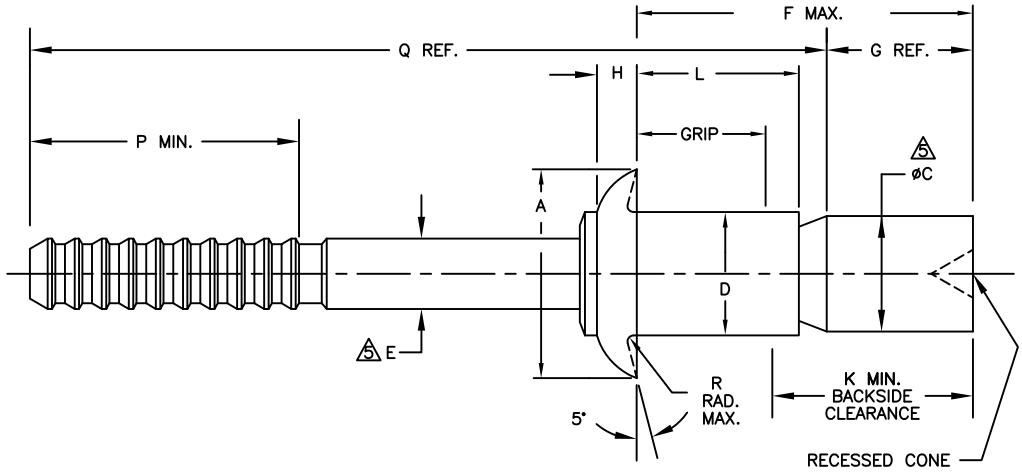
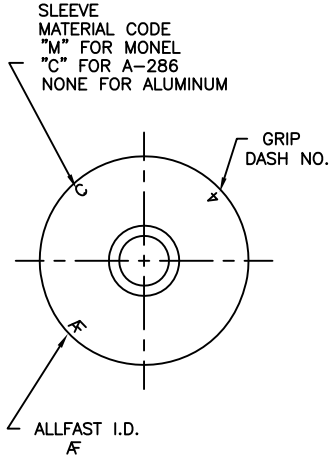


ALLFAST

FASTENING SYSTEMS, INC.



DIA. DASH NO.	NOM. DIA.	A DIA.	C DIA.	D DIA.	E DIA.	H	P MIN.	R. RAD.		RECOMMENDED	PROCEDURE
								ALUM.	MONEL A-286	DRILL SIZE	HOLE LIMITS
-4	1/8	.262 / .238		.128 / .124		.064 / .054	.375	.010	.020	#30 (.1285)	.129 / .132
-5	5/32	.328 / .296		.159 / .155		.077 / .067	.375	.010	.020	#20 (.1610)	.160 / .164
-6	3/16	.394 / .356		.190 / .186		.090 / .080	.375	.010	.020	#10 (.1935)	.192 / .196
-8	1/4	.525 / .475		.253 / .249		.117 / .107	.375	.010	.020	#8 (.2570)	.256 / .261

GROUP	Q REF.			
	-4	-5	-6	-8
A	1.79	1.81	1.85	1.97
B		2.06	2.10	2.22
C			2.35	2.47

GRIP LIMITS	RIVET GROUP	GRIP DASH NO.	-3 DIA.				-4 DIA.				-5 DIA.				-6 DIA.				-8 DIA.															
			F MAX.	G REF.	K	L MAX.	F MAX.	G REF.	K	L MAX.	F MAX.	G REF.	K	L MAX.	F MAX.	G REF.	K	L MAX.	F MAX.	G REF.	K	L MAX.												
.062	A	-1	.330	.131	.267	.193	.390	.147	.327	.198	.38	.127	.28	.201	.44	.107	.27	.225																
.125	A	-2	.430	.172	.305	.229	.510	.147	.385	.250	.49	.183	.34	.263	.55	.163	.32	.287	.57	.179	.32	.323												
.187	A	-3	.530	.211	.343	.291	.630	.203	.443	.323	.61	.239	.39	.326	.67	.219	.37	.350	.69	.235	.37	.385												
.250	A	-4	.630	.250	.380	.354	.750	.259	.500	.385	.73	.295	.45	.388	.79	.275	.43	.412	.81	.291	.43	.448												
.312	A	-5	.730	.305	.418	.416	.870	.315	.558	.448	.85	.351	.50	.451	.91	.331	.48	.475	.93	.347	.48	.510												
.375	A	-6	.830	.386	.455	.479	.980	.371	.605	.510	.97	.407	.56	.513	1.03	.387	.54	.537	1.04	.403	.54	.573												
.437	A	-7	.990	.449	.553	.542	1.110	.437	.673	.573	1.09	.463	.62	.576	1.15	.443	.60	.600	1.16	.459	.60	.635												
.500	A	-8	1.110	.511	.610	.605	1.230	.493	.730	.635	1.20	.519	.67	.638	1.27	.499	.65	.662	1.28	.515	.65	.698												
.562	B	-9					1.350	.605	.788	.698	1.38	.575	.73	.701	1.44	.555	.71	.725	1.46	.571	.71	.760												
.625	B	-10									1.50	.631	.78	.763	1.56	.611	.76	.787	1.58	.627	.76	.823												
.687	B	-11													1.68	.667	.82	.850	1.70	.683	.82	.885												
.750	B	-12													1.81	.723	.87	.912	1.83	.739	.87	.948												
.812	C	-13																	1.95	.795	.93	1.010												
.875	C	-14																	2.07	.851	.98	1.073												

BASIC PART NO.	MATERIAL			FINISH		
	SLEEVE	STEM	LOCK RING	SLEEVE	STEM	LOCK RING
AF2000()-() NAS1398D()-()	2017-T4 QQ-A-430	7075 QQ-A-430	5056-H38 QQ-A-430	CHEM FILM GOLD PER MIL-DTL-5541	CHEM FILM GOLD PER MIL-DTL-5541	NONE
AF2050()-() NAS1398B()-()	5056-F QQ-A-430	7075 QQ-A-430	5056-H38 QQ-A-430	CHEM FILM ORANGE PER MIL-DTL-5541		
AF2090()-() NAS1398M()-()	MONEL QQ-N-281	MONEL QQ-N-281 OR A-286 AMS 5731	MONEL QQ-N-281	CAD PLATE PER AMS-QQ-P-416 TYPE II, CLASS 2 WHEN SPECIFIED BY CODE LETTER "W" OR SILVER PLATE PER QQ-S-365 WHEN SPECIFIED BY CODE LETTER "S"	NONE	NONE
AF2040()-() NAS1398C()-()	A-286 AMS5731	A-286 AMS5731	MONEL QQ-N-281			

PROCUREMENT SPEC: NAS1400 AS APPLICABLE.

NOTES:

DIA. DASH NO.	MIN. GRIP
-3	.020
-4	.025
-5	.031
-6	.037

PART NUMBER CODE: AF2040 W 5 -2
 L MAXIMUM GRIP IN 16THS
 NOMINAL DIA. IN 32NDS
 FINISH CODE
 BASIC PART NUMBER
 A-286 CRES

- LUBRICATION: AS REQUIRED FOR PERFORMANCE, UNPLATED MONEL OR A-286 COMPONENTS MAY BE LUBRICATED WITH SOLID FILM (MoS₂) LUBRICANT.
- AFTER MATERIAL CODE LETTER, ADD "FC" TO INDICATE CHEMICAL FILM TREATMENT, "P" TO INDICATE ANODIZE, "W" TO INDICATE CADMIUM PLATE, "S" TO INDICATE SILVER PLATE FINISH ON SLEEVES, OR "TL" TO INDICATE DRY FILM LUBE ONLY.
- RIVET GROUP REFERS TO SHIFT POINT SETTING.
- NOT TO EXCEED RIVET DIAMETER.

UNCONTROLLED COPY
WILL NOT BE KEPT UP TO DATE

FED. IDENT. CODE 53551

BY:	DATE	REV.	BY	DATE	C.R.NO.	STANDARD
DRAWN BY: L. VARGAS	08/13/91	D	L.D.	04/17/07	6066	AF2000 WIRE DRAW
CHECKED: APPROVAL		E	L.D.	04/23/07	6071	
APPROVED: ON FILE		F	L.D.	06/22/07	6114	

BLIND RIVET
 UNIVERSAL HEAD, LOCKED STEM