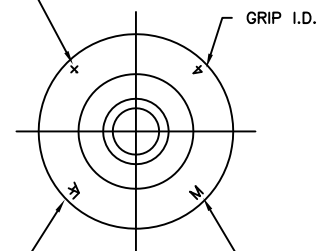


ALLFAST

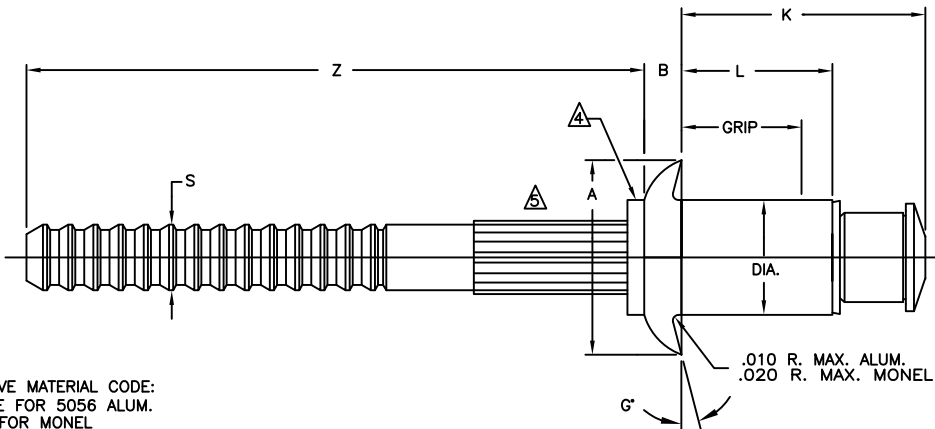
FASTENING SYSTEMS, INC.

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



ALLFAST I.D.
F

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



.010 R. MAX. ALUM.
.020 R. MAX. MONEL

LUBRICATION: AS REQUIRED FOR PERFORMANCE

DIA. DASH NO.	A +.003 - .001	B ±.010	S ±.005	Z DIA. REF.	HOLE MIN.	HOLE LIMITS	DRILL SIZE NO.	G MAX.
-4	.126	.250	.059	.071	.87	.129-.132	30	8"
-5	.157	.312	.072	.089	.94	.160-.164	20	8"
-6	.189	.375	.085	.108	.94	.192-.196	10	8"

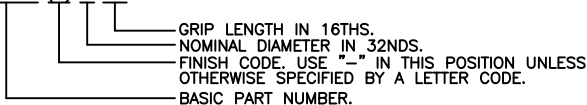
GRIP LIMITS	GRIP DASH NO.	-4 DIA.		-5 DIA.		-6 DIA.	
		L +.000 - .030	K MAX.	L +.000 - .030	K MAX.	L +.000 - .030	K MAX.
.062	-01	.161	.38	.187	.41	.219	.47
.063	.125	.224	.45	.230	.47	.262	.51
.126	.187	.287	.51	.293	.53	.325	.57
.188	.250	.349	.57	.355	.59	.387	.64
.251	.312	.412	.63	.418	.65	.450	.70
.313	.375	.474	.70	.480	.72	.512	.76
.376	.437	.537	.76	.543	.77	.575	.82
.438	.500	.599	.82	.605	.84	.637	.88
.501	.562	.662	.88	.668	.90	.700	.95
.563	.625	-10		.730	.96	.762	1.01
.626	.687	-11		.793	1.02	.825	1.07
.688	.750	-12				.887	1.13

RIVET NO.	MATERIAL			FINISH		
	SLEEVE	STEM	LOCK RING	SLEEVE	STEM	LOCK RING
AF3213 NAS9301B	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
AF3223 NAS9301E	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
AF3523 NAS9307M	MONEL QQ-N-281	PH 15-7 MO. CRES AMS 5657	A-286 CRES AMS 5731	NONE	PASSIVATE AMS2700	PASSIVATE AMS2700
AF3523R	MONEL QQ-N-281	PH 15-7 MO. CRES AMS 5657	A-286 CRES AMS 5731	NONE	PASSIVATE AMS2700 AF90	PASSIVATE AMS2700
AF3523P NAS9307MN	MONEL QQ-N-281	PH 15-7 MO. CRES AMS 5657	A-286 CRES AMS 5731	ALUM. COAT NAS 4006	PASSIVATE AMS2700	PASSIVATE AMS2700
AF3523F NAS9307ML	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
AF3523PPR	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
AF3213G	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	.025
-5	.031
-6	.037

AF3XXX (X) X-XX S△



- DO NOT CLEAN OR DEGREASE PRIOR TO INSTALLATION.
- ADD LETTER "T" TO BASIC PART NUMBER TO DESIGNATE TRANSLUBE OR DRY FILM LUBRICANT ONLY.
EXAMPLE: AF3213T4-03
- GOLD COLORED DRIVING ANVIL IDENTIFIES NOMINAL DIAMETER RIVETS.
- SPRIAL 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.	ALLMAX RIVET UNIVERSAL HEAD, LOCKED SPINDLE NOMINAL DIAMETER	STANDARD	
DRAWN BY: J.YOUSSEF	04/10/90	P	P.M.	08/05/08	6495		AF3213	AF3523
CHECKED: APPROVAL		Q	P.M.	10/20/10	7133		AF3223	
APPROVED: ON FILE		R	P.M.	09/11/15	9188			