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# HEAD MARKING

(NOT REQUIRED ON -.3 DIA)

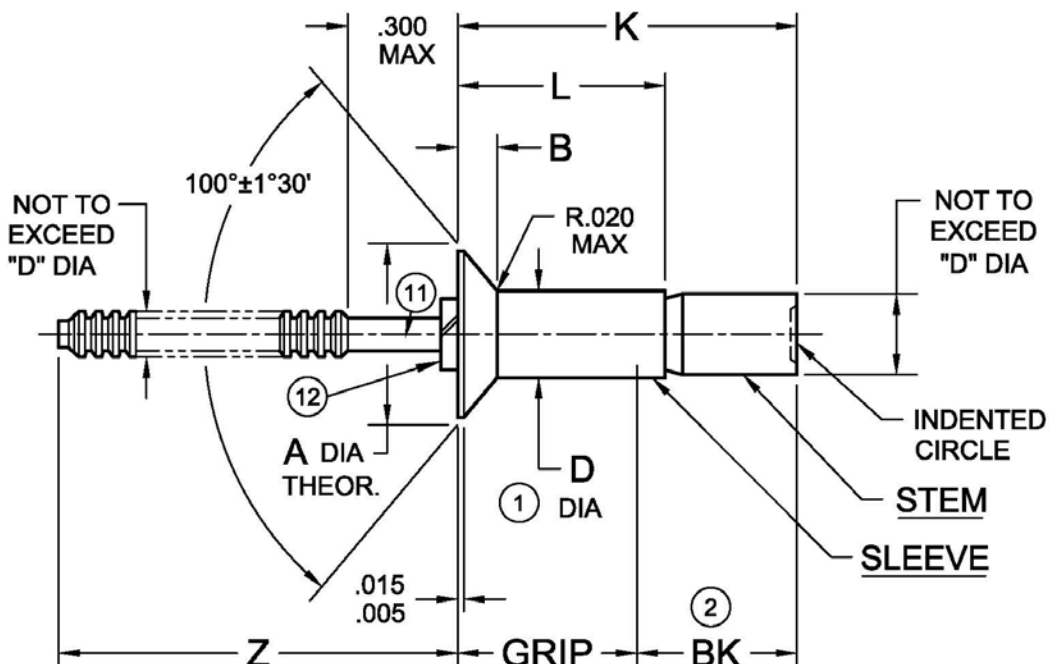
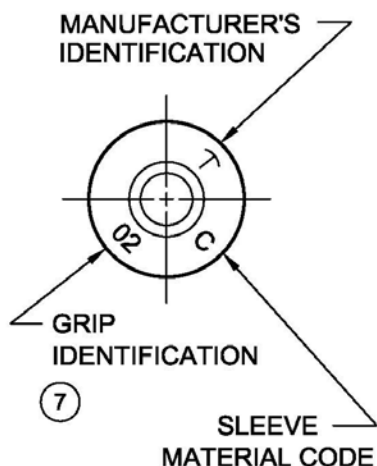


TABLE I

DIA. DASH NO.	A ±.004	B REF	D +.003 -.001	Z MIN	HOLE LIMITS	
					MIN	MAX
-3	.179	.036	.094	.750	.097	.100
-4	.225	.042	.125	---	.129	.132
-5	.286	.055	.156	---	.160	.164
-6	.353	.070	.187	---	.192	.196
-8	.476	.095	.250	---	.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<sup>®</sup> 'A' RIVET**  
WIREDRAW-NOMINAL  
100° FLUSH HEAD

SHEET 1 OF 3

ISSUE

9-10-87

REV.

AB

10-14-15

PART NUMBER

**CR2672**



TABLE II

FINISH CODE	NAS 523 CODE	MATERIAL ③			FINISH		
		SLEEVE	STEM	LOCK RING	SLEEVE	STEM	LOCK RING
---	ACX	A-286 CRES PER AMS 5731, 5732, 5737	A-286 CRES PER AMS 5731	MONEL PER QQ-N-281	PASSIVATE PER AMS 2700	PASSIVATE PER AMS 2700	NONE
CW	AFE				CAD PLATE PER QQ-P-416 TYPE II, CL 2		
EE	---				ALUM COAT PER NAS 4006		
FA ⑬	---				DRY FILM LUBE PER SAE AS5272 TYPE I		
S	AFF				SILVER PLATE PER ASTM B700		
GEE ⑭	---				ALUM COAT PER NAS 4006 CLASS NC		

TABLE III

GRIP DASH NO. ⑦	GRIP RANGE		- 3 DIAMETER			-4 DIAMETER			-5 DIAMETER			-6 DIAMETER			-8 DIAMETER			
	MIN	MAX	L	K	BK	L	K	BK	L	K	BK	L	K	BK	L	K	BK	
			MAX	MAX	②	MAX	MAX	②	MAX	MAX	②	MAX	MAX	②	MAX	MAX	②	
-02	④	.125	.229	.390	.235	.260	.45	.30	.263	.44	.28	.287	.48	.26	---	---	---	
-03		.126	.187	.291	.505	.288	.323	.57	.35	.326	.56	.34	.350	.60	.32	.385	.63	.37
-04		.188	.250	.354	.620	.340	.385	.69	.41	.388	.67	.39	.412	.72	.37	.448	.75	.43
-05		.251	.312	.416	.735	.393	.448	.81	.46	.451	.79	.45	.475	.83	.43	.510	.87	.48
-06		.313	.375	.479	.850	.445	.510	.93	.52	.513	.91	.50	.537	.95	.48	.573	.99	.54
-07		.376	.437	.542	.965	.498	.573	1.05	.57	.576	1.03	.56	.600	1.07	.54	.635	1.11	.60
-08		.438	.500	.605	1.080	.550	.636	1.17	.62	.638	1.15	.62	.662	1.19	.60	.698	1.23	.65
-09		.501	.562	.668	1.195	.603	.698	1.29	.68	.701	1.27	.67	.725	1.31	.65	.760	1.34	.71
-10		.563	.625	.731	1.320	.655	---	---	---	.763	1.44	.78	.787	1.48	.76	.823	1.52	.82
-11		.626	.687	.793	1.440	.708	---	---	---	---	---	---	.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	---	---	---	---	---	---	---	---	---	1.037	1.95	1.00	1.073	2.01	1.06

SHEET 2 OF 3

PART NUMBER

ISSUE 9-10-87

REV. AB 10-14-15

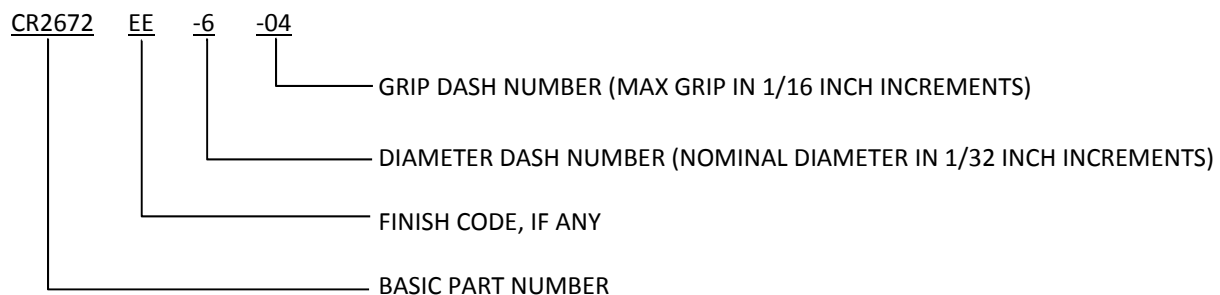
CR2672



## NOTES:

- ① AN INCREASE OF .001 PERMISSIBLE WITHIN .100 OF BASE OF HEAD.
- ② MINIMUM BLIND SIDE CLEARANCE FOR SATISFACTORY INSTALLATION.
- ③ MATERIAL DESIGNATION REFERS TO CHEMICAL COMPOSITION ONLY.
- ④ MINIMUM GRIP FOR -3 AND -4 DIAMETERS IS .063, FOR -5 DIAMETER IS .065 AND FOR -6 DIAMETER IS .080.
5. SHEET THICKNESS FOR MACHINE COUNTERSUNK HOLES SHALL NOT BE LESS THAN "B" + .010.
6. SIZES BELOW HEAVY LINES ARE MANUFACTURED ONLY ON REQUEST.
- ⑦ SINGLE DIGIT MARKING IS PERMISSIBLE, AT MANUFACTURER'S OPTION, FOR GRIP DASH (-) NUMBERS LESS THAN 10.
8. THIS PRODUCT MEETS THE REQUIREMENTS FOR NAS 1399C( )A( ) AND NAS 1400.
9. RECOMMENDED MINIMUM BLIND SIDE MATERIAL AND THICKNESS:  
MATERIAL: 7075 ALUMINUM OR STRONGER  
THICKNESS: 1/3 DIAMETER MINIMUM
10. UNLESS OTHERWISE SPECIFIED, PARTS MAY BE BARE OR LUBRICATED AT THE MANUFACTURER'S OPTION TO ASSURE PROPER FUNCTION OF THE BLIND RIVET. THE LUBRICANT USED SHALL PASS THE LUBRICANT COATING CORROSION TEST PER NAS 1400.
- ⑪ STEM GEOMETRY IN THIS AREA MAY BE SMOOTH OR KNURLED.
- ⑫ LOCK COLLAR MAY BE SOLID OR SPLIT.
- ⑬ "FA" -3 DIAMETER RIVETS MAY BE USED ON DRY APPLICATIONS PER NAS1400 OR WET APPLICATIONS USING SEALANT P/S 870B-2.
- ⑭ FINISH CODES WITH PREFIX "G" INDICATE REACH COMPLIANT COATING.

## EXAMPLE OF CHERRY PART NUMBER:



SHEET 3 OF 3			PART NUMBER
ISSUE	9-10-87		CR2672
REV.	AB	10-14-15	

**STANDARDS PAGE REVISION LOG      CR2672**

REV LTR	DATE	DCR NUMBER	REVISION DESCRIPTION	COMP. BY
AB	10-14-15	15-1048	• ADDED "Z" DIMENSION	MC