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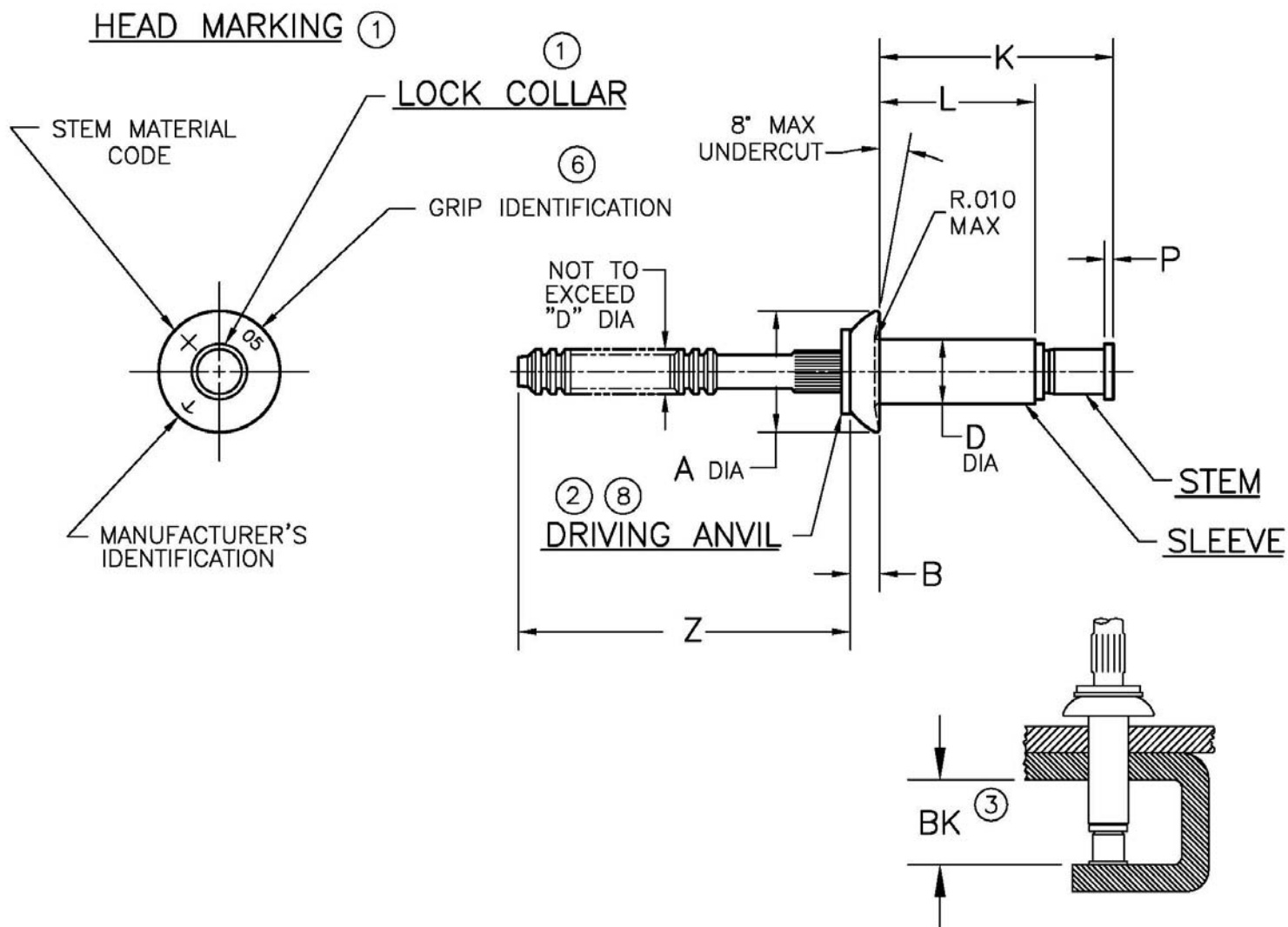


TABLE I

| DIA.<br>DASH<br>NO. | A<br>±.010 | B<br>+.010<br>-.000 | D<br>+.003<br>-.001 | P<br>MIN | Z<br>REF | BK<br>MIN | HOLE LIMITS |      |
|---------------------|------------|---------------------|---------------------|----------|----------|-----------|-------------|------|
|                     |            |                     |                     |          |          |           | MIN         | MAX  |
| -4                  | .250       | .054                | .126                | .010     | .87      | .355      | .129        | .132 |
| -5                  | .312       | .067                | .157                | .015     | .94      | .370      | .160        | .164 |
| -6                  | .375       | .080                | .189                |          |          | .415      | .192        | .196 |
| -8                  | .500       | .107                | .253                |          |          | .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

**CHERRYMAX<sup>®</sup> RIVET**  
NOMINAL DIAMETER  
UNIVERSAL HEAD

SHEET 1 OF 4

PART NUMBER

ISSUE

02-16-82

REV.

AH

5-20-15

**CR3223**



TABLE II

| FINISH<br>CODE | NAS 523<br>CODE | MATERIAL ⑤                |                              |                                          | FINISH                                                             |                                                       |                           |
|----------------|-----------------|---------------------------|------------------------------|------------------------------------------|--------------------------------------------------------------------|-------------------------------------------------------|---------------------------|
|                |                 | SLEEVE                    | STEM                         | LOCK COLLAR                              | SLEEVE                                                             | STEM                                                  | LOCK COLLAR               |
| ---            | AYE             | 5056 ALUM PER<br>QQ-A-430 | 15-7 PH CRES<br>PER AMS 5657 | A-286 CRES PER<br>AMS 5731 &<br>AMS 5737 | CHEM. FILM<br>PLAIN COLOR<br>PER<br>MIL-DTL-5541                   | PASSIVATE PER<br>AMS 2700                             | PASSIVATE PER<br>AMS 2700 |
| CF             | ---             |                           |                              |                                          |                                                                    | PASSIVATE PER<br>AMS 2700 &<br>DICRONITE DL-5         |                           |
| DL<br>⑧        | ---             |                           |                              |                                          |                                                                    | PASSIVATE PER<br>AMS 2700                             |                           |
| PR<br>⑦        | ---             |                           |                              |                                          |                                                                    | TUNGSTEN<br>DISULFIDE OR<br>PASSIVATE PER<br>AMS 2700 |                           |
| TD             | ---             |                           |                              |                                          |                                                                    | CAD. PLATE PER<br>QQ-P-416<br>TYPE I, CL 2            |                           |
| V              | ---             |                           |                              |                                          | ANODIZE LIGHT<br>GREEN PER<br>MIL-A-8625                           | PASSIVATE PER<br>AMS 2700                             |                           |
| G<br>⑨         | ---             |                           |                              |                                          | CHEM. FILM<br>PLAIN COLOR<br>PER<br>MIL-DTL-5541<br>CL 1A, TYPE II | PASSIVATE PER<br>AMS 2700 &<br>DICRONITE DL-5         |                           |
| GCF<br>⑨       | ---             |                           |                              |                                          |                                                                    | PASSIVATE PER<br>AMS 2700                             |                           |
| GDL<br>⑧⑨      | ---             |                           |                              |                                          |                                                                    | TUNGSTEN<br>DISULFIDE OR<br>PASSIVATE PER<br>AMS 2700 |                           |
| GPR<br>⑦⑨      | ---             |                           |                              |                                          |                                                                    |                                                       |                           |
| GTD<br>⑧⑨      | ---             |                           |                              |                                          |                                                                    |                                                       |                           |

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TABLE III

| GRIP<br>DASH<br>NO. | GRIP RANGE |      | -4 DIA              |          | -5 DIA              |          | -6 DIA              |          | -8 DIA              |          |
|---------------------|------------|------|---------------------|----------|---------------------|----------|---------------------|----------|---------------------|----------|
|                     | MIN        | MAX  | L<br>+.000<br>-.030 | K<br>MAX | L<br>+.000<br>-.030 | K<br>MAX | L<br>+.000<br>-.030 | K<br>MAX | L<br>+.000<br>-.030 | K<br>MAX |
| -01                 | ④          | .062 | .161                | .38      | .187                | .41      | .219                | .47      | ---                 | ---      |
| -02                 | .063       | .125 | .224                | .45      | .230                | .47      | .262                | .51      | .313                | .59      |
| -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     |

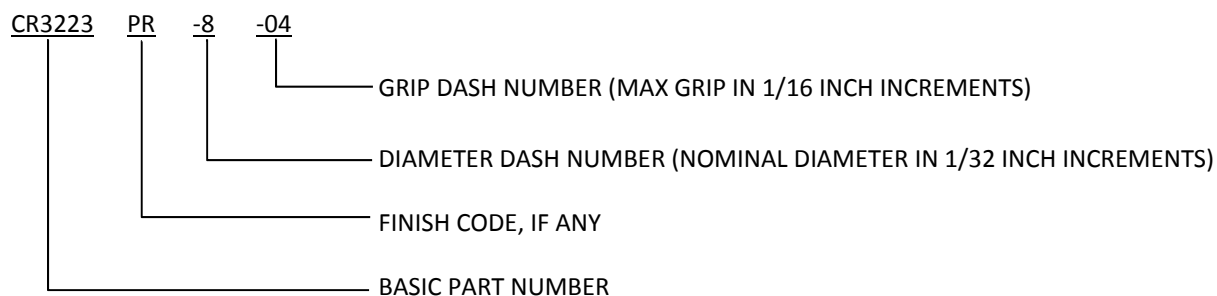
| SHEET 3 OF 4 |          |         | PART NUMBER |  |
|--------------|----------|---------|-------------|--|
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## NOTES:

- 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 -4 DIA. IS .025; FOR -5 IS .031; AND FOR -6 IS .037.
- ⑤ MATERIAL DESIGNATION REFERS TO CHEMICAL COMPOSITION ONLY.
- ⑥ SINGLE DIGIT HEAD MARKING IS PERMISSIBLE, AT MANUFACTURER'S OPTION, FOR GRIP DASH NUMBERS LESS THAN 10.
- ⑦ "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.
- 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 FINISH CODES WITH THE PREFIX "G" INDICATE REACH COMPLIANT COATING.

## EXAMPLE OF CHERRY PART NUMBER:



| SHEET 4 OF 4 |          |         | PART NUMBER |
|--------------|----------|---------|-------------|
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## STANDARDS PAGE REVISION LOG

| REV LTR | DATE    | DCR<br>NUMBER | REVISION DESCRIPTION                                                                             | COMP.<br>BY |
|---------|---------|---------------|--------------------------------------------------------------------------------------------------|-------------|
| AH      | 5-20-15 | 15-0398       | <ul style="list-style-type: none"><li>CORRECTED NOTE CALLOUTS ON PART GRAPHICS, PAGE 1</li></ul> | MC          |