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HEAD MARKING

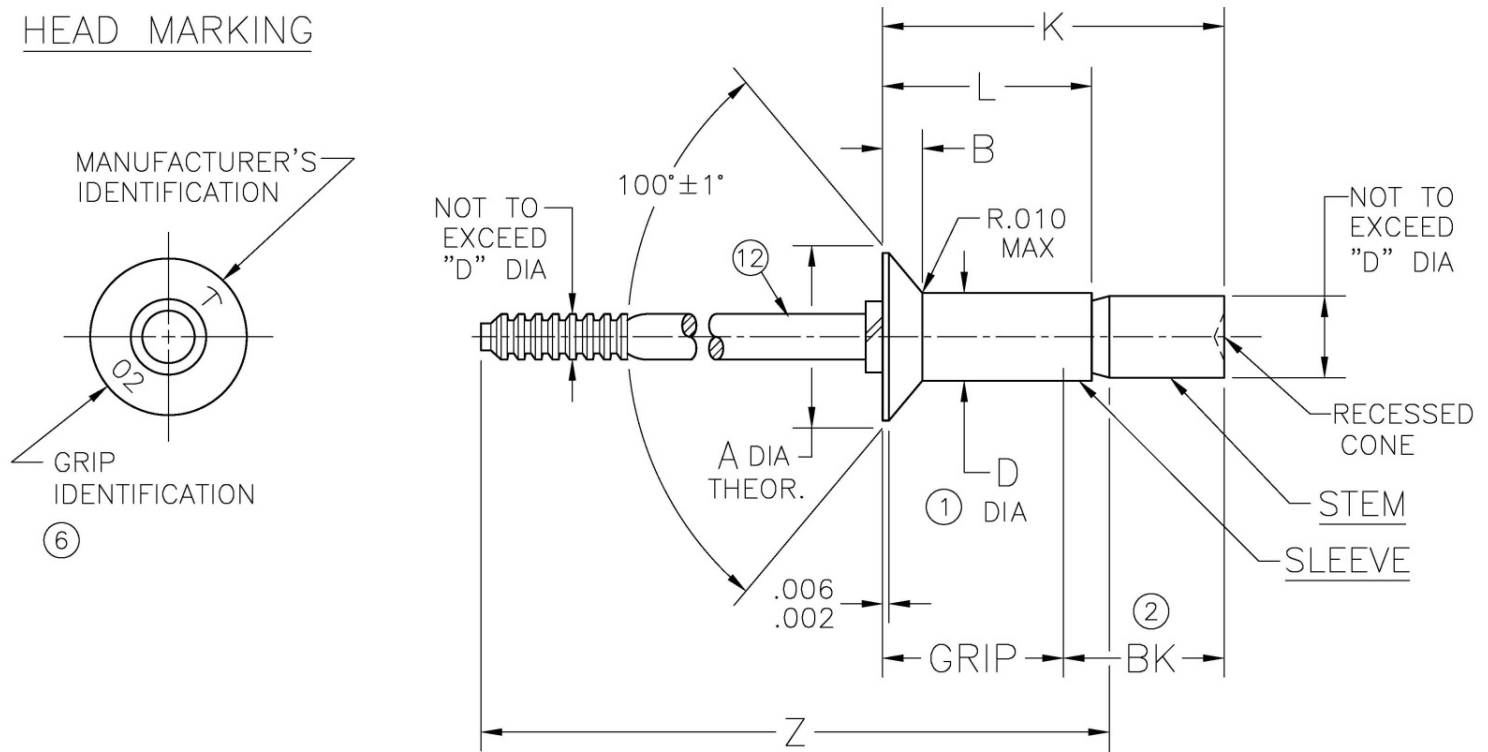


TABLE I

DIA. DASH NO.	A ±.004	B REF	D +.003 -.001	Z REF			HOLE LIMITS	
				A GROUP	B GROUP	C GROUP	MIN	MAX
-4	.225	.042	.125	1.79	---	---	.129	.132
-5	.286	.055	.156	1.81	2.06	---	.160	.164
-6	.353	.070	.187	1.85	2.10	2.35	.192	.196
-8	.476	.095	.250	1.97	2.22	2.47	.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-SHIPED CONDITION OR INSTALLED IN CONDITIONS OTHER THAN SPECIFIED HEREIN.

PROCUREMENT SPECIFICATION: NAS1400 NAS 523 CODE: SEE TABLE II	CHERRYLOCK® RIVET WIREDRAW 100° FLUSH HEAD	SHEET 1 OF 3		PART NUMBER	
		ISSUE	05-12-82		CR2162
		REV.	Y	5-27-15	



TABLE II

FINISH CODE	NAS 523 CODE	MATERIAL ③			FINISH		
		SLEEVE	STEM	LOCK RING	SLEEVE	STEM	LOCK RING ⑦
---	RP	2017-T4 PER QQ-A-430	7075 PER QQ-A-430	5056-H38 PER QQ-A-430	CHEM. FILM PER MIL-DTL-5541	CHEM. FILM PER MIL-DTL-5541	NONE
A	ASH				ANODIZE PER MIL-A-8625	ANODIZE PER MIL-A-8625	
V	---				CHEM. FILM PER MIL-DTL-5541	CHEM. FILM PER MIL-DTL-5541	
PR ⑩	---				CHEM. FILM PER MIL-DTL-5541	CHEM. FILM PER MIL-DTL-5541	
G ⑬	---				CHEM. FILM PER MIL-DTL-5541 CL 1A, TYPE II	CHEM. FILM PER MIL-DTL-5541 CL 1A, TYPE II	
GPR ⑩ ⑬	---						

TABLE III

GRIP DASH NO. ⑥	GRIP RANGE		RIVET GROUP ④	-4 DIAMETER			-5 DIAMETER			-6 DIAMETER			-8 DIAMETER		
	MIN	MAX		L MAX	K MAX	BK	L MAX	K MAX	BK	L MAX	K MAX	BK	L MAX	K MAX	BK
-02	⑤	.125	A	.260	.45	.30	.263	.44	.28	.287	.48	.26	---	---	---
-03	.126	.187		.323	.57	.35	.326	.56	.34	.350	.60	.32	.385	.63	.37
-04	.188	.250		.385	.69	.41	.388	.67	.39	.412	.72	.37	.448	.75	.43
-05	.251	.312		.448	.81	.46	.451	.79	.45	.475	.83	.43	.510	.87	.48
-06	.313	.375		.510	.93	.52	.513	.91	.50	.537	.95	.48	.573	.99	.54
-07	.376	.437		.573	1.05	.57	.576	1.03	.56	.600	1.07	.54	.635	1.11	.60
-08	.438	.500		.635	1.17	.63	.638	1.15	.62	.662	1.19	.60	.698	1.23	.65
-09	.501	.562		.698	1.29	.68	.701	1.27	.67	.725	1.31	.65	.760	1.34	.71
-10	.563	.625		---	---	---	.763	1.44	.78	.787	1.48	.76	.823	1.52	.82
-11	.626	.687	B	---	---	---	---	---	.850	1.60	.82	.885	1.64	.88	
-12	.688	.750		---	---	---	---	---	.912	1.72	.88	.948	1.77	.94	
-13	.751	.812		---	---	---	---	---	.975	1.83	.94	1.010	1.89	1.00	
-14	.813	.875	C	---	---	---	---	---	1.037	1.95	1.00	1.073	2.01	1.06	

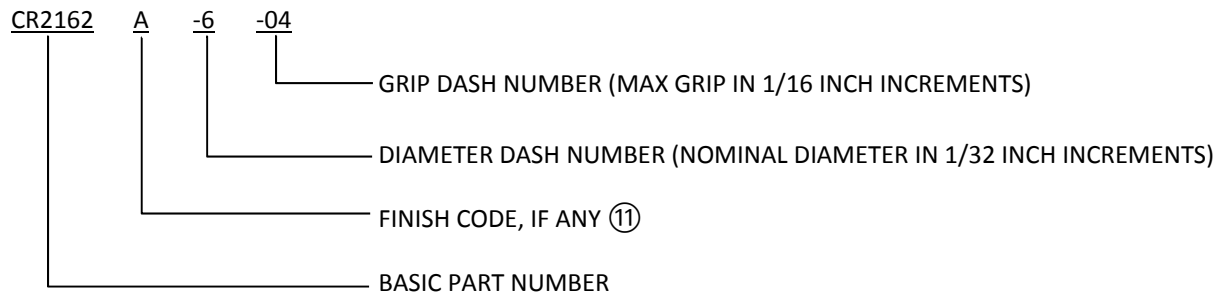
SHEET 2 OF 3		PART NUMBER
ISSUE	05-12-82	
REV.	Y	5-27-15
CR2162		



NOTES:

- ① AN INCREASE OF .001 PERMISSIBLE WITHIN 0.100 OF BASE OF HEAD.
- ② MINIMUM BLIND SIDE CLEARANCE FOR SATISFACTORY INSTALLATION.
- ③ MATERIAL DESIGNATION REFERS TO CHEMICAL COMPOSITION ONLY.
- ④ RIVET GROUP REFERS TO SHIFT-POINT SETTING OF RIVETER.
- ⑤ MINIMUM GRIP FOR -4 DIA IS .063, FOR -5 DIA IS .065 AND FOR -6 DIA IS .080.
- ⑥ SINGLE DIGIT MARKING IS PERMISSIBLE, AT MANUFACTURER'S OPTION, FOR GRIP DASH (-) NUMBERS LESS THAN 10.
- ⑦ MAY HAVE BEIGE COLOR TO IDENTIFY 5056 MATERIAL.
8. DO NOT CLEAN OR DEGREASE PRIOR TO INSTALLATION.
9. SHEET THICKNESS FOR MACHINE COUNTERSUNK HOLES SHALL NOT BE LESS THAN "B" + .010.
- ⑩ "PR" CODE – IF LUBRICATION IS REQUIRED, USE PAR 90 ONLY.
- ⑪ FINISH CODES MAY BE COMBINED. EXAMPLE "APR" = CHEM FILM COATED SLEEVE WITH "PR" LUBRICATION RESTRICTION. WHEN COMBINING FINISH CODES PLACE PLATING OR COATING CODE BEFORE LUBRICATION CODE.
- ⑫ STEM GEOMETRY IN THIS AREA MAY BE SMOOTH OR KNURLED.
- ⑬ FINISH CODES WITH PREFIX "G" INDICATE REACH COMPLIANT COATING

EXAMPLE OF CHERRY PART NUMBER:



SHEET 3 OF 3		PART NUMBER
ISSUE	05-12-82	CR2162
REV.	Y 5-27-15	

STANDARDS PAGE REVISION LOG CR2162

REV LTR	DATE	DCR NUMBER	REVISION DESCRIPTION	COMP. BY
Y	5-27-15	14-1284	<ul style="list-style-type: none">• ADDED REACH COMPLIANT COATING G, GPR• ADDED NOTE 13• GENERAL CLEANUP AND STANDARDIZATION	AD