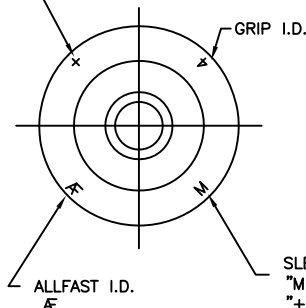


ALLFAST

FASTENING SYSTEMS, INC.

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



SLEEVE MATERIAL CODE:
 "M" FOR MONEL
 "+" FOR INCONEL

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	.140	.225	.035	.081	.87	.143-.146	27
-5	.173	.286	.047	.100	.94	.176-.180	16
-6	.201	.353	.063	.117	.94	.205-.209	5

GRIP LIMITS	GRIP DASH NO.	-4 DIA.		-5 DIA.		-6 DIA.	
		L +.000 - .030	K MAX.	L +.000 - .030	K MAX.	L +.000 - .030	K MAX.
.125	-02	.238	.45	.266	.47	.265	.48
.126	-03	.301	.52	.309	.53	.328	.55
.188	-04	.363	.58	.371	.60	.390	.62
.251	-05	.426	.65	.434	.66	.453	.68
.313	-06	.488	.71	.496	.72	.515	.74
.376	-07	.551	.78	.559	.79	.578	.82
.438	-08	.613	.84	.621	.85	.640	.89
.501	-09	.676	.90	.684	.91	.703	.95
.563	-10			.746	.98	.765	1.01
.626	-11			.809	1.04	.828	1.07
.688	-12					.890	1.14

RIVET NO.	SLEEVE	MATERIAL		FINISH		
		STEM	LOCK RING	SLEEVE	STEM	LOCK RING
AF3242 NAS9305B BACR15FP(B)	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
AF3252 NAS9305E BACR15FP(E)	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
AF3552 NAS9311M BACR15FP(M)	MONEL QQ-N-281	PH 15-7 MO. CRES AMS 5657	A-286 CRES AMS 5731	NONE	PASSIVATE AMS2700	PASSIVATE AMS2700
AF3552R	MONEL QQ-N-281	PH 15-7 MO. CRES AMS 5657	A-286 CRES AMS 5731	NONE	PASSIVATE AMS2700 AF90	PASSIVATE AMS2700
AF3552P NAS9311MN BACR15FP(MP)	MONEL QQ-N-281	PH 15-7 MO. CRES AMS 5657	A-286 CRES AMS 5731	ALUM. COAT NAS 4006	PASSIVATE AMS2700	PASSIVATE AMS2700
AF3552F NAS9311ML	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
AF3852 NAS9311C	INCONEL 600 AMS5687	INCONEL X-750 AMS5698	A-286 CRES AMS 5731	NONE	PASSIVATE AMS2700	PASSIVATE AMS2700
AF3552PPR	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

NOTES:

DIA. DASH NO.	MIN. GRIP
-4	.063
-5	.063
-6	.073

AF3XXX (X) X -X S

GRIP LENGTH IN 16THS.
 NOMINAL DIAMETER IN 32NDS.
 FINISH CODE. USE "-" 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: AF3242T4-3
- SILVER COLORED DRIVING ANVIL IDENTIFIES OVERSIZE DIAMETER RIVETS.
- HEAD MARKINGS VISIBLE AFTER INSTALLATION.
- SPRAL 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	N	L.D.	11/19/07	6247	AF3242	AF3552
CHECKED: APPROVAL		P	P.M.	06/04/08	6431	AF3252	AF3852
APPROVED: ON FILE		Q	P.M.	08/05/08	6495	ALLMAX RIVET 100° FLUSH HEAD, LOCKED SPINDLE OVERSIZE DIAMETER	