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**HEAD MARKING** ①

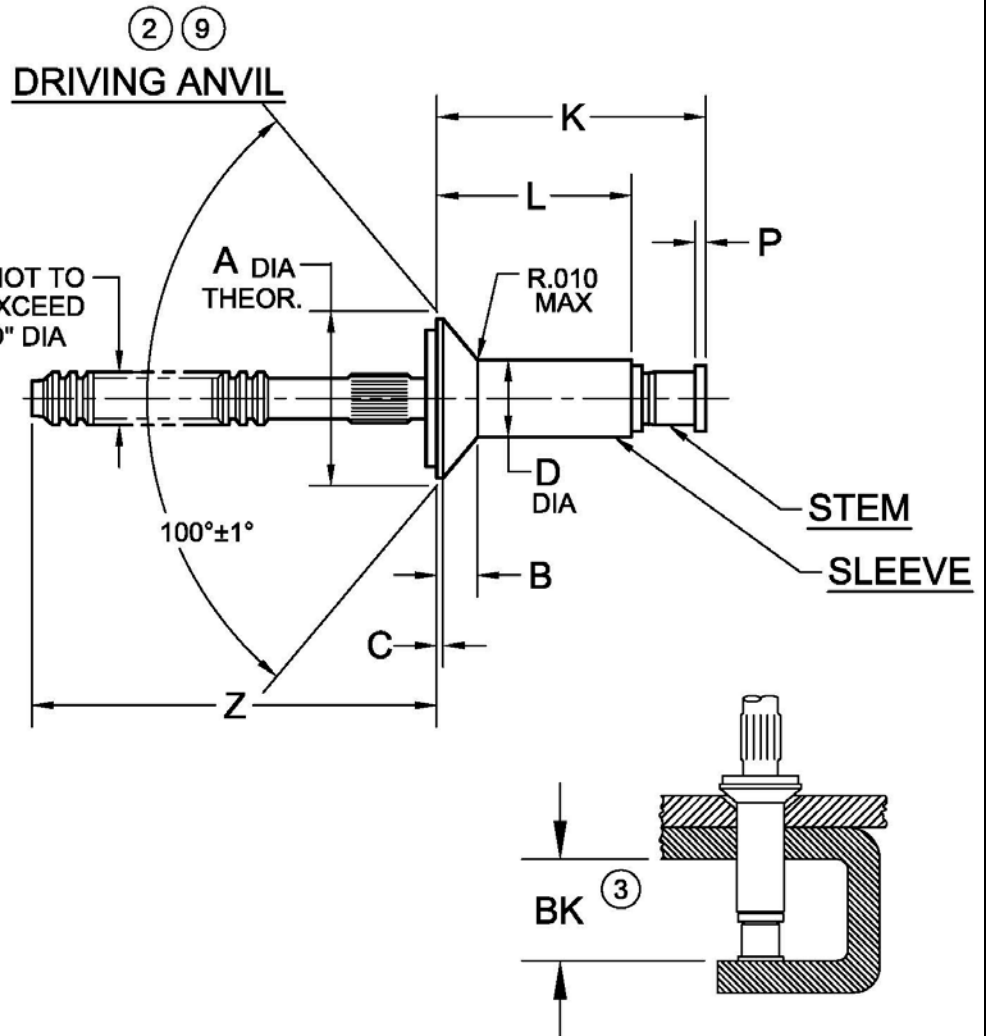
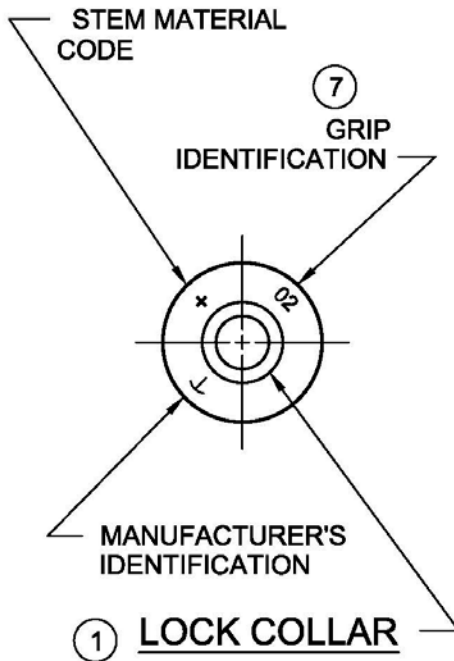


TABLE I

DIA. DASH NO.	A ±.004	B REF	C	D +.003 -0.001	P MIN	Z REF	BK③ MIN	HOLE LIMITS	
								MIN	MAX
-4	.225	.041	.002-.010	.126	.010	.87	.355	.129	.132
-5	.286	.054	.002-.012	.157	.015	.94	.370	.160	.164
-6	.353	.069		.189		.415	.192	.196	
-8	.476	.095	.253	.97		.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® RIVET**  
NOMINAL DIAMETER  
100° FLUSH HEAD

SHEET 1 OF 4

PART NUMBER

ISSUE

02-16-82

REV.

AJ

31 JAN 19

**CR3222**



TABLE II

FINISH CODE	NAS 523 CODE	MATERIAL ⑤			FINISH		
		SLEEVE	STEM	LOCK COLLAR	SLEEVE	STEM	LOCK COLLAR
---	AYH	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	---						
DL ⑨	---						
PR ⑧	---				PASSIVATE PER AMS 2700		
G ⑩	---				PASSIVATE PER AMS 2700		
GCF ⑩	---				PASSIVATE PER AMS 2700		
GDL ⑨⑩	---				PASSIVATE PER AMS 2700 & DICRONITE DL-5		
GPR ⑧⑩	---				PASSIVATE PER AMS 2700		

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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
-02	④	.125	.224	.45	.230	.47	.262	.51	---	---
-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

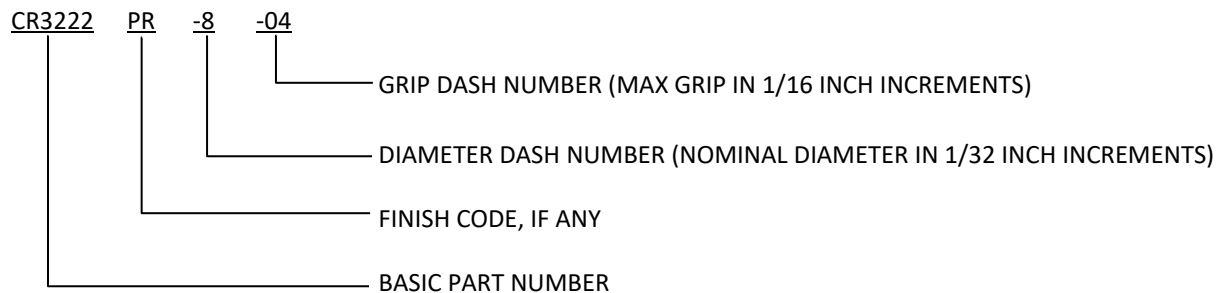
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**NOTES:**

- 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. INSPECTION OF THIS FEATURE IS NOT PERFORMED BY THE MANUFACTURER.
- ④ MINIMUM GRIP FOR -4 DIA. IS .063; FOR -5 IS .065; AND FOR -6 IS .080.
- 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 "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.
- ⑨ 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.
- ⑩ FINISH CODES WITH THE PREFIX "G" INDICATE REACH COMPLIANT COATING.

**EXAMPLE OF CHERRY PART NUMBER:**



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## STANDARDS PAGE REVISION LOG

REV LTR	DATE	DCR NUMBER	REVISION DESCRIPTION	COMP. BY
AJ	31 JAN 19	19-0052	<ul style="list-style-type: none"><li>• SHEET 1 – ADDED NOTE ③ TO BK MIN</li><li>• SHEET 2 – ADDITIONAL COMMENT ADDED TO NOTE ③</li></ul>	AA