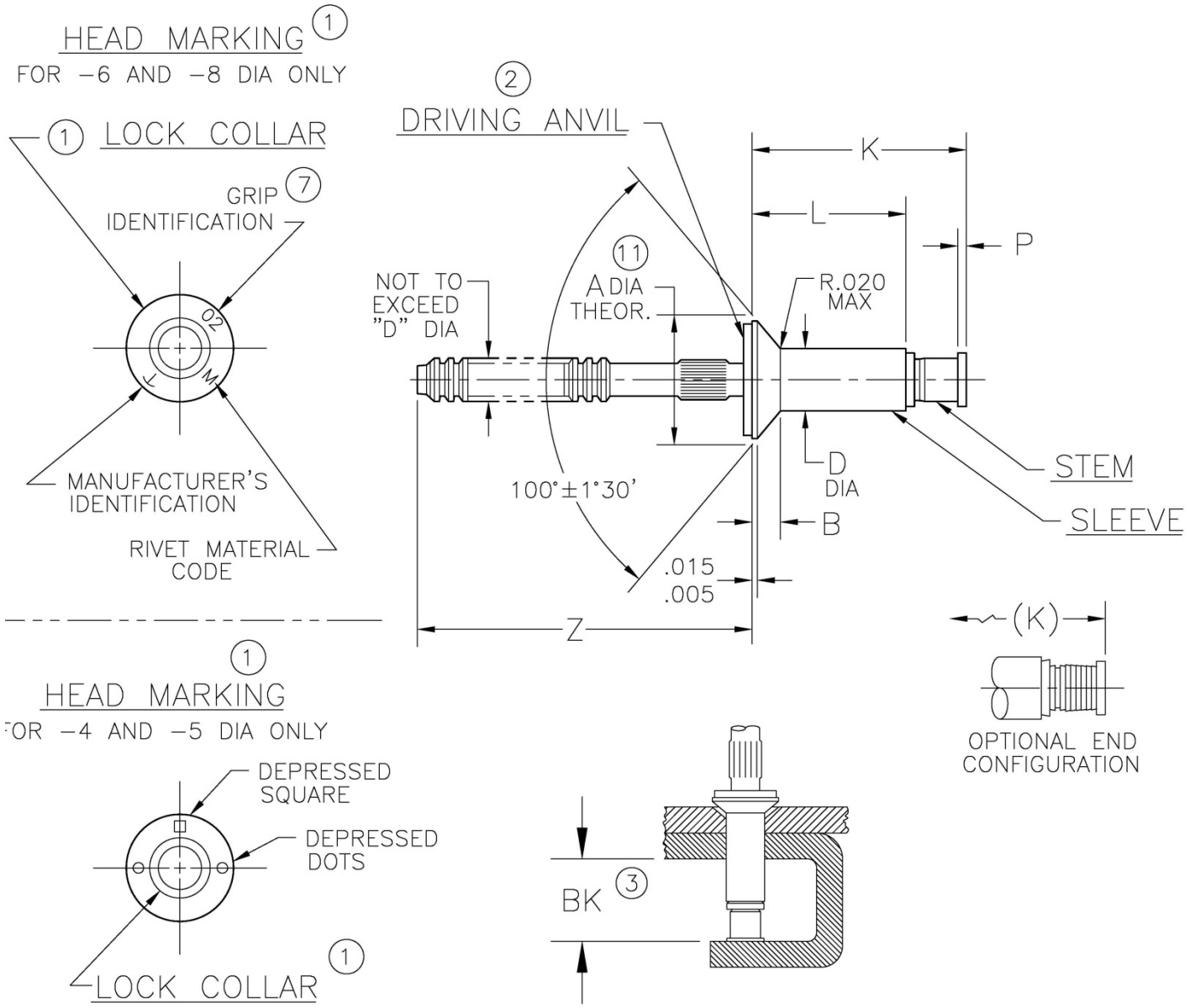


TABLE I

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	.196
-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:	CHERRYMAX® RIVET	SHEET 1 OF 4		PART NUMBER
PS-CMR-3000	NOMINAL DIAMETER	ISSUE	03-31-83	CR3524
NAS 523 CODE: SEE TABLE II	NAS 1097 100° FLUSH HEAD	REV. AB	03-23-15	

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	NONE	
P ⑪	AYY				ALUM. COAT PER MIL-DTL-83488		
PR ⑨	- - -				NONE		
GP ⑪⑫	- - -				ALUM. COAT PER MIL-DTL-83488 (SUPPLEMENTAL: MIL-DTL-5541 CL 1A, TYPE II)		
GEE ⑪⑫	- - -				ALUM. COAT PER NAS 4006 CLASS NC		

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

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.

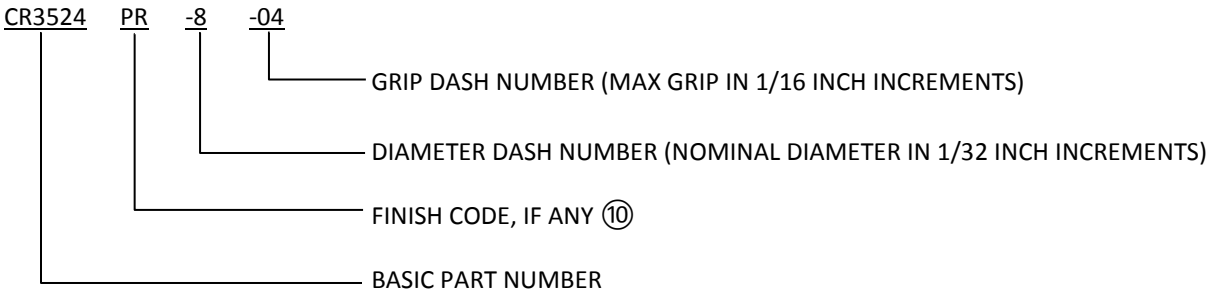
⑨ "PR" CODE – PARTS ARE MANUFACTURED BARE; IF LUBE IS REQUIRED, USE PAR 90 ONLY. IN ADDITION, MANUFACTURER'S OPTION TO APPLY MOLYBDENUM DISULFIDE TYPE I PER AS5272 TO STEM ONLY.

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:



STANDARDS PAGE REVISION LOG

REV LTR	DATE	DCR NUMBER	REVISION DESCRIPTION	COMP. BY
AB	03-23-15	14-1290	• ADDED REACH COMPLIANT COATING GP, GEE • ADDED NOTE 12 • GENERAL CLEANUP AND STANDARDIZATION	CL