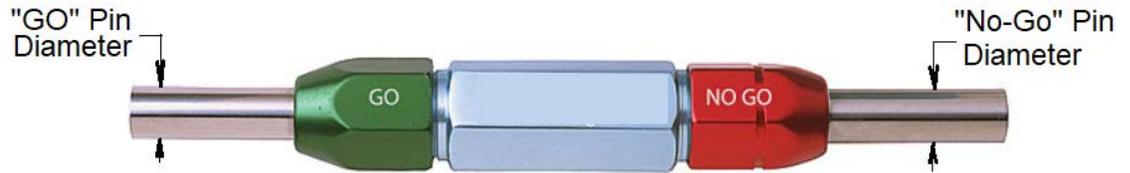


DIMENSIONAL DATA



Gage Number	Description	Hole To Gage		Pin Gage Diameters			
		Min	Max	"Go"		"No Go"	
				-.0002	+.0000	-.0000	+.0002
T172 - 3	¹ Nominal Diameter CherryLOCK®/Nut-Plate Rivet	0.097	0.101	0.0970	0.1012		
T172 - 4	Nominal Diameter, all Cherry products including MaxiBolt®	0.129	0.132	0.1290	0.1322		
T172 - 5	Nominal Diameter, all Cherry products except MaxiBolt®	0.160	0.164	0.1600	0.1642		
T172 - 6	Nominal Diameter, all Cherry products except MaxiBolt®	0.192	0.196	0.1920	0.1962		
T172 - 7	Nominal Diameter, all Cherry products except MaxiBolt®	0.220	0.225	0.2200	0.2252		
T172 - 8	Nominal Diameter, all Cherry products except MaxiBolt®	0.256	0.261	0.2560	0.2612		
T172 - 9	Nominal Diameter, all Cherry products except MaxiBolt®	0.289	0.295	0.2890	0.2952		
T172 - 40	² Oversize MS9000 Series	0.137	0.141	0.1370	0.1412		
T172 - 50	² Oversize MS9000 Series	0.177	0.181	0.1770	0.1812		
T172 - 60	² Oversize MS9000 Series	0.206	0.210	0.2060	0.2102		
T172 - 80	² Oversize MS9000 Series	0.271	0.276	0.2710	0.2762		
T172 - 400	³ Oversize Cherrymax® & CherryLOCK®	0.143	0.146	0.1430	0.1462		
T172 - 500	³ Oversize Cherrymax® & CherryLOCK®	0.176	0.180	0.1760	0.1802		
T172 - 600	³ Oversize Cherrymax® & CherryLOCK®	0.205	0.209	0.2050	0.2092		
T172 - 800	³ Oversize Cherrymax® & CherryLOCK®	0.271	0.275	0.2710	0.2752		
T172 - 5MB	⁴ Nominal Diameter MaxiBolt®	0.164	0.167	0.1640	0.1672		
T172 - 6MB	⁴ Nominal Diameter MaxiBolt®	0.199	0.202	0.1990	0.2022		
T172 - 8MB	⁴ Nominal Diameter MaxiBolt®	0.260	0.263	0.2600	0.2632		
T172 - 10MB	⁴ Nominal Diameter MaxiBolt®	0.312	0.315	0.3120	0.3152		
T172 - 12MB	⁴ Nominal Diameter MaxiBolt®	0.374	0.377	0.3740	0.3772		
T172 - 500MB	⁵ First Oversize (1/64") MaxiBolt®	0.176	0.180	0.1760	0.1802		
T172 - 600MB	⁵ First Oversize (1/64") MaxiBolt®	0.215	0.218	0.2150	0.2182		
T172 - 800MB	⁵ First Oversize (1/64") MaxiBolt®	0.276	0.280	0.2760	0.2802		

Notes: The flags above refer to the following Cherry Part Numbers (see below).

"X" in the part numbers below are just placeholders showing an additional 3 digits in the part number.

- CherryLOCK® WireDraw: **CR2X6X**
CherryLOCK® A: **CR2X7X**
Nut-Plate: **CCR2XX**
- Oversize MS9000 Part Numbers: **CR9178, CR9179, CR9278, CR9279, CR9578, CR9579**
- Oversize CherryMAX® Part Numbers: **CR324X, CR325X, CR355X, CR385X**
Oversize CherryLOCK® Bulb Part Numbers: **CR223X, CR224X, CR253X, CR254X, CR283X, CR284X**
- MaxiBolt® Nominal Part Numbers: **CR731X, CR762X, CR7XXX**
- MaxiBolt® Oversize Part Numbers: **CR734X, CR765X**



CHERRY®
AEROSPACE

1224 East Warner Ave,
Santa Ana, CA 92705
Tel: 1-714-545-5511
www.cherryaerospace.com

How To Use The Gage

- The green side of the gage matches the hole minimum diameter; the red side of the gage is slightly larger than the maximum hole diameter.
- Check the hole with the “Go” side first and make sure the pin goes into the hole easily.
- Turn the gage to the “NoGO” side and attempt to push the pin into the hole; this side should not be able to go into the hole.



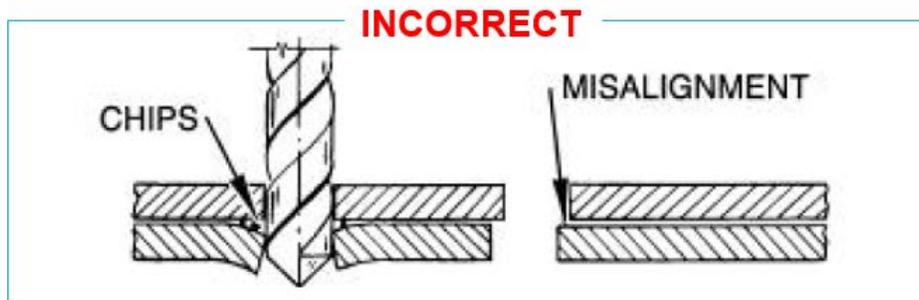
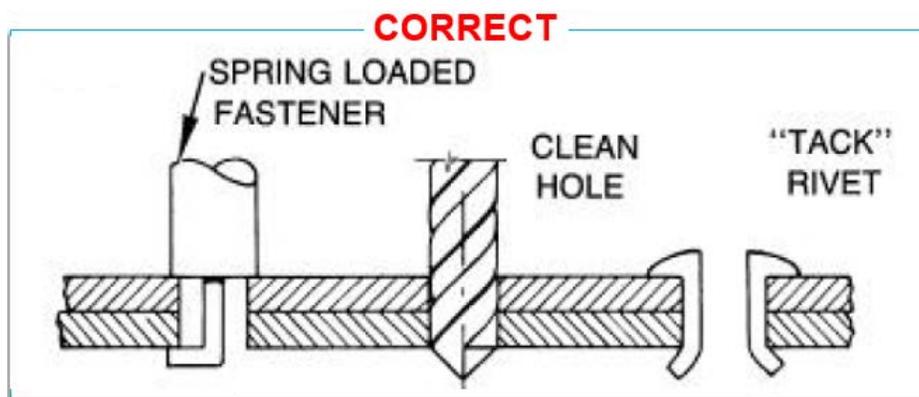
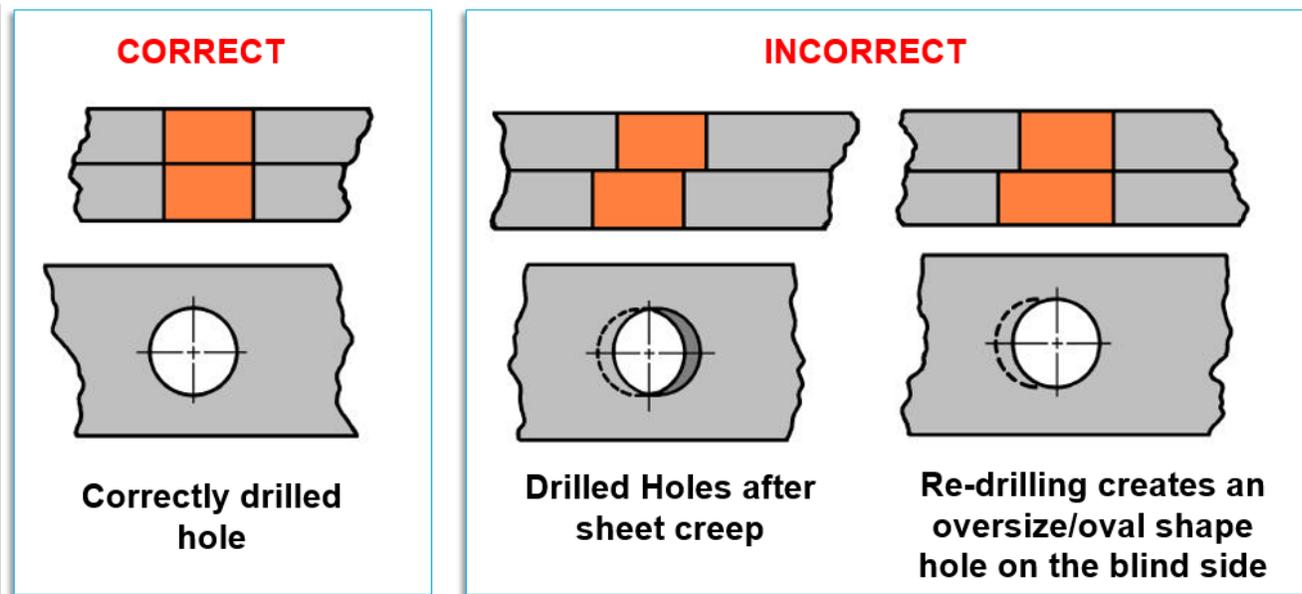
ADDITIONAL NOTES:

Acceptance

- The hole is properly prepared if the “Go” side slides in and the “NoGo” side does not.
- Please be aware that a visual inspection is also strongly recommended; there could be many cases in which the holes are improperly prepared, but they gage properly; see the next page for hole-preparation / inspection recommendations.

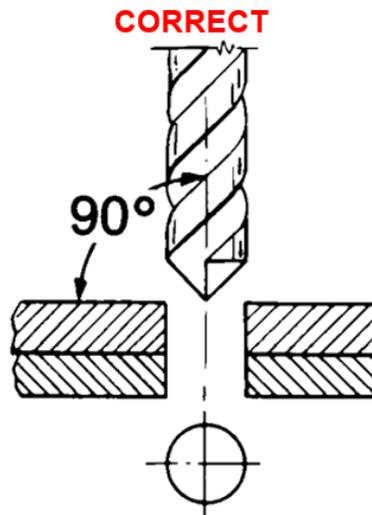
Hole Alignment

- Take special care fixturing and setting up the structure so the holes are drilled and aligned properly.

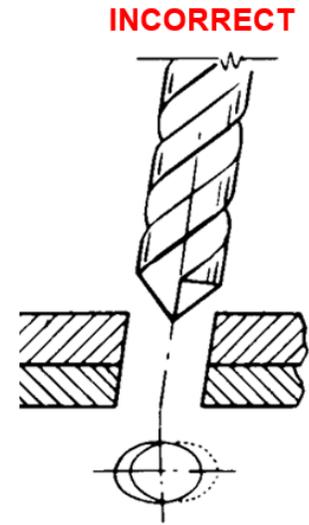


Perpendicularity

- Make sure that the holes are drilled perpendicular to the structure.
- An elliptical or out of round hole may cause sever installation issues.



The drill is perpendicular to the structure, resulting in a proper hole



The drill is NOT perpendicular to the structure, resulting in an oblong or deformed hole

Proper Deburring

- When deburring, make sure to not break the corners.
- Corner breaks, especially between the structure layers and on the blind side will affect fastener installation and its joint properties.



Hole edges still sharp



All corners broken

Proper Dimpling

- For thin structures where dimpling is necessary, make sure to ream the dimpled hole to the recommended size.

