



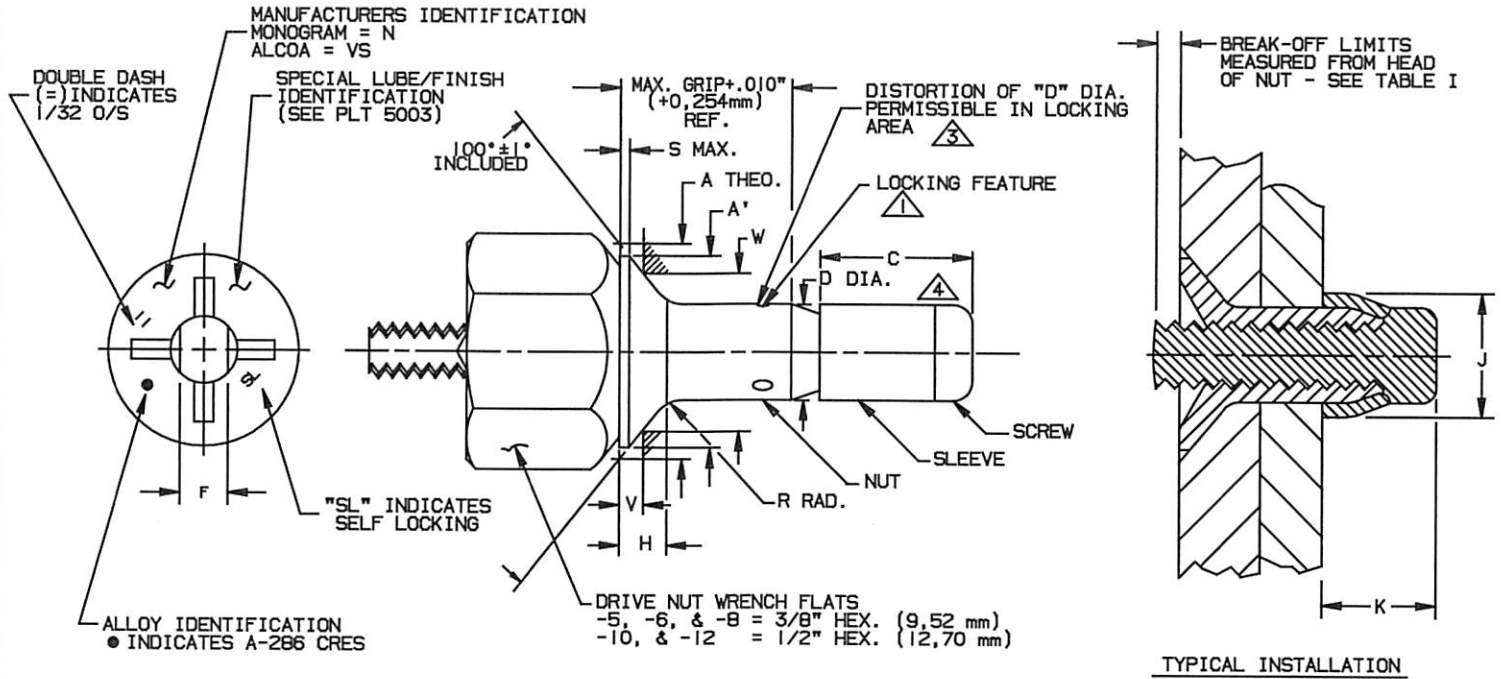
ALCOA

Alcoa Fastening Systems

CUSTODIAN: ENGINEERING STANDARD COMMITTEE FOR BLIND BOLTS
3423 SOUTH GARFIELD AVENUE
LOS ANGELES, CALIFORNIA 90040



MONOGRAM
AEROSPACE
FASTENERS



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.		A' DIA. MIN.		C MAX.		D DIA.		F FLATS		H REF.		J DIA. MAX.		K MAX.		R RAD.	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
PLT 5422-6-()	.2290	5,817	.343 .338	8,71 8,59	.311	7,90	.360	9,14	.2300 .2280	5,84 5,79	.104 .099	2,64 2,51	.047	1,19	.315	8,00	.333	8,46	.030 .015	0,76 0,38
PLT 5422-8-()	.2900	7,366	.437 .432	11,10 10,97	.405	10,29	.404	10,26	.2910 .2890	7,39 7,34	.135 .130	3,43 3,30	.061	1,55	.401	10,19	.366	9,30	.030 .015	0,76 0,38
PLT 5422-10-()	.3415	8,674	.505 .500	12,83 12,70	.473	12,01	.493	12,52	.3425 .3405	8,70 8,65	.152 .147	3,86 3,73	.068	1,73	.442	11,23	.447	11,35	.040 .020	1,02 0,51
PLT 5422-12-()	.4045	10,274	.592 .587	15,04 14,91	.560	14,22	.583	14,80	.4055 .4035	10,30 10,25	.185 .180	4,70 4,57	.078	1,98	.531	13,49	.527	13,39	.040 .020	1,02 0,51

TABLE I (CONT.)

PART NUMBER	S MAX.		V GAGE PROT.		W GAGE DIA.		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		INCH	mm	IN-LBS	Nm	LBS.	kN	LBS.	kN
PLT 5422-6-()	.015	0,38	.0324 .0293	0,823 0,744	.2671 .2669	6,784 6,779	+.088 -.000	+2,24 -0,00	-2	.233 .231	5,92 5,86	1.5	0,170	6200	27.6	1400	6.2
PLT 5422-8-()	.015	0,38	.0273 .0244	0,693 0,620	.3731 .3729	9,477 9,472	+.098 -.000	+2,49 -0,00	-3	.294 .292	7,47 7,41	2.5	0,282	9900	44.0	2100	9.3
PLT 5422-10-()	.015	0,38	.0312 .0281	0,792 0,714	.4320 .4318	10,973 10,967	+.103 -.000	+2,62 -0,00	-3	.346 .343	8,79 8,71	3.5	0,400	13700	60.9	3600	16.0
PLT 5422-12-()	.015	0,38	.0456 .0420	1,158 1,067	.4854 .4852	12,329 12,324	+.103 -.000	+2,62 -0,00	-4	.409 .406	10,39 10,32	4.0	0,452	19300	85.8	5600	24.9

ALCOA

CODE IDENT. NO.
5M902

MONOGRAM

CODE IDENT. NO.
98524

APPROVED DATE

5-28-85 ECN 4154

REV. LETTER AND DATE

© ECN #5841
09-27-11

TITLE
VISU-LOK® II FASTENER, BLIND
INTERNALLY THREADED, EXTERNAL SLEEVE
A-286 CRES - 1200°F
100° FLUSH SHEAR HEAD, SELF LOCKING
1/32" O/S to PLT5420, 1/64" O/S to PLT5421

STANDARD

PLT 5422

SHEET 1 OF 2



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APPLICABLE SPECIFICATIONS:

PROCUREMENT SPECIFICATION = PLT 5000, CLASS 2, TYPE II
PART NUMBER ASSIGNMENT = PLT 5001
INSTALLATION AND REMOVAL = PLT 5002
SPECIAL LUBE AND FINISH = PLT 5003

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

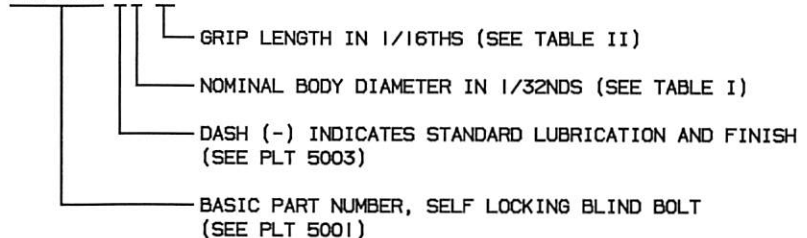
HEAT TREAT: NUT & SCREW: HEAT TREAT TO A CORE HARDNESS OF RC 30-45
SLEEVE: AS REQUIRED FOR PERFORMANCE
DRIVE NUT: AS REQUIRED FOR PERFORMANCE

FINISH: NUT, SCREW & SLEEVE: PASSIVATE PER AMS2700
DRIVE NUT: CORROSION RESISTANT COATING. COLOR BLACK

LUBRICATION: SOLID DRY FILM LUBRICANT PER THE CHEMICAL REQUIREMENTS OF ASS272 TYPE I OR EVERLUBE 812 PER MIL-L-81329, PARAFFIN WAX OR CETYL ALCOHOL PER AS87132 MAY BE APPLIED TO ANY OR ALL COMPONENTS AS REQUIRED FOR PERFORMANCE, (SEE PLT 5003 FOR SPECIAL LUBRICANTS AND FINISHES)

PART CODE & EXAMPLE:

PLT 5422 -6 -6



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 5422-6-4.5 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 OUTSIDE DIAMETER OF HEAD OF SCREW AND OUTSIDE DIAMETER OF SLEEVE SHALL NOT BE GREATER THAN MAXIMUM "D" DIAMETER.

5. DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.

TABLE II

Table with 5 columns: 2ND DASH NO., MIN. GRIP INCH, MIN. GRIP mm, MAX. GRIP INCH, MAX. GRIP mm. Rows range from -2 to -32.

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SHEET 2 OF 2