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HEAD MARKING

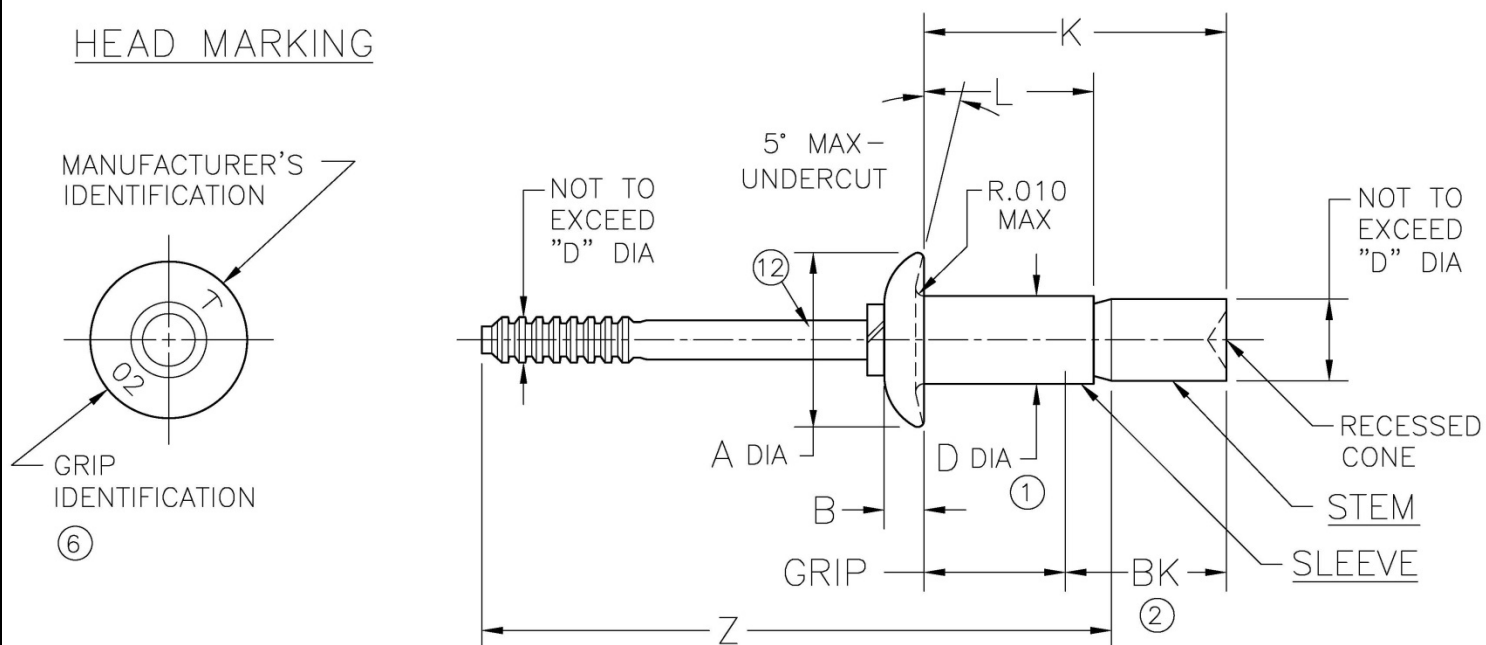


TABLE I

DIA. DASH NO.	A	B +.010 -.000	D +.003 -.001	Z REF			HOLE LIMITS	
				A GROUP	B GROUP	C GROUP	MIN	MAX
-4	.238-.262	.054	.125	1.79	---	---	.129	.132
-5	.296-.328	.067	.156	1.81	2.06	---	.160	.164
-6	.356-.394	.080	.187	1.85	2.10	---	.192	.196
-8	.475-.525	.107	.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-SHIPPED CONDITION OR INSTALLED IN CONDITIONS OTHER THAN SPECIFIED HEREIN.

PROCUREMENT SPECIFICATION:

NAS1400

NAS 523 CODE: SEE TABLE II

CHERRYLOCK® RIVET
WIREDRAW
UNIVERSAL HEAD

SHEET 1 OF 3

ISSUE

05-12-82

REV.

W

5-27-15

PART NUMBER

CR2163



TABLE II

FINISH CODE	NAS 523 CODE	MATERIAL ③			FINISH		
		SLEEVE	STEM	LOCK RING	SLEEVE	STEM	LOCK RING ⑦
---	RL	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	ASJ				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 CL 1A, TYPE II	CHEM. FILM PER MIL-DTL-5541 CL 1A, TYPE II	
G ⑬	---						
GPR ⑩ ⑬	---						

TABLE III

GRIP DASH NO. ⑥	GRIP RANGE		RIVET GROUP ④	-4 DIAMETER ⑨			-5 DIAMETER ⑨			-6 DIAMETER ⑨			-8 DIAMETER ⑨		
	MIN	MAX		L MAX	K MAX	BK	L MAX	K MAX	BK	L MAX	K MAX	BK	L MAX	K MAX	BK
-01	⑤	.062	A	.198	.39	.30	.201	.38	.28	.225	.44	.27	---	---	---
-02	.063	.125		.260	.51	.35	.263	.49	.34	.287	.55	.32	.323	.57	.37
-03	.126	.187		.323	.63	.41	.326	.61	.39	.350	.67	.37	.385	.69	.43
-04	.188	.250		.385	.75	.46	.388	.73	.45	.412	.79	.43	.448	.81	.48
-05	.251	.312		.448	.87	.52	.451	.85	.50	.475	.91	.48	.510	.93	.54
-06	.313	.375		.510	.98	.57	.513	.97	.56	.537	1.03	.54	.573	1.04	.60
-07	.376	.437		.573	1.11	.63	.576	1.09	.62	.600	1.15	.60	.635	1.16	.65
-08	.438	.500		.635	1.23	.69	.638	1.20	.67	.662	1.27	.65	.698	1.28	.71
-09	.501	.562	B	---	---	---	.701	1.38	.78	.725	1.44	.76	.760	1.46	.82
-10	.563	.625		---	---	---	.763	1.50	.84	.787	1.56	.82	.823	1.58	.88
-11	.626	.687		---	---	---	---	---	---	.850	1.68	.88	.885	1.70	.94
-12	.688	.750		---	---	---	---	---	---	.912	1.81	.94	.948	1.83	1.00
-13	.751	.812	C	---	---	---	---	---	---	.948	1.94	.99	1.010	1.95	1.06
-14	.813	.875		---	---	---	---	---	---	---	---	---	1.073	2.07	1.12

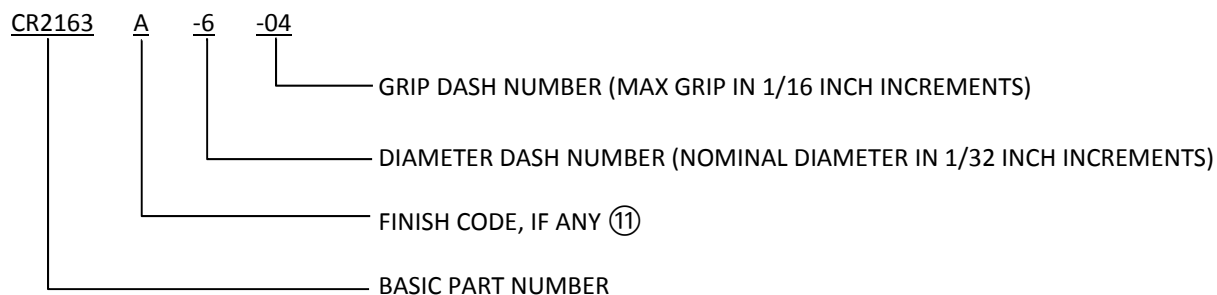
SHEET 2 OF 3			PART NUMBER	
ISSUE	05-12-82		CR2163	
REV.	W	5-27-15		



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 .025, FOR -5 DIA IS .031 AND FOR -6 DIA IS .037.
- 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 SIZES BELOW HEAVY LINES ARE NOT COVERED BY NAS1398, AND MANUFACTURED BY SPECIAL ORDER ONLY.
- 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		CR2163
REV.	W	5-27-15	

STANDARDS PAGE REVISION LOG CR2163

REV LTR	DATE	DCR NUMBER	REVISION DESCRIPTION	COMP. BY
W	5-27-15	14-1284	• ADDED REACH COMPLIANT COATING G, GPR • ADDED NOTE 13 • GENERAL CLEANUP AND STANDARDIZATION	CL