U.S. PATENT

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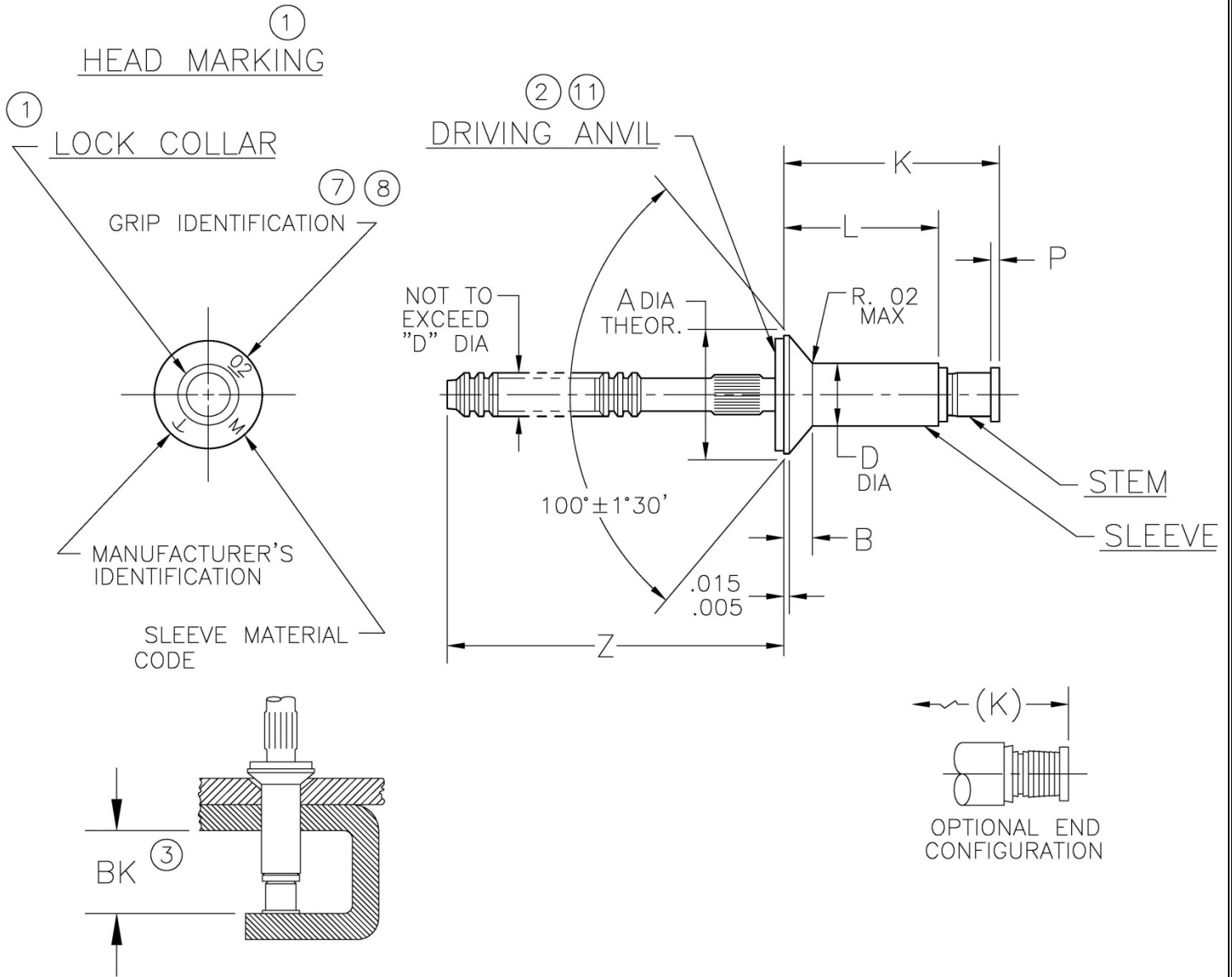
CHERRY ® AEROSPACE
SPS Fastener Division, a *PCC* Company

① HEAD MARKING

① LOCK COLLAR

GRIP IDENTIFICATION ⑦ ⑧

MANUFACTURER'S IDENTIFICATION

SLEEVE MATERIAL CODE

② ⑪ DRIVING ANVIL

NOT TO EXCEED "D" DIA

A DIA THEOR.

100° ± 1°30'

.015
.005

R .02 MAX

K

L

P

D DIA

B

STEM

SLEEVE

Z

BK ③

(K)

OPTIONAL END CONFIGURATION

TABLE I

DIA. DASH NO.	A ±.004	B REF	D +.003 -.001	P MIN	Z REF	③ BK MIN	HOLE LIMITS MIN	HOLE LIMITS MAX
-4	.225	.035	.140	.010	.87	.390	.143	.146
-5	.286	.047	.173	.015	.94	.395	.176	.180
-6	.353	.063	.201	.015	.94	.410	.205	.209
-8	.476	.086	.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:	**CHERRYMAX® RIVET** OVERSIZE DIAMETER 100° FLUSH HEAD	SHEET 1 OF 4		PART NUMBER
PS-CMR-3000		ISSUE	06-24-92	**CR3552**
NAS 523 CODE: SEE TABLE II		REV.	AH 31 JAN 19	

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TABLE II

FINISH CODE	NAS 523 CODE	MATERIAL ⑤			FINISH		
		SLEEVE	STEM	LOCK COLLAR	SLEEVE	STEM	LOCK COLLAR
- - -	ARF OR AZD	MONEL PER QQ-N-281	15-7 PH CRES PER AMS 5657	A-286 CRES PER AMS 5731 & AMS 5737	NONE	NONE	PASSIVATE PER AMS 2700
DL ⑩	- - -					PASSIVATE PER AMS 2700 & DICRONITE DL-5	
EE	- - -				ALUM. COAT PER NAS 4006 AND BMS 10-85	NONE	
P	AZE				ALUM. COAT PER MIL-DTL-83488		
PR ⑨	- - -				NONE		
Y	- - -				NONE	LUBECO 905	
GP ⑫	- - -				ALUM. COAT PER MIL-DTL-83488 CL 3, TYPE II (SUPPLEMENTAL: MIL-DTL-5541 CL 1A, TYPE II)	NONE	
GEE ⑫	- - -				ALUM. COAT PER NAS 4006 CLASS NC		

		PART NUMBER
ISSUE	06-24-92	CR3552
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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
-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

SHEET 3 OF 4		PART NUMBER
ISSUE	06-24-92	CR3552
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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.
INSPECTION OF THIS FEATURE IS NOT PERFORMED BY THE MANUFACTURER

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 SIDE 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 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.

⑪ 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.

⑫ FINISH CODES WITH THE PREFIX "G" INDICATE REACH COMPLIANT COATING.

EXAMPLE OF CHERRY PART NUMBER:

CR3552   PR   -8   -04

- GRIP DASH NUMBER (MAX GRIP IN 1/16 INCH INCREMENTS)
- DIAMETER DASH NUMBER (NOMINAL DIAMETER IN 1/32 INCH INCREMENTS)
- FINISH CODE, IF ANY ⑪
- BASIC PART NUMBER
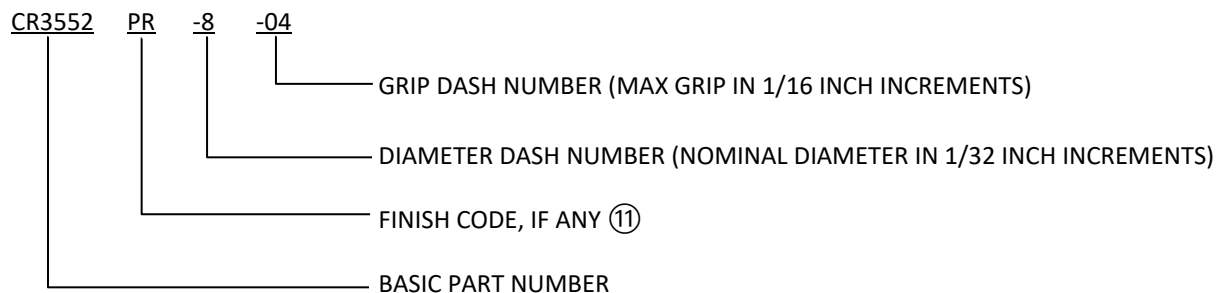
SHEET 4 OF 4		PART NUMBER
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STANDARDS PAGE REVISION LOG

REV LTR	DATE	DCR NUMBER	REVISION DESCRIPTION	COMP. BY
AH	31 JAN 19	19-0052	• SHEET 1 – ADDED NOTE ③ TO BK MIN • SHEET 2 – ADDITIONAL COMMENT ADDED TO NOTE ③	AA