



HEAD MARKINGS DEPRESSED .010 INCH (0.254 mm MAX.) (POSITION OPTIONAL)  
DRIVE-NUT NOT SHOWN FOR CLARITY OF HEAD MARKINGS.

TABLE I

PART NUMBER	NOM. DIA.		A DIA. THEO.		C MAX.		D DIA.		F FLATS		H HEAD HEIGHT		J DIA. MAX.		K REF.		R RAD.		W REF. (DRIVE NUT)	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
PLT 5244-5-()	.1640	4.166	.250 .244	6.35 6.20	.268	6.81	.1645 .1635	4.178 4.153	.086 .081	2.18 2.06	.096 .070	2.44 1.78	.244	6.20	.246	6.25	.020 .010	0.51 0.25	.375	9.52
PLT 5244-6-()	.2021	5.133	.312 .305	7.92 7.75	.303	7.70	.2026 .2016	5.146 5.121	.104 .099	2.64 2.52	.113 .074	2.87 1.88	.300	7.62	.281	7.14	.025 .015	0.63 0.38	.375	9.52
PLT 5244-8-()	.2645	6.718	.375 .367	9.52 9.32	.354	8.99	.2651 .2641	6.733 6.708	.135 .130	3.43 3.30	.135 .084	3.43 2.13	.384	9.75	.325	8.25	.025 .015	0.63 0.38	.375	9.52
PLT 5244-10-()	.3115	7.912	.437 .429	11.10 10.90	.423	10.74	.3120 .3110	7.925 7.899	.152 .147	3.86 3.73	.160 .106	4.06 2.69	.427	10.85	.390	9.91	.030 .015	0.76 0.38	.500	12.70
PLT 5244-12-()	.3740	9.500	.500 .491	12.70 12.47	.510	12.95	.3745 .3735	9.512 9.487	.185 .180	4.70 4.57	.190 .127	4.83 3.22	.516	13.11	.470	11.94	.030 .015	0.76 0.38	.500	12.70

TABLE I (CONT.)

PART NUMBER	BREAK-OFF LIMITS		MINIMUM AVAILABLE GRIP LENGTH (TABLE II)	HOLE SIZE		PREVAILING TORQUE MIN.		DOUBLE SHEAR STRENGTH MIN.		TENSILE STRENGTH MIN.		SEATING TORQUE	
	INCH	mm		INCH	mm	IN-LBS	Nm	LBS.	N	LBS.	N	IN-LBS	N.m
PLT 5244-5-()	+.088 +.000	+2.23 +0.00	-1	.1680 .1650	4.27 4.19	1.0	0.113	3960	17620	1150	5115	4	0.452
PLT 5244-6-()	+.103 +.015	+2.62 +0.38	-1	.2060 .2030	5.23 5.16	1.5	0.170	5850	26020	1690	7520	6	0.678
PLT 5244-8-()	+.130 +.032	+3.30 +0.81	-2	.2685 .2655	6.82 6.74	2.5	0.282	10000	44480	2900	12900	10	1.130
PLT 5244-10-()	+.130 +.027	+3.30 +0.68	-2	.3150 .3120	8.00 7.92	3.5	0.400	14400	64050	4170	18550	20	2.260
PLT 5244-12-()	+.130 +.027	+3.30 +0.68	-3	.3780 .3750	9.60 9.52	4.0	0.452	20760	92340	5970	26550	30	3.390

<b>VOI-SHAN</b>
CODE IDENT. NO. <b>92215</b>
APPROVED DATE 6-8-87 ECN 4984
REV. LETTER AND DATE "A" 10-16-91 ECN 6861

U.S. PATENT NO. 3643544, 4747202, AND 4967463  
EUROPEAN PATENT NO. 0152531 AND 0216980

<b>MONOGRAM</b>
CODE IDENT. NO. <b>98524</b>
<b>STANDARD</b>
<b>PLT 5244</b>
SHEET 1 OF 2

TITLE  
VISU-LOK® II FASTENER, BLIND  
HEXAGONAL PROTRUDING HEAD  
NOMINAL DIAMETER - GROUND SHANK  
95 KSI F<sub>su</sub> CRES

APPLICABLE SPECIFICATIONS:

PROCUREMENT SPECIFICATION = PLT 5000, CLASS 6, TYPE V  
PART NUMBER ASSIGNMENT = PLT 5001  
INSTALLATION AND REMOVAL = PLT 5002  
SPECIAL LUBE AND FINISH = PLT 5003

MATERIAL: NUT & SLEEVE: CORROSION AND HEAT RESISTANT STEEL, A-286  
PER AMS 5731, AMS 5732 OR AMS 5737  
SCREW: INCONEL 718 PER AMS 5662  
DRIVE NUT: MILD STEEL

HEAT TREAT: NUT & SCREW: HEAT TREAT TO A CORE HARDNESS OF RC 30-45  
AS REQUIRED FOR PERFORMANCE  
SLEEVE: AS REQUIRED FOR PERFORMANCE  
DRIVE NUT: AS REQUIRED FOR PERFORMANCE

FINISH: NUT, SCREW & SLEEVE: PASSIVATE PER MIL-S-5002  
DRIVE NUT: CORROSION RESISTANT COATING, COLOR BLACK

LUBRICATION: SOLID DRY FILM LUBRICANT PER THE CHEMICAL REQUIREMENTS OF  
MIL-L-46010 TYPE I OR EVERLUBE 812 PER MIL-L-81329, PARAFFIN  
WAX OR CETYL ALCOHOL PER MIL-L-87132 MAY BE APPLIED TO ANY  
OR ALL COMPONENTS AS REQUIRED FOR PERFORMANCE,  
(SEE PLT 5003 FOR SPECIAL LUBRICANTS AND FINISHES)

PART CODE & EXAMPLE: **PLT 5244 - 6 - 4**  

GRIP LENGTH IN 1/16THS (SEE TABLE II)  
NOMINAL BODY DIAMETER IN 1/32NDS (SEE TABLE I)  
DASH (-) INDICATES STANDARD LUBRICATION AND FINISH (SEE PLT 5003)  
BASIC PART NUMBER, SELF-LOCKING BLIND BOLT (SEE PLT 5001)

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: PLT 5244-6-4.5 HAS A NOMINAL GRIP LENGTH OF 4-1/2 16THS (.281" = 7.14mm) AND A GRIP RANGE OF .250" THRU .312". (6.35mm THRU 7.92mm)
- ③ 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 MINIMUM RECOMMENDED HOLE SIZE. FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS (22.23 NEWTONS)
- 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 SECOND DASH NUMBER (GRIP RANGE) -17 THROUGH -32 NOT AVAILABLE IN -5 DIAMETER

TABLE II

2ND DASH NO. ⑤	GRIP RANGE ②			
	MIN. GRIP		MAX. GRIP	
	INCH	mm	INCH	mm
-1	.032	0,81	.093	2,36
-2	.094	2,39	.156	3,96
-3	.157	3,99	.219	5,56
-4	.220	5,59	.281	7,14
-5	.282	7,16	.344	8,74
-6	.345	8,76	.406	10,31
-7	.407	10,34	.469	11,91
-8	.470	11,94	.531	13,49
-9	.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	29,38	1,219	30,97
-20	1,220	30,98	1,281	32,54
-21	1,282	32,55	1,344	34,14
-22	1,345	34,15	1,406	35,72
-23	1,407	35,73	1,469	37,32
-24	1,470	37,33	1,531	38,89
-25	1,532	38,90	1,594	40,49
-26	1,595	40,50	1,656	42,07
-27	1,657	42,08	1,719	43,67
-28	1,720	43,68	1,781	45,24
-29	1,782	45,25	1,844	46,84
-30	1,845	46,85	1,906	48,42
-31	1,907	48,43	1,969	50,02
-32	1,970	50,03	2,031	51,59

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