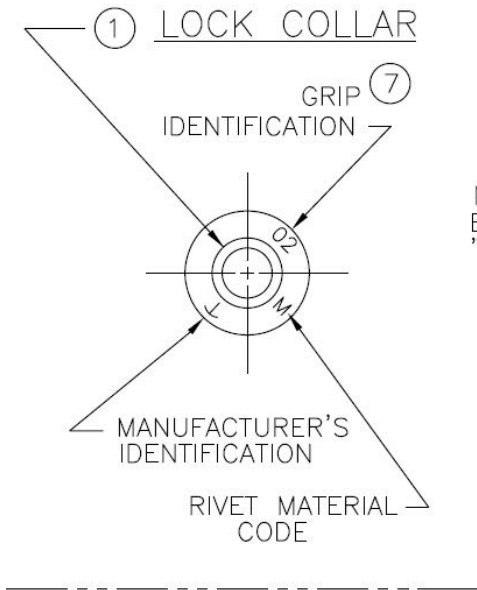


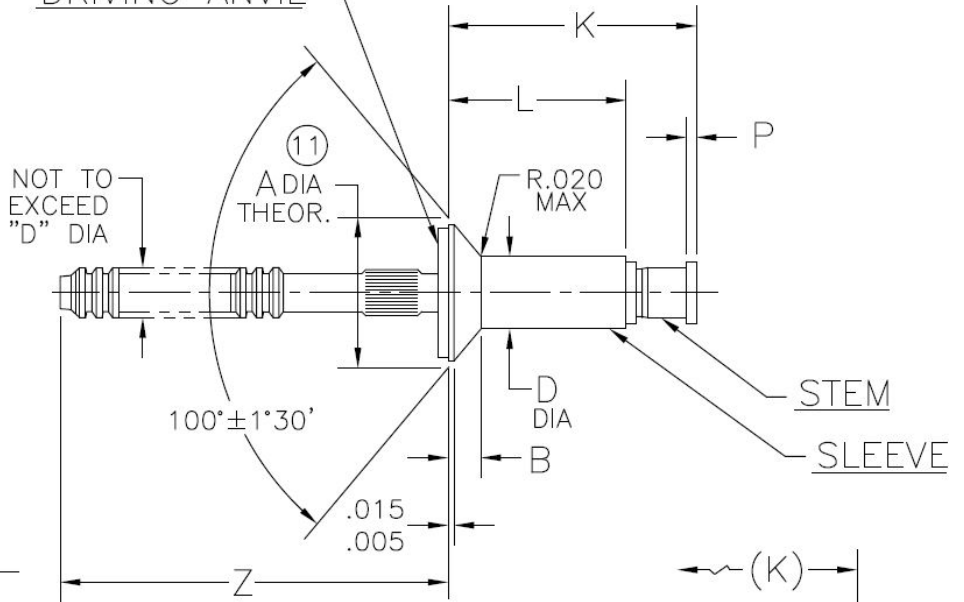


PRINTED COPIES OF THIS DOCUMENT ARE FOR "REFERENCE" ONLY. CURRENT REVISIONS ARE AVAILABLE ONLINE.

HEAD MARKING ①
FOR -6 AND -8 DIA ONLY



DRIVING ANVIL ②



HEAD MARKING ①
FOR -4 AND -5 DIA ONLY

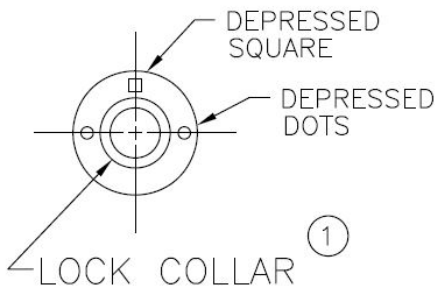


TABLE I

| DIA. DASH NO. | A ±.004 | B REF | D +.003 -.001 | P MIN | Z REF | ③ BK MIN | HOLE LIMITS | |
|---------------------|------------|----------|---------------------|----------|----------|----------------|-------------|------|
| | | | | | | | MIN | MAX |
| -4 | .192 ⑪ | .028 | .126 | .010 | .87 | .355 | .129 | .132 |
| -5 | .243 | .037 | .157 | .015 | .94 | .370 | .160 | .164 |
| -6 | .299 | .046 | .189 | | | | .192 | .196 |
| -8 | .392 | .060 | .253 | | | | .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 NAS 1097 100° FLUSH HEAD | | SHEET 1 OF 4 | | PART NUMBER |
| | | | ISSUE | 03-31-83 | CR3524 |
| | | | REV. | AE 31 JAN 19 | |



TABLE II

| FINISH CODE | NAS 523 CODE | MATERIAL ⑤ | | | FINISH | | |
|-------------|--------------|--------------------|---------------------------|--|--|---|------------------------|
| | | SLEEVE | STEM | LOCK COLLAR | SLEEVE | STEM | LOCK COLLAR |
| --- | AYX | MONEL PER QQ-N-281 | 15-7 PH CRES PER AMS 5657 | A-286 CRES PER AMS 5731 & AMS 5737 AMS 5737 | NONE (DRY FILM LUBE OPTIONAL) | NONE (DRY FILM LUBE OPTIONAL) | PASSIVATE PER AMS 2700 |
| DL ⑧ | --- | | | | | PASSIVATE PER AMS 2700 & DICRONITE DL-5 | |
| EE ⑪ | BCT | | | | ALUM. COAT PER NAS 4006 & BMS 10-85 | NONE (DRY FILM LUBE OPTIONAL) | |
| P ⑪ | AYY | | | | ALUM. COAT PER MIL-DTL-83488 | | |
| PR ⑨ | --- | | | | SEE NOTE 9 | NONE (DRY FILM LUBE OPTIONAL) | |
| PRC ⑨ | --- | | | | SEE NOTE 9 | | |
| GP ⑪ ⑫ | --- | | | | ALUM. COAT PER MIL-DTL-83488 (SUPPLEMENTAL: MIL-DTL-5541 CL 1A, TYPE II) | | |
| GEE ⑪ ⑫ | --- | | | | ALUM. COAT PER NAS 4006 CLASS NC | | |

| | | |
|--------------|--------------|---------------|
| SHEET 2 OF 4 | | PART NUMBER |
| ISSUE | 03-31-83 | CR3524 |
| REV. | AE 31 JAN 19 | |



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 | .221 | .45 | --- | --- | --- | --- | --- | --- |
| -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 |

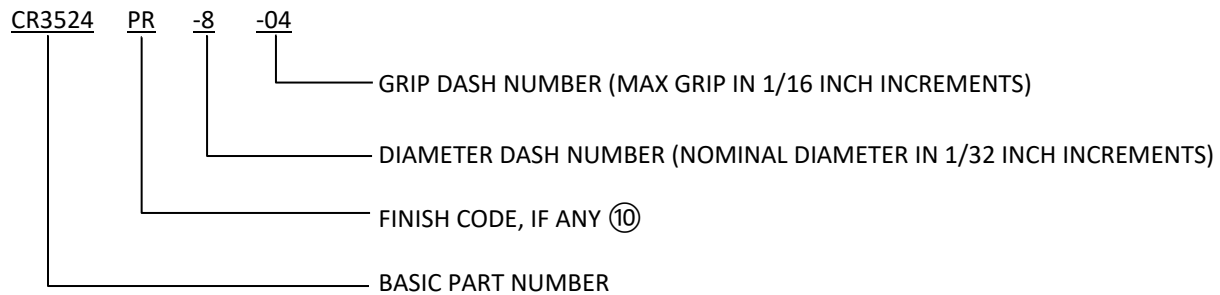
| | | | |
|--------------|----------|-----------|-------------|
| SHEET 3 OF 4 | | | PART NUMBER |
| ISSUE | 03-31-83 | | CR3524 |
| REV. | AE | 31 JAN 19 | |



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 -02 GRIP PARTS: 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 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 "PR" CODE – PARTS ARE MANUFACTURED BARE; IF LUBE IS REQUIRED, USE PAR 90 ONLY. "PRC" CODE ARE SIMILAR TO "PR" EXCEPT FOR ADDITIONAL PROCESSING FOR PAINT ADHERENCE AT HIGH TEMPERATURE EXPOSURE OPTIONAL MOLYBDENUM DISULFIDE TYPE I PER AS5272 MAY BE APPLIED TO STEM ONLY.
- ⑩ FINISH CODES MAY BE COMBINED. EXAMPLE: CODE "PPR" – ALUMINUM COATED SLEEVE WITH "PR" LUBE RESTRICTION. WHEN COMBINING FINISH CODES, PLACE PLATING CODE BEFORE LUBE CODE.
- ⑪ FOR -4 DIAMETER, "A" THEORETICAL DIMENSION IS MEASURED PRIOR TO THE APPLICATION OF THE FINISH.
- ⑫ FINISH CODES WITH THE PREFIX "G" INDICATE REACH COMPLIANT COATING.

EXAMPLE OF CHERRY PART NUMBER:



| | | |
|---------------|----------|-------------|
| SHEET 4 OF 4 | | PART NUMBER |
| ISSUE | 03-31-83 | |
| REV. | AE | 31 JAN 19 |
| CR3524 | | |

STANDARDS PAGE REVISION LOG

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