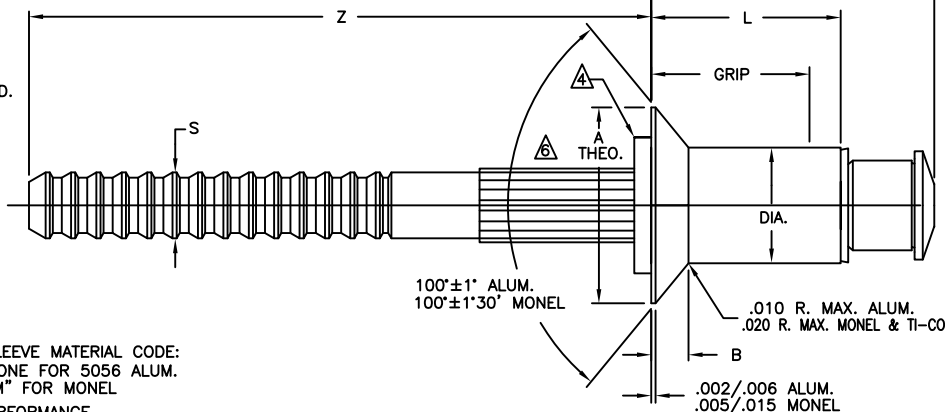
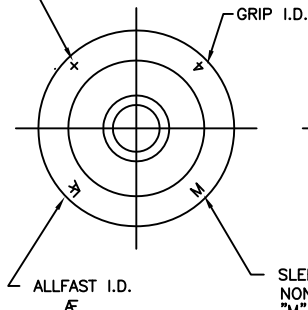


# ALLFAST

FASTENING SYSTEMS, INC.

STEM MATERIAL CODE:  
"+" FOR ALUM./15-7 CRES.



SLEEVE MATERIAL CODE:  
NONE FOR 5056 ALUM.  
"M" FOR MONEL

LUBRICATION: AS REQUIRED FOR PERFORMANCE.

DIA. DASH NO.	DIA. +.003 - .001	A DIA. ±.004	B REF.	S DIA. REF.	Z MIN.	HOLE LIMITS	DRILL SIZE NO.
-4	.126	.225	.042	.071	.87	.129-.132	30
-5	.157	.286	.055	.089	.94	.160-.164	20
-6	.189	.353	.070	.108	.94	.192-.196	10

GRIP LIMITS	GRIP DASH NO.	-4 DIA.		-5 DIA.		-6 DIA.	
		L +.000	K MAX.	L +.000	K MAX.	L +.000	K MAX.
MIN.	MAX.	MAX.	MAX.	MAX.	MAX.	MAX.	MAX.
.125	-.02	.224	.45	.230	.47	.262	.51
.126	.187	-.03	.287	.51	.293	.53	.325
.188	.250	-.04	.349	.57	.355	.59	.387
.251	.312	-.05	.412	.63	.418	.65	.450
.313	.375	-.06	.474	.70	.480	.72	.512
.376	.437	-.07	.537	.76	.543	.77	.575
.438	.500	-.08	.599	.82	.605	.84	.637
.501	.562	-.09	.662	.88	.668	.90	.700
.563	.625	-.10			.730	.96	.762
.626	.687	-.11			.793	1.02	.825
.688	.750	-.12					.887

RIVET NO.	MATERIAL			FINISH		
	SLEEVE	STEM	LOCK RING	SLEEVE	STEM	LOCK RING
AF3212 NAS9302B	5056 ALUM. ALLOY QQ-A-430	8740 ALLOY STEEL AMS 6322	A-286 CRES AMS 5731	MIL-DTL-5541 PLAIN COLOR	CAD PLATE AMS-QQ-P-416 TYPE II CLASS II	PASSIVATE AMS2700
AF3222 NAS9302E	5056 ALUM. ALLOY QQ-A-430	PH 15-7 MO. CRES AMS 5657	A-286 CRES AMS 5731	MIL-DTL-5541 PLAIN COLOR	PASSIVATE AMS2700	PASSIVATE AMS2700
AF3522 NAS9308M	MONEL QQ-N-281	PH 15-7 MO. CRES AMS 5657	A-286 CRES AMS 5731	NONE	PASSIVATE AMS2700	PASSIVATE AMS2700
AF3522R	MONEL QQ-N-281	PH 15-7 MO. CRES AMS 5657	A-286 CRES AMS 5731	NONE	PASSIVATE AMS2700 AF90	PASSIVATE AMS2700
AF3522P NAS9308MN	MONEL QQ-N-281	PH 15-7 MO. CRES AMS 5657	A-286 CRES AMS 5731	ALUM. COAT NAS 4006	PASSIVATE AMS2700	PASSIVATE AMS2700
AF3522F NAS9308ML	MONEL QQ-N-281	PH 15-7 MO. CRES AMS 5657	A-286 CRES AMS 5731	MIL-C-83488 ALUM. COAT	PASSIVATE AMS2700	PASSIVATE AMS2700
AF3522PPR	MONEL QQ-N-281	PH 15-7 MO. CRES AMS 5657	A-286 CRES AMS 5731	MIL-C-83488 ALUM. COAT	PASSIVATE AMS2700 AF90	PASSIVATE AMS2700
AF3212G	5056 ALUM. ALLOY QQ-A-430	8740 ALLOY STEEL AMS 6322	A-286 CRES AMS 5731	MIL-DTL-5541 PLAIN COLOR	ZINC NICKEL AMS2417	PASSIVATE AMS2700

NOTES:

DIA. DASH NO.	MIN. GRIP
-4	.063
-5	.065
-6	.080

AF3XXX (X) X -X S

GRIP LENGTH IN 16THS  
NOMINAL DIAMETER IN 32NDS.  
FINISH CODE. USE "L" IN THIS POSITION UNLESS  
OTHERWISE SPECIFIED BY A LETTER CODE.  
BASIC PART NUMBER.

- DO NOT CLEAN OR DEGREASE PRIOR TO INSTALLATION.
- ADD LETTER "T" TO BASIC PART NUMBER TO DESIGNATE TRANSLUBE OR DRY FILM LUBRICANT ONLY.  
EXAMPLE: AF3212T4-3
- GOLD COLORED DRIVING ANVIL IDENTIFIES NOMINAL DIAMETER RIVETS.
- HEAD MARKING VISIBLE AFTER INSTALLATION.
- SPIRAL KNURL OPTIONAL.
- "R" CODE-PARTS MAY HAVE AF90 OR MOLYBDENUM DISULFIDE AT MANUFACTURER'S OPTION ON STEM ONLY. AF90 IS A DRY FILM LUBRICANT.
- ADD LETTER "S" TO END OF PART NUMBER TO DESIGNATE FASTENERS LOADED IN STRIPS FOR USE WITH RV3000 INSTALLATION TOOL.

**UNCONTROLLED COPY**  
**WILL NOT BE KEPT UP TO DATE**

BY:	DATE:	REV.:	BY:	DATE:	C.R.NO.:	STANDARD	
DRAWN BY: J.YOUSSEF	04/10/90	M	L.D.	06/22/07	6114	AF3212	AF3522
CHECKED: APPROVAL		N	P.M.	08/05/08	6495	AF3222	
APPROVED: ON FILE		P	P.M.	09/11/15	9188		

ALLMAX RIVET  
100° FLUSH HEAD,  
LOCKED SPINDLE  
NOMINAL DIAMETER