

PART NUMBER	NOM. DIA.		A DIA.		C MAX.		D DIA.		E DIA. MAX.		F DRIVING FLATS		H MAX.		J DIA. MAX.	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
PLT215(-)-05(-)	.1635	4.15	.250 .244	6.35 6.20	.268	6.81	.1645 .1625	4.178 4.128	.1620	4.12	.086 .081	2.18 2.06	.096	2.44	.244	6.20
PLT215(-)-06(-)	.1890	4.80	.312 .305	7.92 7.75	.303	7.70	.1900 .1880	4.826 4.775	.1875	4.77	.104 .099	2.64 2.52	.113	2.87	.300	7.62
PLT215(-)-08(-)	.2480	6.30	.375 .367	9.52 9.32	.354	8.99	.2490 .2470	6.325 6.274	.2465	6.27	.135 .130	3.43 3.30	.135	3.43	.384	9.75
PLT215(-)-10(-)	.3105	7.89	.437 .429	11.10 10.90	.423	10.74	.3115 .3095	7.912 7.861	.3090	7.85	.152 .147	3.86 3.73	.160	4.06	.427	10.85
PLT215(-)-12(-)	.3735	9.49	.500 .491	12.70 12.47	.510	12.95	.3745 .3725	9.512 9.462	.3720	9.45	.185 .180	4.70 4.57	.190	4.83	.516	13.11

PART NUMBER	K MAX.		N MIN.		R RAD.		HOLE SIZE		BREAK-OFF LIMITS		PREVAILING TORQUE MIN.		DOUBLE SHEAR STRENGTH MIN.		TENSILE STRENGTH MIN.	
	INCH	mm	INCH	MM	INCH	mm	INCH	mm	INCH	mm	INCH-LBS	Nm	LBS	N	LBS	N
PLT215(-)-05(-)	.246	6.25	.272	6.90	.020 .010	0.51 0.25	.168 .165	4.27 4.19	+0.88 +0.00	+2.23 +0.00	1.0	0.113	3355	14900	900	4000
PLT215(-)-06(-)	.281	7.14	.340	8.63	.025 .015	0.63 0.38	.193 .190	4.90 4.82	+0.98 +0.10	+2.49 +0.25	1.5	0.170	4650	20600	1400	6230
PLT215(-)-08(-)	.325	8.25	.409	10.38	.025 .015	0.63 0.38	.252 .249	6.40 6.32	+1.35 +0.47	+3.43 +1.19	2.5	0.282	7770	34500	2100	9340
PLT215(-)-10(-)	.390	9.91	.479	12.16	.030 .015	0.76 0.38	.315 .312	8.00 7.92	+1.46 +0.43	+3.71 +1.09	3.5	0.400	12000	53400	3600	16010
PLT215(-)-12(-)	.470	11.94	.548	13.91	.030 .015	0.76 0.38	.378 .375	9.60 9.52	+1.52 +0.49	+3.86 +1.24	4.0	0.452	19500	86700	5600	24910

a TriMas company
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TITLE:
VISU-LOK, FASTENER, BLIND
INTERNALLY THREADED, EXTERNAL SLEEVE
ALLOY STEEL
PROTRUDING HEX HEAD, SELF LOCKING
FRACTIONAL DIAMETER

DRAWING NO:
PLT215(-)-(-)-(-)

DRAWN BY: G.MARTINEZ
DRAWN DATE: 07-08-13

APPROVED BY: _____
CHECKED DATE: _____

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MONOGRAM
CAGE CODE:
98524

ECN NO:
14-0672
ECN DATE:
11/03/14

REV:
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SHEET 1 OF 2



PROCUREMENT SPEC: ESCBB-2, CLASS I EXCEPT AS NOTE HEREIN.

MATERIAL:

NUT & SCREW: ALLOY STEEL; 4130 PER AMS-S-6758, 4140 PER AMS6382 OR AMS6349, OR 8740 PER AMS6322.

SLEEVE: CORROSION RESISTANT STEEL; 303 OR 304 PER AMS-QQ-S-763, AMS5639, OR AMS5641.

HEAT TREAT:

NUT & SCREW: HEAT TREAT PER AMS2759. APPROXIMATELY 180,000 TO 200,000 PSI (1240 TO 1380 N/mm²) TENSILE (HRC 39-43).

SLEEVE: AS REQUIRED FOR PERFORMANCE.

FINISH:

NUT & SCREW: CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2. CADMIUM PLATE PER NAS 672 IS PERMISSIBLE PROVIDED IT IS FOLLOWED BY A DICHROMATE POST TREATMENT PER AMS-QQ-P-416.

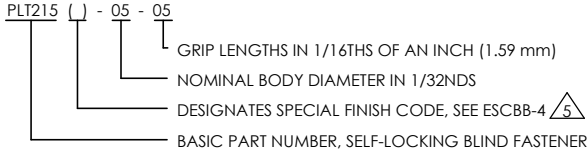
SLEEVE: PASSIVATE PER AMS2700. CADMIUM PLATE PER AMS-QQ-P-416, TYPE I, CLASS 3.

LUBRICANT: LUBRICANTS LISTED BELOW MAY BE APPLIED TO ANY OR ALL COMPONENTS IF REQUIRED FOR PERFORMANCE.

NUT: WWM CARBO-WAX, PARAFFIN WAX AND/OR CETYL ALCOHOL PER AS87132.

SCREW & SLEEVE: DRY FILM LUBE PER AS5272 TYPE I OR MIL-PRF-81329, WWM CARBO-WAX, PARAFFIN WAX AND/OR CETYL ALCOHOL PER AS87132.

PART CODE & EXAMPLE:



GENERAL NOTES:

- OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT BE GREATER THAN MAXIMUM "E" DIAMETER.
2. FASTENERS SHALL BE FREE OF ALL LOOSE OR HANGING BURRS.
- LOCKING FEATURE CONSISTS OF THREE (3) INDENTATIONS LOCATED 120° APART ON THE PERIPHERY OF THE NUT COMPONENT AND APPROXIMATELY .040" (1.02 mm) ABOVE THE INTERSECTION OF THE NUT NOSE ANGLE AND O.D. (MEAN GRIP OF FASTENER).
4. HEAD MARKING ON NUT DEPRESSED .010" (0.26 mm) MAXIMUM.
- STANDARD FINISHES AND LUBRICANTS ARE SHOWN ABOVE. REFER TO SPECIFICATION ESCBB-4 FOR SPECIAL FINISHES AND/OR LUBRICANTS, IF REQUIRED.
- 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 MAXIMUM "D" + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS (22.23 NEWTONS).
- HALF-GRIP SIZES MAY BE ORDERED BY ADDING (.5) TO THE GRIP DASH NUMBERS.
EXAMPLE: PLT215-06-4.5 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 MAXIMUM GRIP ±.031 (±0.79 mm) AND THE OVERALL SCREW LENGTH "L" DIMENSION MAY VARY AT THE MANUFACTURER'S OPTION.
- STANDARD GRIP LENGTHS ARE AS TABULATED, SHORTER OR LONGER GRIPS THAN THOSE LISTED MAY BE AVAILABLE AS SPECIALS. ON GRIP LENGTHS SHORTER THAN THOSE LISTED, THE BREAKOFF LIMITS AND PREVAILING TORQUES AS TABULATED DO NOT APPLY.
9. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.
- THE PREVAILING TORQUE SHALL CONFORM TO THE VALUES AS TABULATED. WHEN TESTED IN ACCORDANCE WITH SPECIFICATION EXCBB-2. HOWEVER, PREVAILING TORQUES FOR THE PLT215-06-01 SHALL BE RECORDED THRU A ROTATION OF ONLY 360° OF THE NUT.
- PLT215-05-() IS EQUIVALENT TO PLT210-05-(); PLT215-10-() IS EQUIVALENT TO PLT210-10-(); PLT215-12-() IS EQUIVALENT TO PLT210-12-().
- "G" TOLERANCES: FOR -05 & -06 SIZES +.030/-0.010; FOR -08 & -10 SIZES +0.040/-0.10; FOR -12 SIZES +.050/-0.10.

SECOND DASH NUMBER			GRIP RANGE						L REF.														
			MIN.			MAX.			PLT215														
			IN	mm	IN	mm	IN	mm	-05-()		-06-()		-08-()		-10-()		-12-()						
-01	.093	2.36	.031	0.78	.093	2.36	.733	18.62	.874	22.20	-	-	-	-	-	-	-	-	-	-	-	-	-
-02	.156	3.96	.094	2.39	.156	3.96	.795	20.19	.936	23.77	1.006	25.55	1.158	29.41	-	-	-	-	-	-	-	-	-
-03	.219	5.56	.157	3.99	.219	5.56	.858	21.80	.999	25.37	1.069	27.15	1.221	31.013	1.304	33.122	-	-	-	-	-	-	-
-04	.281	7.14	.220	5.59	.281	7.14	.920	23.37	1.061	26.95	1.131	28.73	1.283	32.588	1.367	34.722	-	-	-	-	-	-	-
-05	.344	8.74	.282	7.16	.344	8.74	.983	24.97	1.124	28.55	1.194	30.33	1.346	34.188	1.429	36.230	-	-	-	-	-	-	-
-06	.406	10.31	.345	8.76	.406	10.31	1.045	26.543	1.186	30.12	1.256	31.90	1.408	35.763	1.492	36.897	-	-	-	-	-	-	-
-07	.469	11.91	.407	10.34	.469	11.91	1.108	28.143	1.249	31.72	1.319	33.50	1.471	37.363	1.554	39.472	-	-	-	-	-	-	-
-08	.531	13.49	.470	11.94	.531	13.49	1.170	29.718	1.311	33.30	1.381	35.08	1.533	38.938	1.617	41.072	-	-	-	-	-	-	-
-09	.594	15.11	.532	13.51	.594	15.11	1.233	31.318	1.374	34.90	1.444	36.68	1.596	40.538	1.679	42.647	-	-	-	-	-	-	-
-10	.656	16.66	.595	15.11	.656	16.66	1.295	32.893	1.436	36.47	1.506	38.25	1.658	42.113	1.742	44.247	-	-	-	-	-	-	-
-11	.719	18.26	.657	16.69	.719	18.26	1.358	34.493	1.499	38.07	1.569	39.85	1.721	43.713	1.804	45.822	-	-	-	-	-	-	-
-12	.781	19.84	.720	18.29	.781	19.84	1.420	36.068	1.561	39.65	1.631	41.43	1.783	45.288	1.867	47.422	-	-	-	-	-	-	-
-13	.844	21.44	.782	19.86	.844	21.44	1.483	37.668	1.624	41.25	1.694	43.03	1.846	46.888	1.929	48.997	-	-	-	-	-	-	-
-14	.906	23.01	.845	21.46	.906	23.01	1.545	39.243	1.686	42.82	1.756	44.60	1.908	48.463	1.992	50.597	-	-	-	-	-	-	-
-15	.969	24.61	.907	23.04	.969	24.61	1.608	40.843	1.749	44.42	1.819	46.20	1.971	50.063	2.054	52.172	-	-	-	-	-	-	-
-16	1.031	26.19	.970	24.64	1.031	26.19	1.670	42.418	1.811	46.00	1.881	47.78	2.033	51.638	2.117	53.772	-	-	-	-	-	-	-
-17	1.094	27.79	1.032	26.21	1.094	27.79	-	-	1.874	47.60	1.944	49.38	2.096	53.238	2.179	55.347	-	-	-	-	-	-	-
-18	1.156	29.36	1.095	27.81	1.156	29.36	-	-	1.936	49.17	2.006	50.95	2.158	54.813	2.242	56.947	-	-	-	-	-	-	-
-19	1.219	30.96	1.157	29.39	1.219	30.96	-	-	1.999	50.77	2.069	52.55	2.221	56.413	2.304	58.522	-	-	-	-	-	-	-
-20	1.281	32.54	1.220	30.99	1.281	32.54	-	-	2.061	52.35	2.131	54.13	2.283	57.988	2.367	60.122	-	-	-	-	-	-	-
-21	1.344	34.14	1.282	32.56	1.344	34.14	-	-	2.124	53.95	2.194	55.73	2.346	59.588	2.429	61.697	-	-	-	-	-	-	-
-22	1.406	35.71	1.345	34.16	1.406	35.71	-	-	2.186	55.52	2.256	57.30	2.408	61.163	2.492	63.297	-	-	-	-	-	-	-
-23	1.469	37.31	1.407	35.74	1.469	37.31	-	-	2.249	57.12	2.319	58.90	2.471	62.763	2.554	64.872	-	-	-	-	-	-	-
-24	1.531	38.89	1.470	37.34	1.531	38.89	-	-	2.311	58.70	2.381	60.48	2.533	64.338	2.617	66.472	-	-	-	-	-	-	-
-25	1.594	40.49	1.532	38.91	1.594	40.49	-	-	2.374	60.30	2.444	62.08	2.596	65.938	2.679	68.047	-	-	-	-	-	-	-
-26	1.656	42.06	1.595	40.51	1.656	42.06	-	-	2.436	61.87	2.506	63.65	2.658	67.513	2.742	69.647	-	-	-	-	-	-	-
-27	1.719	43.66	1.657	42.09	1.719	43.66	-	-	2.499	63.47	2.569	65.25	2.721	69.113	2.804	71.222	-	-	-	-	-	-	-
-28	1.781	45.24	1.720	43.69	1.781	45.24	-	-	2.561	65.05	2.631	66.83	2.783	70.688	2.867	72.822	-	-	-	-	-	-	-
-29	1.844	46.84	1.782	45.26	1.844	46.84	-	-	2.624	66.65	2.694	68.43	2.846	72.288	2.929	74.397	-	-	-	-	-	-	-
-30	1.906	48.41	1.845	46.86	1.906	48.41	-	-	2.686	68.22	2.756	70.00	2.908	73.863	2.992	75.997	-	-	-	-	-	-	-
-31	1.969	50.01	1.907	48.44	1.969	50.01	-	-	2.749	69.82	2.819	71.60	2.971	75.463	3.054	77.572	-	-	-	-	-	-	-
-32	2.031	51.59	1.970	50.04	2.031	51.59	-	-	2.811	71.40	2.881	73.18	3.033	77.038	3.117	79.172	-	-	-	-	-	-	-

NOT AVAILABLE IN .05 DIAMETER

3423 SOUTH GARFIELD AVENUE
COMMERCE, CALIFORNIA 90040
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TITLE:
VISU-LOK, FASTENER, BLIND INTERNALLY THREADED, EXTERNAL SLEEVE ALLOY STEEL PROTRUDING HEX HEAD, SELF LOCKING FRACTIONAL DIAMETER

DRAWING NO:
PLT215()-()-()

DRAWN BY: G.MARTINEZ DRAWN DATE: 07-08-13

APPROVED BY: CHECKED DATE:

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SHEET 2 OF 2