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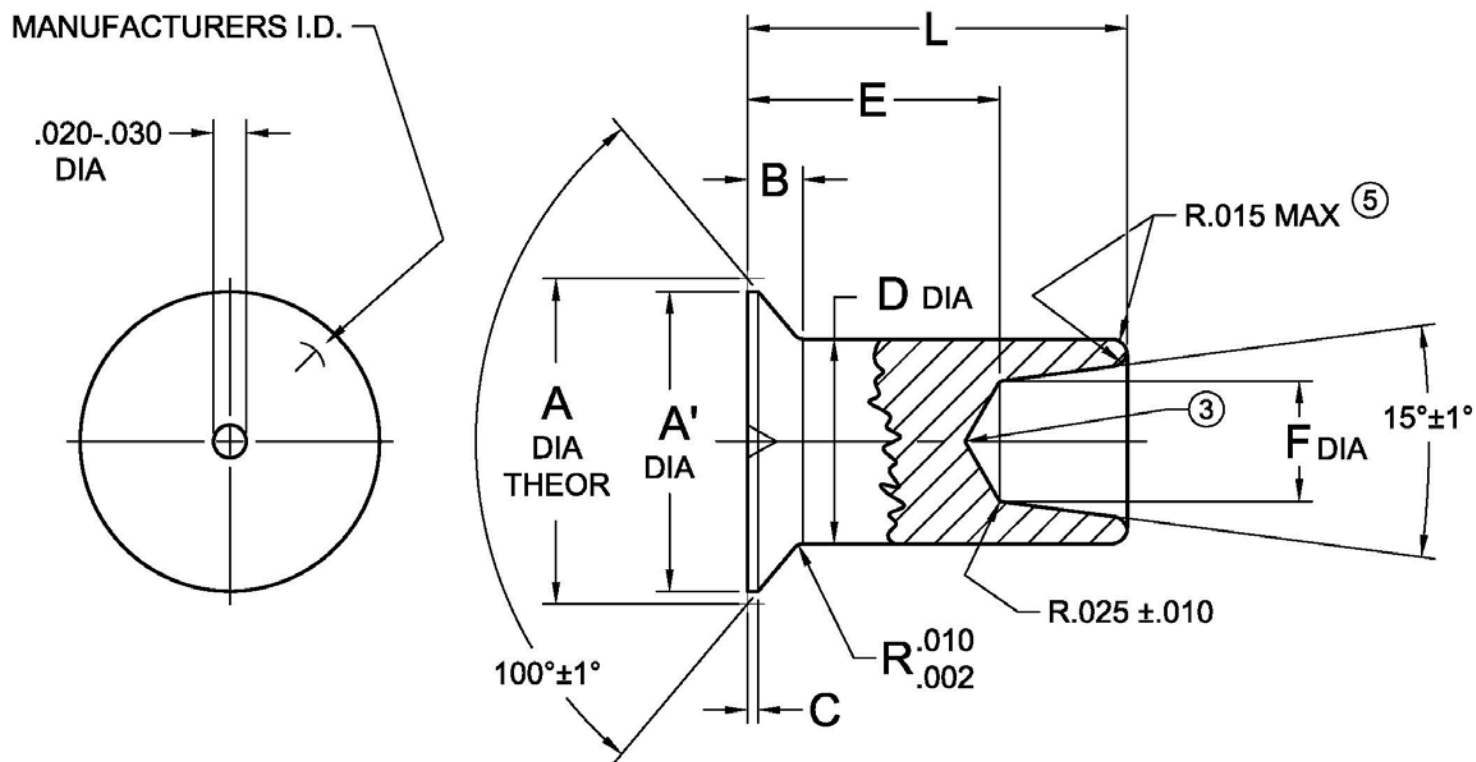


TABLE I

DIA. DASH NO.	A ±.004	A' MIN	B REF	C MAX	D +.003 -.001	F +.005 -.000
-4	.192	.174	.028	.006	.125	.073
-5	.243	.225	.037	.008	.156	.091
-6	.298	.275	.046	.010	.187	.110
-7 (7)	.324	.298			.219	.142

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.

CAGE CODE:
11815

PROCUREMENT SPECIFICATION:

PS-HEEZB-900

**CHERRY® HOLLOW-ENDED
E-Z BUCK®**
100° FLUSH HEAD

SHEET 1 OF 3

ISSUE

2-26-85

REV.

V

1-22-16

PART NUMBER

CSR90433



TABLE II

FINISH CODE	FINISH	LUBRICATION
---	NONE	NONE
E (8)	ALUMINUM COATING PER NAS 4006	
F	PHOSPHATE FLUORIDE PER BAC 5861 AND AMS 2486	
G (8)	IVD ALUMINUM COATING PER MIL-DTL-83488 CL 3, TYPE II	
W	ANODIZE BLUE PER ISO 8080	
GE (8) (10)	ALUMINUM COATING PER NAS 4006 CLASS NC	
GG (8) (10)	IVD ALUMINUM COATING PER MIL-DTL-83488 CL 3 TYPE II (SUPPLEMENTAL: MIL-DTL-5541 CL 1A, TYPE II)	

TABLE III

GRIP DASH NO.	GRIP RANGE		-4 DIA		-5 DIA		-6 DIA		-7 DIA (7)	
	MIN	MAX	L ±.005	E ±.005	L ±.005	E ±.005	L ±.005	E ±.005	L ±.005	E ±.005
-4	.095	.125	.149	.061	---	---	---	---	---	---
-5	.126	.156	.180	.092	.186	.084	.192	.075	---	---
-6	.157	.187	.212	.124	.218	.116	.223	.106	.223	.106
-7	.188	.219	.243	.155	.249	.147	.255	.138	.255	.138
-8	.220	.250	.274	.186	.280	.178	.286	.169	.286	.169
-9	.251	.281	.305	.217	.311	.209	.317	.200	.317	.200
-10	.282	.312	.337	.249	.343	.241	.348	.231	.348	.231
-11	.313	.343	.369	.280	.374	.272	.379	.262	.379	.262
-12	.344	.375	.399	.311	.405	.303	.411	.294	.411	.294
-13	.376	.407	.430	.342	.436	.334	.442	.325	.442	.325
-14	.408	.438	.462	.374	.468	.366	.474	.357	.474	.357
-15	.439	.469	.493	.405	.499	.397	.505	.388	.505	.388
-16	.470	.500	.524	.436	.530	.428	.536	.419	.536	.419
-17	.501	.531	.555	.467	.561	.459	.567	.450	.567	.450
-18	.532	.562	.587	.499	.593	.491	.598	.481	.598	.481
-19	.563	.594	.618	.530	.624	.522	.630	.513	.630	.513
-20	.595	.625	.649	.561	.655	.553	.661	.544	.661	.544
-21	.626	.656	.680	.592	.686	.584	.692	.575	.692	.575
-22	.657	.687	.712	.624	.718	.616	.723	.606	.723	.606
-23	.688	.719	.743	.655	.749	.647	.755	.638	.755	.638
-24	.720	.750	.774	.686	.780	.678	.786	.669	.786	.669
-25	.751	.781	.805	.717	.811	.709	.817	.700	.817	.700
-26	.782	.812	.837	.749	.843	.741	.848	.731	.848	.731
-27	.813	.843	.868	.780	.874	.772	.879	.762	.879	.762
-28	.844	.875	.899	.811	.905	.803	.911	.794	.911	.794
-29	.876	.907	.930	.842	.936	.834	.942	.825	.942	.825
-30	.908	.938	.962	.874	.968	.866	.974	.857	.974	.857
-31	.939	.969	.993	.905	.999	.897	1.005	.888	1.005	.888
-32	.970	1.000	1.024	.936	1.030	.928	1.036	.919	1.036	.919

SHEET 2 OF 3

PART NUMBER

ISSUE

2-26-85

REV.

V

1-22-16

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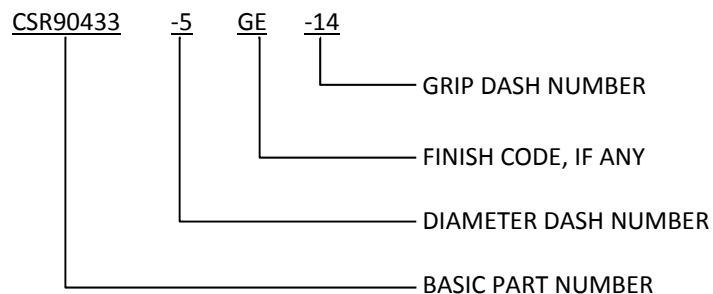
MATERIAL : 55 Ti-45 Cb TITANIUM ALLOY; CHEMICAL COMPOSITION PER AMS 4982.
HYDROGEN CONTENT OF FINISHED PRODUCT TO BE 85 PPM MAXIMUM.

HEAT TREAT : ANNEALED

NOTES:

1. A .001 INCREASE IN "D" DIAMETER IS PERMISSIBLE WITHIN .100 OF THE BASE OF THE HEAD.
2. CONICAL SURFACE OF HEAD AND RECESS TO BE CONCENTRIC TO "D" DIAMETER WITHIN .005 F.I.M.
- ③ BOTTOM CONFIGURATION OF RECESS IS OPTIONAL.
4. HEAD COCKING ANGLE RELATIVE TO AXIS OF RIVET 1/2° MAXIMUM.
- ⑤ FREE FLOW OF MATERIAL IN THIS AREA MAY BE ROUND, FLAT OR CHAMFERED.
- ⑥ RECESS CONFIGURATION IS COVERED UNDER BOEING PATENT #4,221,041 AND LICENSE AGREEMENT BETWEEN CHERRY AEROSPACE LLC AND THE BOEING COMPANY.
- ⑦ -7 DIAMETER IS FOR REPLACEMENT/REPAIR FOR -6 DIAMETER. NOT TO BE USED FOR NEW DESIGN.
- ⑧ DIMENSIONS APPLY AFTER PLATING AND COATING, BUT ARE EXCLUSIVE OF LUBRICATION.
9. LOCALIZED UNDERFILL ON END OF RIVET NOT TO EXCEED .005 BELOW MINIMUM LENGTH.
- ⑩ FINISH CODES WITH THE PREFIX "G" INDICATE REACH COMPLIANT COATING.

EXAMPLE OF CHERRY PART NUMBER:



SHEET 3 OF 3		PART NUMBER
ISSUE	2-26-85	CSR90433
REV.	V 1-22-16	

STANDARDS PAGE REVISION LOG**CSR90433**

REV LTR	DATE	DCR NUMBER	REVISION DESCRIPTION	COMP. BY
V	22 Jan 16	16-0051	UPDATED TO CURRENT FORMAT	MC