



PRINTED COPIES OF THIS DOCUMENT ARE FOR "REFERENCE" ONLY. CURRENT REVISIONS ARE AVAILABLE ONLINE.

HEAD MARKING

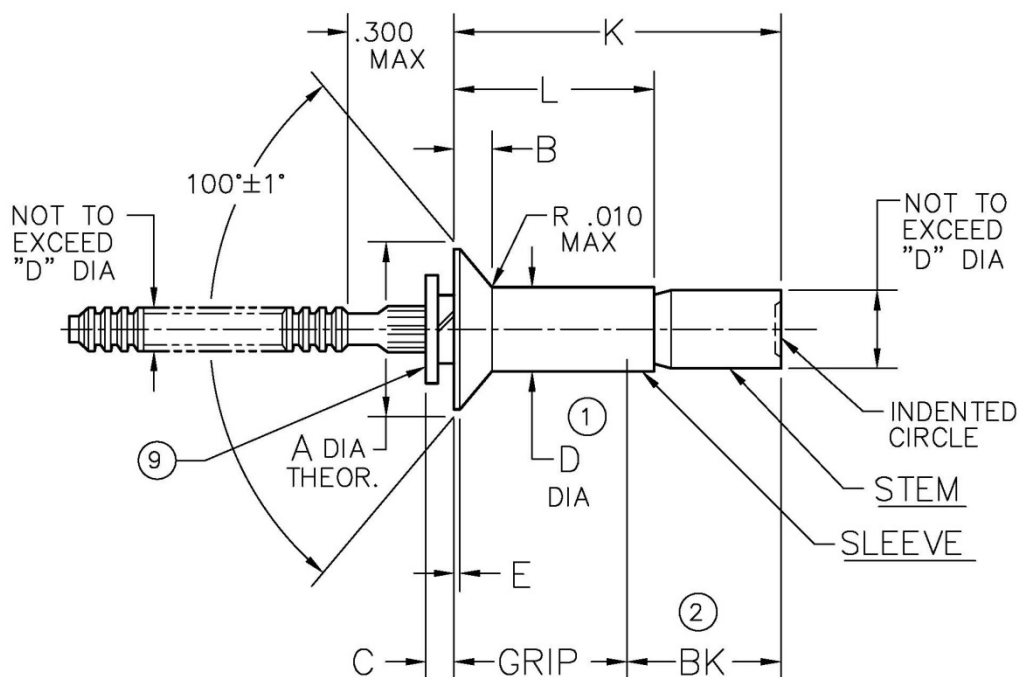
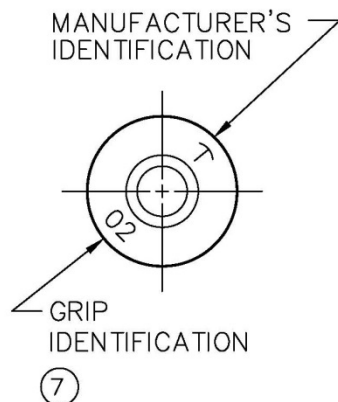


TABLE I

DIA. DASH NO.	A ±.004	B REF	C MAX	D +.003 -.001	E	HOLE LIMITS	
						MIN	MAX
-4	.225	.042	.125	.125	.002-.010	.129	.132
-5	.286	.055	.140	.156	.002-.012	.160	.164
-6	.353	.070	.155	.187		.192	.196
-8	.476	.095	.170	.250	.002-.016	.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:

NAS 1400

NAS 523 CODE: SEE TABLE II

CHERRYMAX[®] "AB" RIVET
WIREDRAW - NOMINAL
100° FLUSH HEAD

SHEET 1 OF 3

PART NUMBER

ISSUE

09-27-85

REV.

N

5-21-15

CR4172



TABLE II

FINISH CODE	NAS 523 CODE	MATERIAL ③			FINISH		
		SLEEVE	STEM	LOCK RING	SLEEVE	STEM	LOCK RING
---	BCH	2017-T4 PER QQ-A-430	7075 PER QQ-A-430	5056-H38 PER QQ-A-430	YELLOW COLOR CHEM. FILM PER MIL-DTL-5541	CHEM. FILM PER MIL-DTL-5541	NONE
PR ⑥	---				CHEM. FILM PER MIL-DTL-5541		
A	---				ANODIZE PER MIL-A-8625	ANODIZE PER MIL-A-8625	
V	---				CHEM. FILM PER MIL-DTL-5541 CL 1A, TYPE II	CHEM. FILM PER MIL-DTL-5541 CL 1A, TYPE II	
G ⑩	---						
GPR ⑥ ⑩	---						

TABLE III

GRIP DASH NO. ⑦	GRIP RANGE		-4 DIAMETER			-5 DIAMETER			-6 DIAMETER			-8 DIAMETER		
	MIN	MAX	L MAX	K MAX	BK ②	L MAX	K MAX	BK ②	L MAX	K MAX	BK ②	L MAX	K MAX	BK ②
-02	④	.125	.260	.45	.30	.263	.44	.28	.287	.48	.26	---	---	---
-03	.126	.187	.323	.57	.35	.326	.56	.34	.350	.60	.32	.385	.63	.37
-04	.188	.250	.385	.69	.41	.388	.67	.39	.412	.72	.37	.448	.75	.43
-05	.251	.312	.448	.81	.46	.451	.79	.45	.475	.83	.43	.510	.87	.48
-06	.313	.375	.510	.93	.52	.513	.91	.50	.537	.95	.48	.573	.99	.54
-07	.376	.437	.573	1.05	.57	.576	1.03	.56	.600	1.07	.54	.635	1.11	.60
-08	.438	.500	.635	1.17	.63	.638	1.15	.62	.662	1.19	.60	.698	1.23	.65
-09	.501	.562	---	---	---	.701	1.27	.67	.725	1.31	.65	.760	1.34	.71
-10	.563	.625	---	---	---	.763	1.44	.78	.787	1.48	.76	.823	1.52	.82
-11	.626	.687	---	---	---	---	---	---	.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

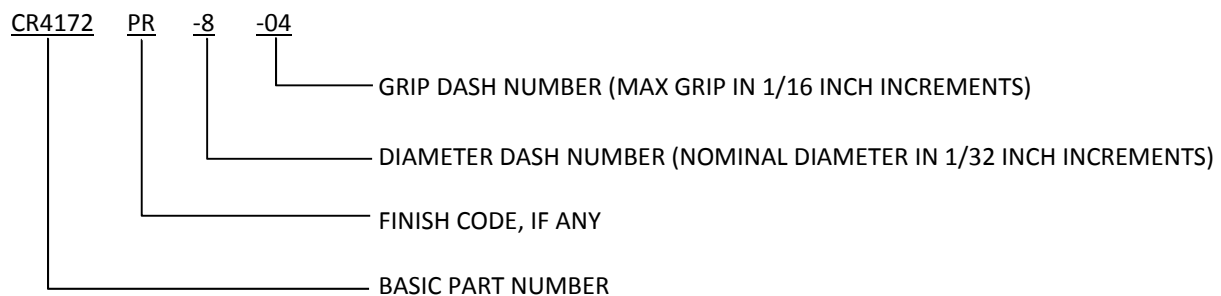
SHEET 2 OF 3			PART NUMBER	
ISSUE	09-27-85		CR4172	
REV.	N	5-21-15		



NOTES:

- ① AN INCREASE OF .001 IS 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 -4 DIAMETER 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 PARTS ARE MANUFACTURED BARE. IF LUBE IS REQUIRED, USE PAR 90 ONLY.
- 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 1399.
9. GOLD COLORED DRIVING ANVIL IDENTIFIES NOMINAL DIAMETER RIVETS.
- ⑩ FINISH CODES WITH THE PREFIX "G" INDICATE REACH COMPLIANT COATING.

EXAMPLE OF CHERRY PART NUMBER:



SHEET 3 OF 3			PART NUMBER
ISSUE	09-27-85		CR4172
REV.	N	5-21-15	

STANDARDS PAGE REVISION LOG CR4172

REV LTR	DATE	DCR NUMBER	REVISION DESCRIPTION	COMP. BY
N	5-21-15	14-1289	• ADDED REACH COMPLIANT COATING G, GPR • ADDED NOTE 10 • GENERAL CLEANUP AND STANDARDIZATION	AD