

9

PART NUMBER	Ø NOM		A HEX		C MAX		Ø D		Ø E MAX		F WRENCH FLATS		H		Ø J MAX		K MAX		R. R	
	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm	INCH	mm
PLT6019-06-(-)	.2332	5.923	.312 .305	7.92 7.75	.364	9.25	.2335 .2330	5.931 5.918	.2300	5.842	.104 .099	2.64 2.51	.113 .074	2.87 1.88	.315	8.00	.333	8.46	.025 .015	0.63 0.38
PLT6019-08-(-)	.2942	7.473	.375 .367	9.52 9.32	.398	10.11	.2945 .2940	7.480 7.468	.2910	7.391	.135 .130	3.43 3.30	.135 .084	3.43 2.13	.401	10.19	.366	9.30	.025 .015	0.63 0.38
PLT6019-10-(-)	.3457	8.781	.437 .429	11.10 10.90	.482	12.24	.3460 .3455	8.788 8.776	.3425	8.700	.152 .147	3.86 3.73	.160 .106	4.06 2.69	.442	11.23	.447	11.35	.030 .015	0.76 0.38
PLT6019-12-(-)	.4087	10.381	.500 .491	12.70 12.47	.567	14.40	.4090 .4085	10.389 10.376	.4055	10.300	.185 .180	4.70 4.57	.190 .127	4.83 3.22	.531	13.49	.527	13.39	.030 .015	0.76 0.38

PART NUMBER	BREAK-OFF LIMITS		MINIMUM AVAILABLE GRIP LENGTH (TABLE II)	HOLE SIZE		PREVAILING TORQUE MIN		DOUBLE SHEAR STRENGTH MIN		TENSILE STRENGTH MIN		N MIN		(L1)		(L3)	
	INCH	mm		INCH	mm	IN-LBS	Nm	LBS	N	LBS	N	INCH	mm	INCH	mm	INCH	mm
PLT6019-06-(-)	+0.08 +0.10	+2.49 +0.25	-01	.237 .234	6.02 5.94	1.5	0.170	4600	20460	1400	6230	.340	8.64	.444	11.28	.931	23.65
PLT6019-08-(-)	+0.135 +0.047	+3.43 +1.19	-02	.298 .295	7.57 7.49	2.5	0.282	7900	35140	2100	9340	.409	10.39	.590	14.99	1.155	29.34
PLT6019-10-(-)	+0.146 +0.043	+3.71 +1.09	-02	.349 .346	8.86 8.79	3.5	0.400	11350	50480	3600	16010	.479	12.17	.617	15.67	1.407	35.74
PLT6019-12-(-)	+0.152 +0.049	+3.86 +1.24	-03	.412 .409	10.46 10.39	4.0	0.452	16450	73170	5600	24910	.548	13.92	.722	18.34	1.476	37.49



APPLICABLE SPECIFICATIONS:
 PROCUREMENT SPECIFICATION: PLT5000, CLASS 5, TYPE V
 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 TREAT PER AMS-H-81200. MAX HYDROGEN 125 PPM.
 SLEEVE: AS REQUIRED FOR PERFORMANCE.

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

LUBRICATION:
 NO 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:

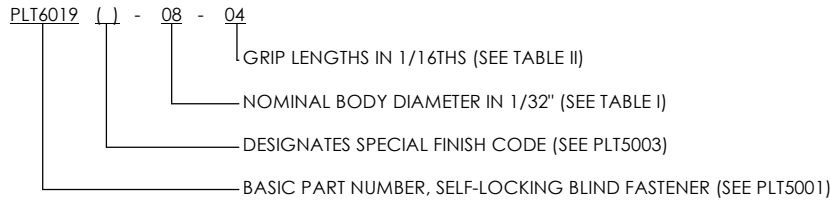


TABLE II

2ND DASH NO. △ S	GRIP RANGE					
	GRIP MIN		GRIP MAX		G/10	
	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	.594	15.09	.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:

- HEAD MARKINGS ON NUT DEPRESSED .010 INCH [0,254 mm] MAXIMUM. POSITION OPTIONAL.
- PARTS SHALL BE FREE OF LOOSE OR HANGING BURRS.
- 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 O.D. (MEAN GRIP OF FASTENER).
- STANDARD GRIP LENGTHS ARE SHOWN IN TABLE II, SHORTER OR LONGER GRIPS 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.
- HALF GRIP SIZES MAY BE ORDERED BY ADDING ".5" TO THE GRIP DASH NUMBER.
EXAMPLE: PLT6019-06-4.5 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].
- 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 MAXIMUM "ØD" + .001". FORCE FOR INSERTION SHALL NOT EXCEED FIVE (5) POUNDS [22.23 N].
- THESE PARTS HAVE A CLOSE TOLERANCE (.0005") GROUND SHANK AND ARE INTENDED FOR UP TO .0035" DIAMETRICAL INTERFERENCE FIT INSTALLATION.
- DIMENSIONS ARE EXCLUSIVE OF LUBRICATION.
- FOR ALUMINUM APPLICATION, "ØD" MAY BE INCREASED BY .0002" [0,005 mm] OVER THE MAXIMUM DIAMETER AND DECREASE .0005" [0,013 mm] UNDER THE MINIMUM DIAMETER.
- "G" TOLERANCES: FOR -06 SIZE; +.030/-010 [+0,762 mm/-0,254 mm].
FOR -08 AND -10 SIZES; +.040/-010 [+1,016 mm/-0,254 mm].
FOR -12 SIZE; +.050/-010 [+1,270 mm/-0,254 mm].
- DRIVE NUT NOT SHOWN FOR CLARITY OF HEAD MARKINGS.
- RECESS OR INDENTED HEX IN HEAD OF NUT OPTIONAL.



TITLE:
 VISU-LOK® II, FASTENER, BLIND,
 HEXAGONAL PROTRUDING HEAD,
 GROUND SHANK, TITANIUM ALLOY
 1/32" O/S TO PLT5274, 1/64" O/S TO PLT6018

DRAWING NO: PLT6019(-)(-)(-)	
DRAWN BY: A PEREZ	DRAWN DATE: 02/15/2014
APPROVED BY:	CHECKED DATE:
Alcoa CAGE CODE: 5M902	MONOGRAM CAGE CODE: 98524
ECN NO: 14-0827	REV: G
ECN DATE: 11/23/14	SHEET 2 OF 2

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