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## HEAD MARKING <sup>①</sup>

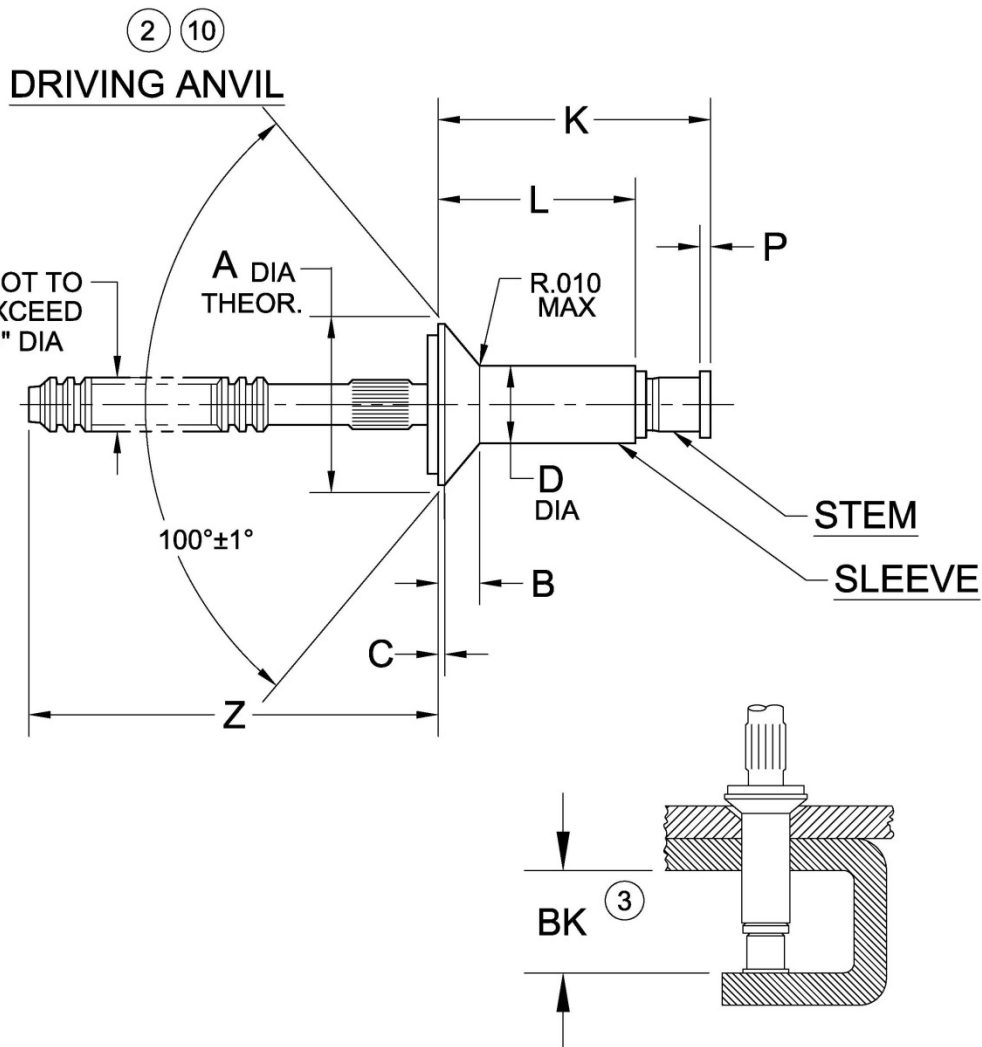
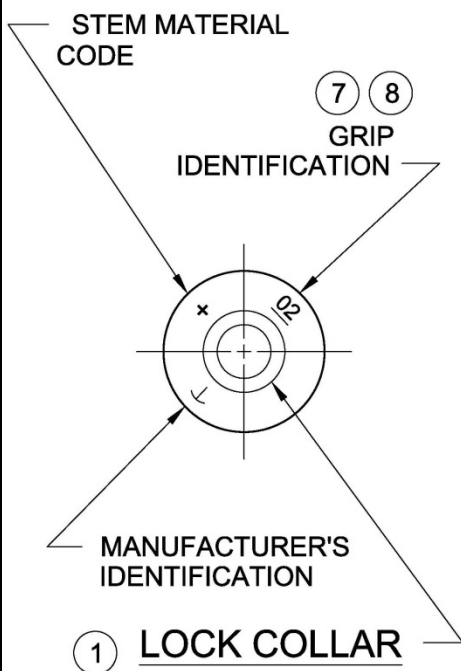


TABLE I

DIA. DASH NO.	A ±.004	B REF	C	D +.003 -.001	P MIN	Z REF	BK MIN	HOLE LIMITS	
								MIN	MAX
-4	.225	.035	.002-.006	.140	.010	.87	.390	.143	.146
-5	.286	.047		.173	.015	.94	.395	.176	.180
-6	.353	.063		.201			.410	.205	.209
-8	.476	.086	.002-.016	.267		.96	.490	.271	.275

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® RIVET**  
OVERSIZE DIAMETER  
100° FLUSH HEAD

SHEET 1 OF 4

ISSUE

06-24-92

REV.

AG

03-23-15

PART NUMBER

**CR3252**



TABLE II

FINISH CODE	NAS 523 CODE	MATERIAL ⑤			FINISH		
		SLEEVE	STEM	LOCK COLLAR	SLEEVE	STEM	LOCK COLLAR
---	ARO OR AYO	5056 ALUM PER QQ-A-430	15-7 PH CRES PER AMS 5657	A-286 CRES PER AMS 5731 & AMS 5737	CHEM. FILM PLAIN COLOR PER MIL-DTL-5541	PASSIVATE PER AMS 2700	PASSIVATE PER AMS 2700
CF	---					PASSIVATE PER AMS 2700 & DICRONITE DL-5	
DL ⑩	---					PASSIVATE PER AMS 2700	
PR ⑨	---				CHEM. FILM PLAIN COLOR PER MIL-DTL-5541 CL 1A, TYPE II	PASSIVATE PER AMS 2700	
G ⑪	---					PASSIVATE PER AMS 2700	
GCF ⑪	---					PASSIVATE PER AMS 2700 & DICRONITE DL-5	
GDL ⑩ ⑪	---					PASSIVATE PER AMS 2700	
GPR ⑨ ⑪	---					PASSIVATE PER AMS 2700	

SHEET 2 OF 4			PART NUMBER
ISSUE	06-24-92		CR3252
REV.	AG	03-23-15	



TABLE III

GRIP DASH NO.	GRIP RANGE		-4 DIA		-5 DIA		-6 DIA		-8 DIA	
	MIN	MAX	L +.000 -.030	K MAX	L +.000 -.030	K MAX	L +.000 -.030	K MAX	L +.000 -.030	K 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	---	---	---	---	.890	1.14	.937	1.20
-13	.751	.812	---	---	---	---	---	---	1.000	1.27
-14	.813	.875	---	---	---	---	---	---	1.062	1.60

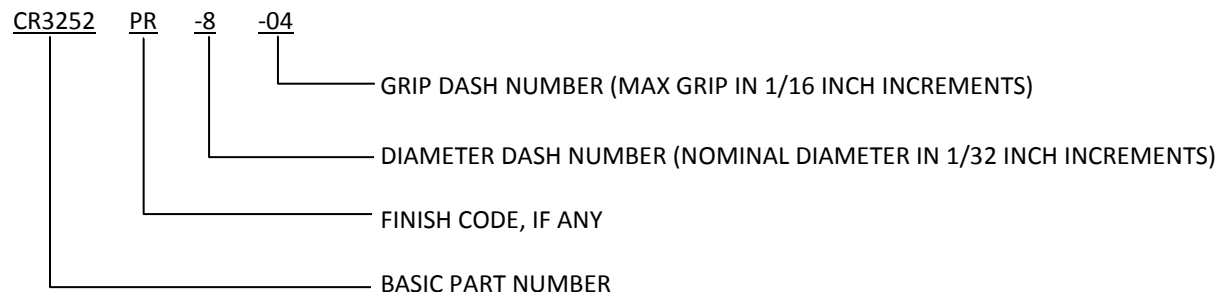
SHEET 3 OF 4			PART NUMBER
ISSUE	06-24-92		CR3252
REV.	AG	03-23-15	



## 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 HEAD MARKING IS PERMISSIBLE, AT MANUFACTURER'S OPTION, FOR GRIP DASH NUMBERS LESS THAN 10.
- ⑧ A DASH MAY BE MARKED UNDER OR TO THE RIGHT OF THE GRIP IDENTIFICATION AT MANUFACTURER'S OPTION.
- ⑨ "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.
- ⑩ "DL" FINISH CODE PARTS HAVE NICKEL PLATED DRIVING ANVILS. LUBRICANTS OTHER THAN DICRONITE DL-5 MAY NOT BE USED. "DL" FINISH MEETS SPECIFICATION DOD-L-85645.
- ⑪ FINISH CODES WITH THE PREFIX "G" INDICATE REACH COMPLIANT COATING.

## EXAMPLE OF CHERRY PART NUMBER:



SHEET 4 OF 4			PART NUMBER
ISSUE	06-24-92		CR3252
REV.	AG	03-23-15	

## STANDARDS PAGE REVISION LOG

REV LTR	DATE	DCR NUMBER	REVISION DESCRIPTION	COMP. BY
AG	03-23-15	14-1290	<ul style="list-style-type: none"><li>• ADDED REACH COMPLIANT COATING G, GCF, GDL, GPR</li><li>• ADDED NOTE 11</li><li>• GENERAL CLEANUP AND STANDARDIZATION</li></ul>	CL