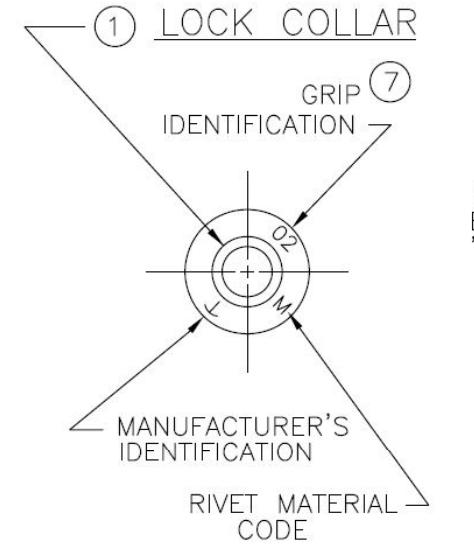




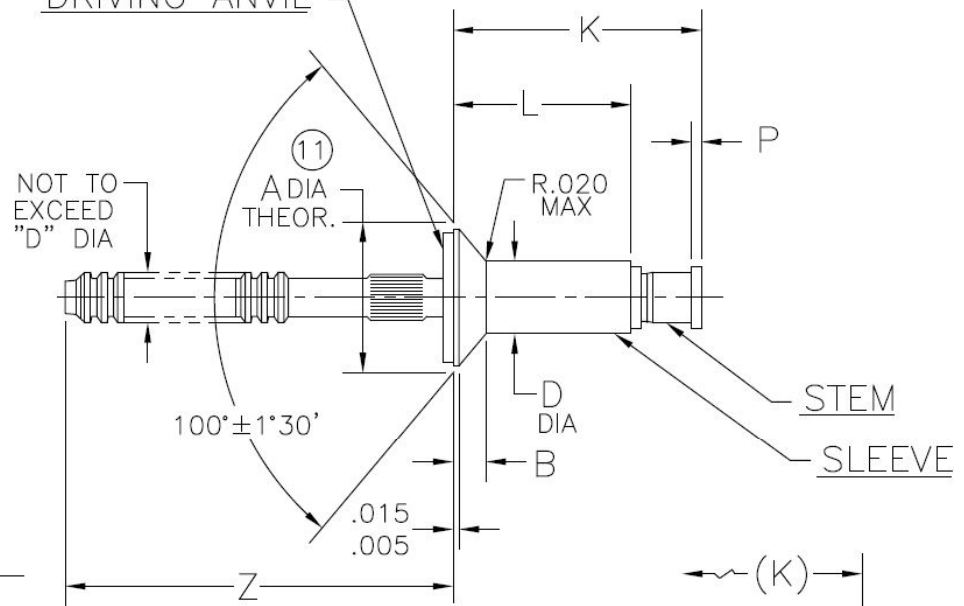
PRINTED COPIES OF THIS DOCUMENT ARE FOR "REFERENCE" ONLY. CURRENT REVISIONS ARE AVAILABLE ONLINE.

**HEAD MARKING** ①  
FOR -6 AND -8 DIA ONLY

FOR -6 AND -8 DIA ONLY

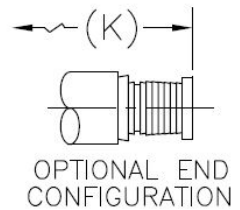
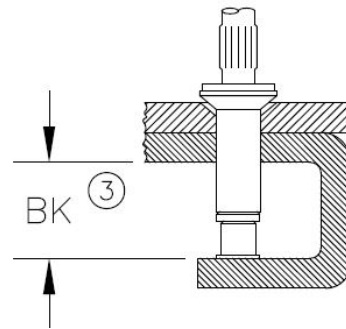
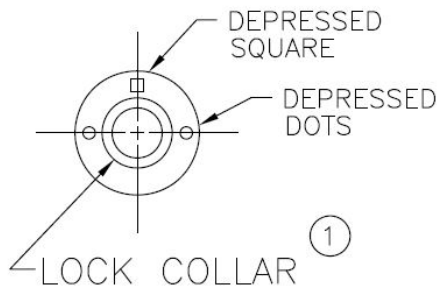


**DRIVING ANVIL** ②



**HEAD MARKING** ①  
FOR -4 AND -5 DIA ONLY

FOR -4 AND -5 DIA ONLY



**TABLE I**

DIA. DASH NO.	A ±.004	B REF	D +.003 - .001	P MIN	Z REF	BK MIN	HOLE LIMITS	
							MIN	MAX
-4	.192 (11)	.028	.126	.010	.87	.355	.129	.132
-5	.243	.037	.157	.015	.94	.370	.160	.164
-6	.299	.046	.189				.415	.192
-8	.392	.060	.253	.97	.485	.256	.261	

NOTICE: ALL DIMENSIONS ARE IN INCHES AND APPLY AFTER FINISH AND BEFORE LUBRICATION UNLESS OTHERWISE SPECIFIED.

WARNING: FASTENERS MAY NOT PERFORM PROPERLY IF ALTERED FROM THE MANUFACTURER'S AS-SHIPPED CONDITION OR INSTALLED IN CONDITIONS OTHER THAN SPECIFIED HEREIN.

PROCUREMENT SPECIFICATION:  PS-CMR-3000  NAS 523 CODE: SEE TABLE II	<b>CHERRYMAX</b> ® RIVET NOMINAL DIAMETER NAS 1097 100° FLUSH HEAD		SHEET 1 OF 4		PART NUMBER
			ISSUE	03-31-83	<b>CR3524</b>
			REV.	AC 06-14-17	



**TABLE II**

FINISH CODE	NAS 523 CODE	MATERIAL ⑤			FINISH		
		SLEEVE	STEM	LOCK COLLAR	SLEEVE	STEM	LOCK COLLAR
---	AYX	MONEL PER QQ-N-281	15-7 PH CRES PER AMS 5657	A-286 CRES PER AMS 5731 & AMS 5737	NONE	NONE	PASSIVATE PER AMS 2700
DL ⑧	---					PASSIVATE PER AMS 2700 & DICRONITE DL-5	
EE ⑪	BCT				ALUM. COAT PER NAS 4006 & BMS 10-85		
P ⑪	AYY				ALUM. COAT PER MIL-DTL-83488		
PR ⑨	---				NONE		
GP ⑪ ⑫	---				ALUM. COAT PER MIL-DTL-83488 (SUPPLEMENTAL: MIL-DTL-5541 CL 1A, TYPE II)		
GEE ⑪ ⑫	---				ALUM. COAT PER NAS 4006 CLASS NC		

SHEET 2 OF 4			PART NUMBER
ISSUE	03-31-83		<b>CR3524</b>
REV.	AC	06-14-17	



TABLE III

GRIP DASH NO.	GRIP RANGE		-4 DIA		-5 DIA		-6 DIA		-8 DIA	
	MIN	MAX	L +.000 -.030	K MAX	L +.000 -.030	K MAX	L +.000 -.030	K MAX	L +.000 -.030	K MAX
-01	.045	.062	.221	.45	---	---	---	---	---	---
-02	④	.125	.224	.45	.230	.47	.262	.51	---	---
-03	.126	.187	.287	.51	.293	.53	.325	.57	.378	.65
-04	.188	.250	.349	.57	.355	.59	.387	.64	.440	.72
-05	.251	.312	.412	.63	.418	.65	.450	.70	.503	.78
-06	.313	.375	.474	.70	.480	.72	.512	.76	.565	.84
-07	.376	.437	.537	.76	.543	.77	.575	.82	.628	.90
-08	.438	.500	.599	.82	.605	.84	.637	.88	.690	.97
-09	.501	.562	.662	.88	.668	.90	.700	.95	.753	1.03
-10	.563	.625	---	---	.730	.96	.762	1.01	.815	1.09
-11	.626	.687	---	---	.793	1.02	.825	1.07	.878	1.15
-12	.688	.750	---	---	---	---	.887	1.13	.940	1.22
-13	.751	.812	---	---	---	---	---	---	1.003	1.28
-14	.813	.875	---	---	---	---	---	---	1.065	1.34

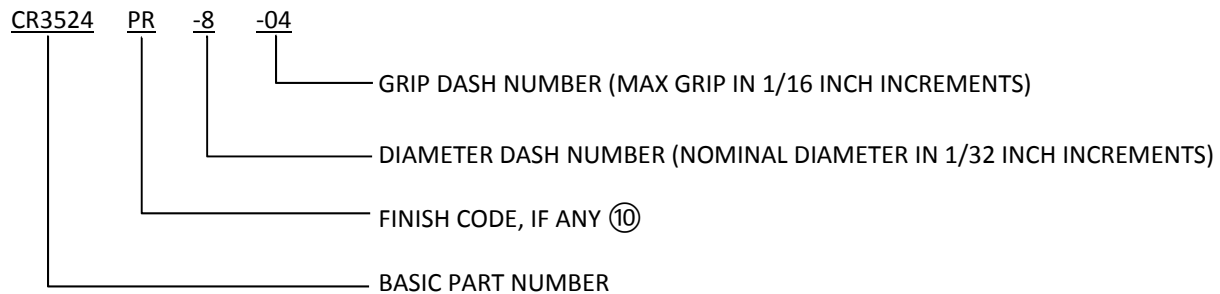
SHEET 3 OF 4			PART NUMBER
ISSUE	03-31-83		CR3524
REV.	AC	06-14-17	



**NOTES:**

- ① HEAD MARKINGS AND LOCK COLLAR VISIBLE AFTER INSTALLATION.
- ② GOLD COLORED DRIVING ANVIL IDENTIFIES NOMINAL DIAMETER RIVETS.
- ③ MINIMUM BLIND SIDE CLEARANCE FOR SATISFACTORY INSTALLATION.
- ④ MINIMUM GRIP FOR -02 GRIP PARTS: FOR -4 DIA. IS .063; FOR -5 IS .065; AND FOR -6 IS .080.
- ⑤ MATERIAL DESIGNATION REFERS TO CHEMICAL COMPOSITION ONLY.
- 6. SHEET THICKNESS FOR MACHINE COUNTERSUNK HOLES SHALL NOT BE LESS THAN "B" +.010.
- ⑦ SINGLE DIGIT HEAD MARKING IS PERMISSIBLE, AT MANUFACTURER'S OPTION, FOR GRIP DASH NUMBERS LESS THAN 10.
- ⑧ NICKEL PLATED (SILVER COLORED) DRIVING ANVILS ARE PROVIDED ON "DL" FINISH CODE PARTS. LUBRICANTS OTHER THAN DICRONITE DL-5 MAY NOT BE USED. "DL" FINISH MEETS SPECIFICATION DOD-L-85645.
- ⑨ "PR" CODE – PARTS ARE MANUFACTURED BARE; IF LUBE IS REQUIRED, USE PAR 90 ONLY. IN ADDITION, MANUFACTURER'S OPTION TO APPLY MOLYBDENUM DISULFIDE TYPE I PER AS5272 TO STEM ONLY.
- ⑩ FINISH CODES MAY BE COMBINED. EXAMPLE: CODE "PPR" – ALUMINUM COATED SLEEVE WITH "PR" LUBE RESTRICTION. WHEN COMBINING FINISH CODES, PLACE PLATING CODE BEFORE LUBE CODE.
- ⑪ FOR -4 DIAMETER, "A" THEORETICAL DIMENSION IS MEASURED PRIOR TO THE APPLICATION OF THE FINISH.
- ⑫ FINISH CODES WITH THE PREFIX "G" INDICATE REACH COMPLIANT COATING.

**EXAMPLE OF CHERRY PART NUMBER:**



SHEET 4 OF 4		PART NUMBER
ISSUE	03-31-83	
REV.	AC	06-14-17
<b>CR3524</b>		

## STANDARDS PAGE REVISION LOG

REV LTR	DATE	DCR NUMBER	REVISION DESCRIPTION	COMP. BY
AC	06-14-17	17-0522	<ul style="list-style-type: none"><li>CORRECTED LOCK COLLAR ARROW LOCATION ON HEAD MARKING VIEW</li></ul>	AA