	.868	22.05
PLT6021-08-(-)	.0273 .0244	0.693 0.620	.3731 .3729	9.477 9.472	+0.098 -0.000	+2.49 -0.00	-03	.298 .295	7.57 7.49	2.5	0.282	7900	35140	1900	8450	.590	14.99	1.030	23.16
PLT6021-10-(-)	.0312 .0281	0.792 0.714	.4320 .4318	10.973 10.968	+0.103 -0.000	+2.62 -0.00	-03	.349 .346	8.86 8.79	3.5	0.400	11350	50480	3250	14460	.617	15.67	1.282	32.56
PLT6021-12-(-)	.0456 .0420	1.158 1.067	.4854 .4852	12.329 12.324	+0.103 -0.000	+2.62 -0.00	-03	.412 .409	10.46 10.39	4.0	0.452	16450	73170	5050	22460	.722	18.34	1.351	34.32

TITLE:

VISU-LOK® II, FASTENER, BLIND,
 INTERNALLY THREADED, EXTERNAL SLEEVE,
 TITANIUM ALLOY, SELF-LOCKING
 100° FLUSH REDUCED FLUSH HEAD, GROUND SHANK
 1/32" O/S TO PLT5474, 1/64" O/S TO PLT6020

DRAWING NO:

PLT6021(-)-(-)-(-)

DRAWN BY:

A PEREZ

DRAWN DATE:

12/10/2013

APPROVED BY:

CHECKED DATE:



APPLICABLE SPECIFICATIONS:

PROCUREMENT SPECIFICATION: PLT5000, CLASS 5, TYPE III
 PART NUMBER ASSIGNMENT: PLT5001
 INSTALLATION AND REMOVAL: PLT5002
 SPECIAL LUBE AND FINISH: PLT5003

MATERIAL:

NUT AND SCREW: 6Al-4V TITANIUM ALLOY PER AMS4928 OR AMS4967.
 SLEEVE: CRES.

HEAT TREAT:

NUT AND SCREW: HEAT TREATED PER AMS-H-81200. MAXIMUM HYDROGEN CONTENT 125 PPM.
 SLEEVE: AS REQUIRED FOR PERFORMANCE.

FINISH:

NUT AND SCREW: NONE.
 SLEEVE: PASSIVATE PER AMS2700.

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 AS87132 MAY BE APPLIED TO ANY OR ALL COMPONENTS AS REQUIRED FOR PERFORMANCE. (SEE PLT5003 FOR SPECIAL LUBRICANTS AND FINISHES).

EXAMPLE PART NUMBER:

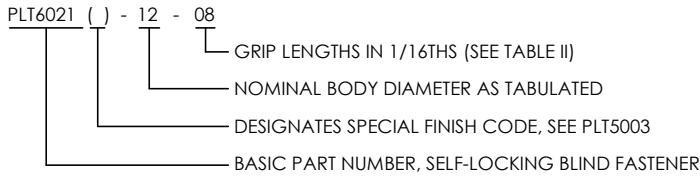


TABLE II

2ND DASH NO. △7	GRIP RANGE					
	GRIP MIN		GRIP MAX		G ^{△13}	
	INCH	mm	INCH	mm	INCH	mm
-01	.032	0.81	.093	2.36	.093	2.36
-02	.094	2.39	.156	3.96	.156	3.96
-03	.157	3.99	.219	5.56	.219	5.56
-04	.220	5.59	.281	7.14	.281	7.14
-05	.282	7.16	.344	8.74	.344	8.74
-06	.345	8.76	.406	10.31	.406	10.31
-07	.407	10.34	.469	11.91	.469	11.91
-08	.470	11.94	.531	13.49	.531	13.49
-09	.532	13.51	.595	15.11	.595	15.11
-10	.595	15.11	.656	16.66	.656	16.66
-11	.657	16.69	.719	18.26	.719	18.26
-12	.720	18.29	.781	19.84	.781	19.84
-13	.782	19.86	.844	21.44	.844	21.44
-14	.845	21.46	.906	23.01	.906	23.01
-15	.907	23.04	.969	24.61	.969	24.61
-16	.970	24.64	1.031	26.19	1.031	26.19
-17	1.032	26.21	1.094	27.79	1.094	27.79
-18	1.095	27.81	1.156	29.36	1.156	29.36
-19	1.157	29.39	1.219	30.96	1.219	30.96
-20	1.220	30.99	1.281	32.54	1.281	32.54
-21	1.282	32.56	1.344	34.14	1.344	34.14
-22	1.345	34.16	1.406	35.71	1.406	35.71
-23	1.407	35.74	1.469	37.31	1.469	37.31
-24	1.470	37.34	1.531	38.89	1.531	38.89
-25	1.532	38.91	1.594	40.49	1.594	40.49
-26	1.595	40.51	1.656	42.06	1.656	42.06
-27	1.657	42.09	1.719	43.66	1.719	43.66
-28	1.720	43.69	1.781	45.24	1.781	45.24
-29	1.782	45.26	1.844	46.84	1.844	46.84
-30	1.845	46.86	1.906	48.41	1.906	48.41
-31	1.907	48.44	1.969	50.01	1.969	50.01
-32	1.970	50.04	2.031	51.59	2.031	51.59

GENERAL NOTES:

- RUNOUT OF HEAD CONICAL SURFACE TO "ØD" SHALL BE WITHIN .005 T.I.R. (EXCEPT OVER INDENTS).
- REMOVE ALL LOOSE OR HANGING BURRS.
- PLT6021 PARTS HAVE A CLOSE TOLERANCE (.0005) GROUND SHANK AND ARE INTENDED FOR USE IN UP TO .0035 DIAMETRAL INTERFERENCE FIT APPLICATIONS.
- △ LOCKING FEATURE CONSISTS OF THREE (3) INDENTATIONS LOCATED 120° APART ON THE PERIPHERY OF THE NUT COMPONENT AND APPROXIMATELY .040 ABOVE THE INTERSECTION OF THE NUT NOSE ANGLE AND OUTER DIAMETER (MEAN GRIP OF FASTENER).
- MANUFACTURER'S IDENTIFICATION:
LETTER "N" DESIGNATES MONOGRAM AEROSPACE FASTENERS
LETTERS "VS" DESIGNATES ALCOA
- △ HEAD MARKINGS ON NUT DEPRESSED .010 INCH [0,254 mm] MAXIMUM. POSITION OPTIONAL.
- △ HALF GRIP SIZES MAY BE ORDERED BY ADDING ".5" TO THE GRIP DASH NUMBER.

EXAMPLE: PLT6021-06-4.5 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/-0,76 mm]. THE BASIC "G" DIMENSION WILL BE NOMINAL GRIP +.031 [+0,79] AND THE OVERALL SCREW LENGTH "L" DIMENSION MAY VARY AT MANUFACTURER'S OPTION.
- STANDARD GRIP LENGTHS ARE SHOWN IN TABLE II. SHORTER OR LONGER GRIPS, OTHER THAN THOSE LISTED, MAY BE AVAILABLE AS SPECIALS. ON GRIP LENGTHS SHORTER THAN THOSE LISTED, THE BREAK-OFF LIMITS AND PREVAILING TORQUE VALUES SHOWN IN TABLE I DO NOT APPLY.
- △ DISTORTION OF "ØD" SHALL NOT PREVENT INSERTION OF THE FASTENER INTO A RING GAUGE OF LENGTH EQUAL TO ONE DIAMETER AND DIAMETER EQUAL TO "ØD" MAX +.001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS.
- DIMENSIONS "ØA", "ØA'" AND "H" ARE FOR ENGINEERING REFERENCES PURPOSES ONLY AND ARE NOT TO USED FOR INSPECTION PURPOSES. THESE DIMENSIONS ARE THEORETICAL VALUES DERIVED FROM "ØD", "S", "V", "ØW" AND HEAD ANGLE DIMENSIONS.
- DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.
- △ FOR ALUMINUM APPLICATION, "ØD" MEASUREMENT MAY INCREASE .0002 INCH OVER THE MAXIMUM DIAMETER AND DECREASE .0005 INCH UNDER THE MINIMUM DIAMETER.
- △ "G" TOLERANCES:
FOR -05 AND -06 SIZES; +.030/-0.010 [+0,762 mm/-0,254 mm].
FOR -08 AND -10 SIZES; +.040/-0.010 [+1,016 mm/-0,254 mm].
FOR -12 SIZE; +.050/-0.010 [+1,270 mm/-0,254 mm].
- △ DRIVE NUT NOT SHOWN FOR CLARITY OF HEAD MARKINGS.



TITLE: VISU-LOK® II, FASTENER, BLIND, INTERNALLY THREADED, EXTERNAL SLEEVE, TITANIUM ALLOY, SELF-LOCKING 100° FLUSH REDUCED FLUSH HEAD, GROUND SHANK 1/32" O/S TO PLT5474, 1/64" O/S TO PLT6020

DRAWING NO: PLT6021(-)-(-)-(-)
 DRAWN BY: A PEREZ
 DRAWN DATE: 12/10/2013
 APPROVED BY:
 CHECKED DATE:

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