

| $\begin{gathered} \text { DIA. } \\ \text { DASH } \\ \text { NO } \end{gathered}$ | $\begin{gathered} \oplus \mathrm{A} \\ \pm .010 \end{gathered}$ | $\begin{array}{\|c} \hline \mathrm{B} \\ +.010 \\ -.000 \end{array}$ | $\begin{gathered} \Phi D \\ +.003 \\ -.001 \end{gathered}$ | ¢P | ©S | $\underset{\operatorname{MAX}}{\cup}$ | $\underset{\mathrm{MiN}}{\mathrm{Z}}$ | INSTALLATION HOLE LIMITS | $\begin{aligned} & \hline \text { DRILL } \\ & \text { SIZE } \\ & \text { NO. } \end{aligned}$ |
| :---: | :---: | :---: | :---: | :---: | :---: | :---: | :---: | :---: | :---: |
| -4 | . 250 | . 054 | . 125 | .109-. 123 | . 088 | 12 | . 87 | .129-. 132 | 30(.129) |
| -5 | . 312 | . 067 | . 156 | .136-. 150 | . 107 | $10^{\circ}$ | . 94 | .160-. 164 | 20(.161) |
| -6 | . 375 | . 080 | . 187 | .161-. 175 | . 126 | $8{ }^{\circ}$ | . 94 | .192-. 196 | 10(.194) |
| -8 | . 500 | . 107 | . 250 | .214-. 228 | . 169 | 6. | . 97 | .256-. 261 | F(.257) |


| $\begin{aligned} & \hline \text { RIVET } \\ & \text { NO. } \\ & \hline \end{aligned}$ | MATERIAL 1 亿 |  |  | FINISH |  |  |
| :---: | :---: | :---: | :---: | :---: | :---: | :---: |
|  | SLEEVE | STEM | LOCK RING | SLEEVE | STEM | LOCK RING |
| $\begin{aligned} & \text { AF4173 } \\ & \text { NAS1398D()AB() } \end{aligned}$ | $\begin{gathered} 2017-T 4 \\ Q Q-A-430 \end{gathered}$ | $\begin{gathered} 7075 \\ \text { QQ-A-430 } \end{gathered}$ | $\begin{aligned} & 5056-H 38 \\ & \text { QQ-A-430 } \end{aligned}$ | MIL-DTL-5541 | MIL-DTL-5541 | NONE |
| $\begin{aligned} & \text { AF4523P()-() } \\ & \text { NAS1398MW()AB() } \end{aligned}$ | $\begin{gathered} \text { MONEL } \\ \text { QQ-N-281 } \end{gathered}$ | $\begin{aligned} & \text { A-286 } \\ & \text { AMS5731 } \end{aligned}$ | $\begin{gathered} \text { MONEL } \\ Q Q-N-281 \end{gathered}$ | CADMIUM PLATE AMS-QQ-P-416 | $\begin{gathered} \text { PASSIVATE } \\ \text { AMS-QQ-P-35 } \end{gathered}$ | NONE |
| $\begin{aligned} & \text { AF4523S()-() } \\ & \text { NAS1398MS()AB() } \end{aligned}$ | $\begin{gathered} \text { MONEL } \\ \text { QQ-N-281 } \end{gathered}$ | $\begin{aligned} & \text { A-286 } \\ & \text { AMS5731 } \end{aligned}$ | $\begin{gathered} \text { MONEL } \\ \text { QQ-N-281 } \end{gathered}$ | SILVER PLATE QQ-S-365 | $\begin{gathered} \text { PASSIVATE } \\ \text { AMS-QQ-P-35 } \end{gathered}$ | NONE |
| $\begin{aligned} & \text { AF4523()-() } \\ & \text { NAS1398M()AB() } \end{aligned}$ | $\begin{gathered} \text { MONEL } \\ \text { QQ-N-281 } \end{gathered}$ | $\begin{aligned} & \text { A-286 } \\ & \text { AMS5731 } \end{aligned}$ | $\begin{gathered} \text { MONEL } \\ Q Q-N-281 \end{gathered}$ | DRY FILM LUBE | $\begin{gathered} \text { PASSIVATE } \\ \text { AMS-QQ-P-35 } \end{gathered}$ | NONE |
| AF4523F()-() | $\begin{gathered} \text { MONEL } \\ \text { QQ-N-281 } \end{gathered}$ | $\begin{aligned} & \text { A-286 } \\ & \text { AMS5731 } \end{aligned}$ | $\begin{gathered} \text { MONEL } \\ \text { QQ-N-281 } \end{gathered}$ | $\begin{gathered} \text { ALUM. COAT } \\ \text { MLL-C-83488 } \\ \text { TYPE ॥ CLASS } 3 \end{gathered}$ | $\begin{gathered} \text { PASSIVATE } \\ \text { AMS-QQ-P-35 } \end{gathered}$ | NONE |
| $\begin{aligned} & \text { AF4623P()-() } \\ & \text { NAS1398CW()AB() } \end{aligned}$ | $\begin{aligned} & \text { A-286 } \\ & \text { AMS5731 } \end{aligned}$ | $\begin{aligned} & \text { A-286 } \\ & \text { AMS5731 } \end{aligned}$ | $\begin{gathered} \text { MONEL } \\ \text { QQ-N-281 } \end{gathered}$ | CADMIUM PLATE <br> AMS-QQ-P-416 | $\begin{gathered} \text { PASSIVATE } \\ \text { AMS-QQ-P-35 } \end{gathered}$ | NONE |
| AF4623S()-() NAS1398CS()AB() | $\begin{aligned} & \text { A-286 } \\ & \text { AMS5731 } \end{aligned}$ | $\begin{aligned} & \text { A-286 } \\ & \text { AMS5731 } \end{aligned}$ | $\begin{gathered} \text { MONEL } \\ \text { QQ-N-281 } \end{gathered}$ | SILVER PLATE QQ-S-365 | $\begin{gathered} \text { PASSIVATE } \\ \text { AMS-QQ-P-35 } \end{gathered}$ | NONE |
| $\begin{aligned} & \hline \text { AF4623()-() } \\ & \text { NAS1398C()AB() } \end{aligned}$ | $\begin{aligned} & \text { A-286 } \\ & \text { AMS5731 } \end{aligned}$ | $\begin{aligned} & \text { A-286 } \\ & \text { AMS5731 } \end{aligned}$ | $\begin{gathered} \text { MONEL } \\ \text { QQ-N-281 } \end{gathered}$ | DRY FILM LUBE | PASSIVATE $A M S-Q Q-P-35$ | NONE |
| $\begin{aligned} & \text { AF4623F()-() } \\ & \text { ABS0547D ( ) ( ) } \end{aligned}$ | $\begin{aligned} & \text { A-286 } \\ & \text { AMS5731 } \end{aligned}$ | $\begin{aligned} & \text { A-286 } \\ & \text { AMS5731 } \end{aligned}$ | $\begin{gathered} \text { MONEL } \\ Q Q-N-281 \end{gathered}$ | $\begin{gathered} \text { ALUM. COAT } \\ \text { MLL-C-83488 } \\ \text { TYPE ॥ CLASS } 3 \end{gathered}$ | $\begin{gathered} \text { PASSIVATE } \\ \text { AMS-QQ-P-35 } \end{gathered}$ | NONE |

UNCONTROLLED COPY
WILL NOT BE KEPT UP TO DATE

| REV. | DATE | BY | E.O. NO. | AB CODE <br> UNIVERSAL HEAD LOCKED SPINDLE | PREPARED | CHECKED | APPROVED |
| :---: | :---: | :---: | :---: | :---: | :---: | :---: | :---: |
| M | 10/09/09 | P.M. | 6872 |  | $\begin{aligned} & \hline \text { DANNY } \\ & \text { BASSEET } \end{aligned}$ | APPR | VAL |
| N | 07/10/12 | P.M. | 7804 |  | 03/04/97 | ON FILE |  |
| P | 03/05/13 | P.M. | 8041 | ALLFAST <br> 15200 DON JULIAN ROAD . CITY OF INDUSTRY CA. 91745 PHONE: (626) 968-9388 | AF4173 <br> AF4523 <br> AF4623 <br> PAGE 1 OF 2 |  |  |
| Q | 07/26/13 | P.M. | 8205 |  |  |  |  |  |  |
| R | 04/22/14 | P.M. | 8482 |  |  |  |  |  |  |
| S | 01/28/15 | P.M. | 8848 |  |  |  |  |  |  |



MINIMUM BLIND-SIDE CLEARANCE FOR RIVET INSTALLATION

|  |  |  | DIA DASH NUMBER |  |  |  |  |  |  |  |  |  |  |  |
| :---: | :---: | :---: | :---: | :---: | :---: | :---: | :---: | :---: | :---: | :---: | :---: | :---: | :---: | :---: |
|  |  |  | -4 |  |  | -5 |  |  | -6 |  |  | -8 |  |  |
| GRIP | RANIP |  |  | F |  |  | F | BK |  | F | BK |  | F |  |
| $\frac{\text { DASH }}{\text { NO }}$ |  |  | $\begin{aligned} & +.000 \\ & -.020 \end{aligned}$ | MAX | MIN | $\begin{array}{r} +.000 \\ -.020 \end{array}$ | MAX | MIN | $+.000$ | MAX | MIN | $\begin{aligned} & +.000 \\ & -.020 \end{aligned}$ | MAX | MIN |
| -01 | A | . 062 | . 198 | . 39 | . 36 | . 198 | . 38 | . 35 | . 198 | . 37 | . 33 |  |  |  |
| -02 | . 063 | . 125 | . 260 | . 51 | . 45 | . 260 | . 49 | . 43 | . 260 | . 48 | . 42 | . 323 | . 57 | . 51 |
| -03 | . 126 | . 187 | . 323 | . 63 | . 50 | . 323 | . 61 | . 48 | . 323 | . 60 | . 47 | . 385 | . 69 | . 56 |
| -04 | . 188 | . 250 | . 385 | . 75 | . 56 | . 385 | . 73 | . 54 | . 385 | . 72 | . 53 | . 448 | . 81 | . 62 |
| -05 | . 251 | . 312 | . 448 | . 87 | . 62 | . 448 | . 85 | . 59 | . 448 | . 84 | . 59 | . 510 | . 93 | . 68 |
| -06 | . 313 | . 375 | . 510 | . 98 | . 67 | . 510 | . 97 | . 65 | . 510 | . 96 | . 65 | . 573 | 1.04 | . 73 |
| -07 | . 376 | . 437 | . 573 | 1.11 | . 73 | . 573 | 1.09 | . 71 | . 573 | 1.08 | . 70 | . 635 | 1.16 | . 78 |
| -08 | . 438 | . 500 | . 636 | 1.23 | . 79 | . 635 | 1.20 | . 76 | . 635 | 1.20 | . 76 | . 698 | 1.28 | . 84 |
| -09 | . 501 | . 562 | . 698 | 1.35 | . 85 | . 698 | 1.37 | . 87 | . 698 | 1.37 | . 87 | . 760 | 1.46 | . 96 |
| -10 | . 563 | . 625 |  |  |  | . 760 | 1.50 | . 94 | . 760 | 1.49 | . 93 | . 823 | 1.58 | 1.02 |
| -11 | . 626 | . 687 |  |  |  |  |  |  | . 823 | 1.61 | . 98 | . 885 | 1.70 | 1.07 |
| -12 | . 688 | . 750 |  |  |  |  |  |  | . 885 | 1.74 | 1.05 | . 948 | 1.83 | 1.14 |
| -13 | . 751 | . 812 |  |  |  |  |  |  |  |  |  | 1.010 | 1.95 | 1.20 |
| -14 | . 813 | . 875 |  |  |  |  |  |  |  |  |  | 1.073 | 2.07 | 1.26 |

## NOTES:

MATERIAL COMPOSITION ONLY
2. MAY BE DRY FILM LUBED AT MANUFACTURER'S OPTION
3. MIN GRIP: DIAMETER $-4=.025$, DIAMETER $-5=.031$, DIAMETER $-6=.037$
4. $\varnothing \mathrm{P}$ ANNEALED
5. EXAMPLE OF PART NUMBER:
$\frac{\text { AF4623 }}{T} \frac{\text { S }}{T} \frac{6-04}{L}$ GRIP LENGTH IN 16THS NOMINAL DIAMETER IN 32NDS.
FINISH CODE.
BASIC PART NUMBER.
UNCONTROLLED COPY
WILL NOT BE KEPT UP TO DATE

| REV. | DATE | BY | E.O. NO. | AB CODE <br> UNIVERSAL HEAD LOCKED SPINDLE | PREPARED | CHECKED | APPROVED |
| :---: | :---: | :---: | :---: | :---: | :---: | :---: | :---: |
| M | 10/09/09 | P.M. | 6872 |  | $\begin{aligned} & \hline \text { DANNY } \\ & \text { BASSETT } \end{aligned}$ | APPR | VAL |
| N | 07/10/12 | P.M. | 7804 |  | 03/04/97 | ON | FILE |
| P | 03/05/13 | P.M. | 8041 | ALIFAST <br> 15200 DON JULIAN ROAD . CITY OF INDUSTRY CA. 91745 PHONE: (626) 968-9388 | $\begin{aligned} & \text { AF4173 } \\ & \text { AF4523 } \\ & \text { AF462 } \end{aligned}$ |  |  |
| Q | 07/26/13 | P.M. | 8205 |  |  |  |  |
| R | 04/22/14 | P.M. | 8482 |  |  |  |  |
| S | 01/28/15 | P.M. | 8848 |  |  |  |  |

