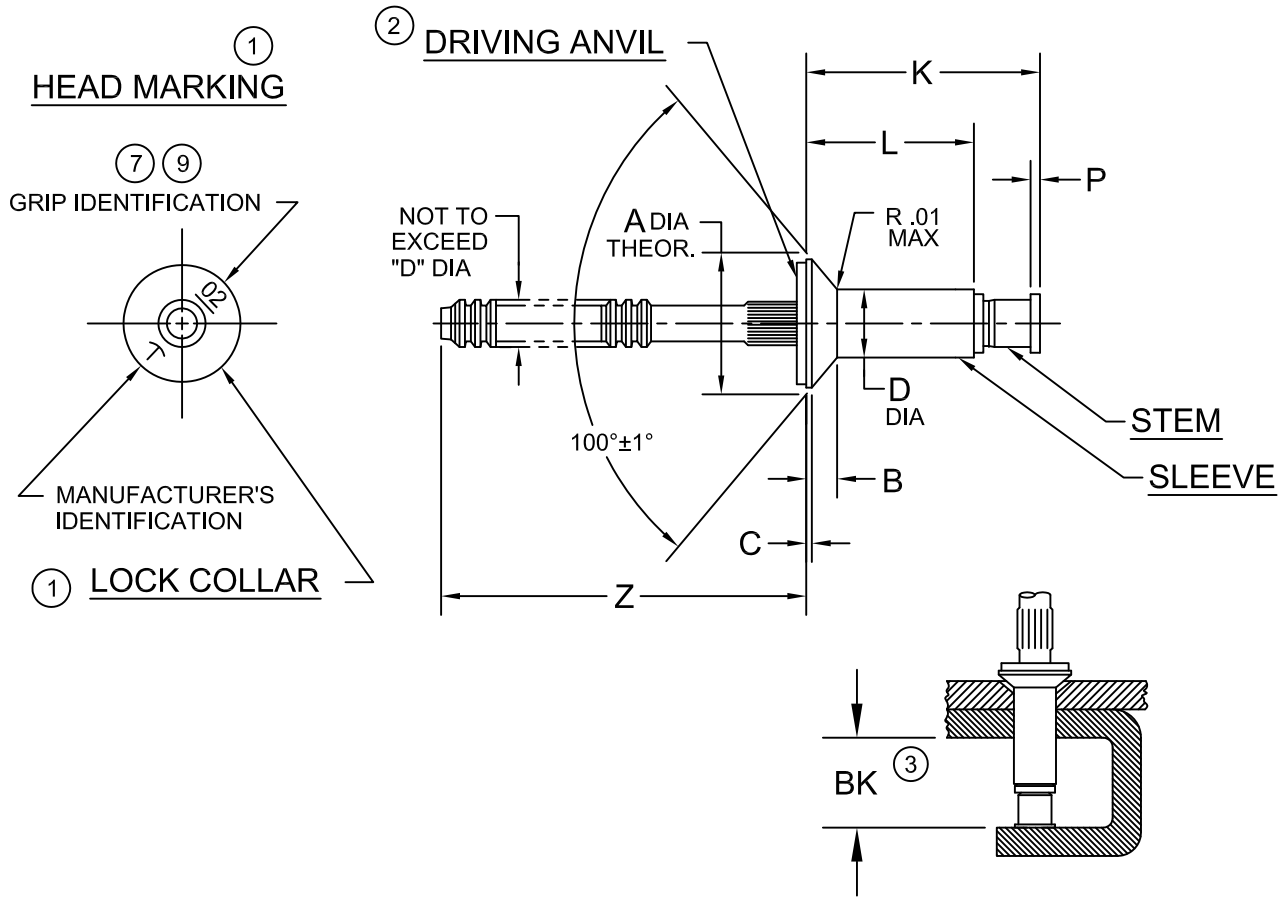




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DIA. DASH NO.	A	B	C	D	P	Z	BK	HOLE LIMITS	
	±.004	REF		+0.003 -.001	MIN	MIN	MIN	MIN	MAX
-4	.225	.035	.002-.006	.140	.010	.87	.390	.143	.146
-5	.286	.047	.002-.006	.173	.015	.94	.395	.176	.180
-6	.353	.063	.002-.006	.201	.015	.94	.410	.205	.209
-8	.476	.086	.002-.016	.267	.015	.96	.490	.271	.275

SEE SHEET 2 FOR LENGTH DIMENSIONS, MATERIALS AND FINISHES

SEE SHEET 3 FOR NOTES AND PART NUMBER EXAMPLE

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 :	<b>CHERRYMAX® RIVET</b> 100° FLUSH HEAD LOCKED SPINDLE (OVERSIZE)	SHEET 1 OF 3	PART NUMBER
PS-CMR-3000		ISSUE	06-24-92
NAS 523 CODE : SEE SHEET 2		REV. AE	07-24-14



GRIP DASH NO.	GRIP LIMITS		-4 DIA		-5 DIA		-6 DIA		-8 DIA	
			L	K	L	K	L	K	L	K
	MIN	MAX	+ .000 - .030	MAX	+ .000 - .030	MAX	+ .000 - .030	MAX	+ .000 - .030	MAX
-01	.045	.062	.200	.45	-	-	-	-	-	-
-02	④	.125	.238	.45	.266	.47	.265	.48	-	-
-03	.126	.187	.301	.52	.309	.53	.328	.55	.375	.64
-04	.188	.250	.363	.58	.371	.60	.390	.62	.437	.70
-05	.251	.312	.426	.65	.434	.66	.453	.68	.500	.77
-06	.313	.375	.488	.71	.496	.72	.515	.74	.562	.83
-07	.376	.437	.551	.78	.559	.79	.578	.82	.625	.89
-08	.438	.500	.613	.84	.621	.85	.640	.89	.687	.95
-09	.501	.562	.676	.90	.684	.91	.703	.95	.750	1.02
-10	.563	.625	-	-	.746	.98	.765	1.01	.812	1.08
-11	.626	.687	-	-	.809	1.04	.828	1.07	.875	1.14
-12	.688	.750	-	-	.871	1.10	.890	1.14	.937	1.20
-13	.751	.812	-	-	-	-	-	-	1.000	1.27
-14	.813	.875	-	-	-	-	-	-	1.062	1.60

FINISH CODE	NAS 523 CODE	MATERIAL ⑤			FINISH		
		SLEEVE	STEM	LOCK COLLAR	SLEEVE	STEM	LOCK COLLAR
--	ARD	5056 ALUM. PER QQ-A-430	8740 STEEL PER AMS 6322	A-286 CRES PER AMS 5731 & AMS 5737	CHEM. FILM PLAIN COLOR PER MIL-C-5541	CAD. PLATE PER QQ-P-416 TYPE II, CL.2	PASSIVATE PER AMS 2700
A	--	5056 ALUM. PER QQ-A-430	8740 STEEL PER AMS 6322	A-286 CRES PER AMS 5731 & AMS 5737	CHEM. FILM GOLD COLOR PER MIL-C-5541	CAD. PLATE PER QQ-P-416 TYPE II, CL.2	PASSIVATE PER AMS 2700
⑩ PR	--	5056 ALUM. PER QQ-A-430	8740 STEEL PER AMS 6322	A-286 CRES PER AMS 5731 & AMS 5737	CHEM. FILM PLAIN COLOR PER MIL-C-5541	CAD. PLATE PER QQ-P-416 TYPE II, CL.2	PASSIVATE PER AMS 2700
⑧ T	--	5056 ALUM. PER QQ-A-430	8740 STEEL PER AMS 6322	A-286 CRES PER AMS 5731 & AMS 5737	CHEM. FILM PLAIN COLOR PER MIL-C-5541	CAD. PLATE PER QQ-P-416 TYPE II, CL.2	PASSIVATE PER AMS 2700

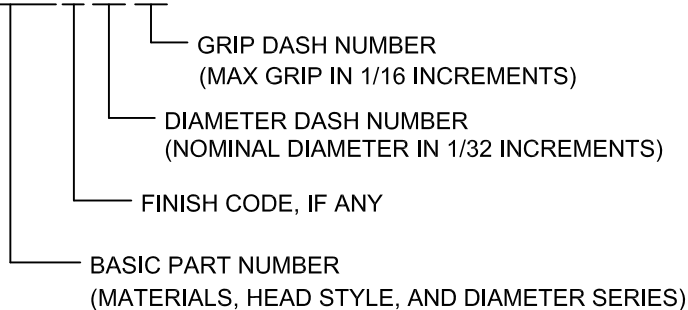
SHEET 2 OF 3		PART NUMBER
ISSUE	06-24-92	
REV.	AE	07-24-14
<b>CR3242</b>		



- NOTES:
- ① HEAD MARKINGS AND LOCK COLLAR VISIBLE AFTER INSTALLATION.
  - ② SILVER COLORED DRIVING ANVIL IDENTIFIES OVERSIZE DIAMETER RIVETS.
  - ③ MINIMUM BLIND SIDE CLEARANCE FOR SATISFACTORY INSTALLATION.
  - ④ MINIMUM GRIP FOR -4 DIA. IS .063; FOR -5 IS .063; AND FOR -6 IS .073.
  - 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 MARKING IS PERMISSIBLE, AT MANUFACTURER'S OPTION, FOR GRIP DASH NUMBERS LESS THAN 10.
  - ⑧ "T" CODE - PARTS ARE MANUFACTURED BARE; IF LUBE IS REQUIRED, USE TRANSLUBE 20204 ONLY. TRANSLUBE ("T" CODE) WILL BE UNAVAILABLE FOR PROCUREMENT AS OF 01-01-92.
  - ⑨ A DASH MAY BE MARKED UNDER OR TO THE RIGHT SIDE OF THE GRIP IDENTIFICATION AT MANUFACTURER'S OPTION.
  - ⑩ "PR" CODE - PARTS ARE MANUFACTURED BARE; IF LUBE IS REQUIRED, USE PAR 90 ONLY.

**PART NUMBER EXAMPLE:**

CR3242 A -5 -05



SHEET 3 OF 3		PART NUMBER
ISSUE	06-24-92	CR3242
REV.	AE 07-24-14	



STANDARDS PAGE REVISION LOG

REV LTR	DATE	DCR NUMBER	REVISION DESCRIPTION	COMP. BY
AE	7-24-14	14-0710	ADDED "P" STEM HEAD THICKNESS TO VIEW AND CHART; ADDED "AND AMS5737" TO LOCK COLLAR MATERIAL CALLOUT	CM