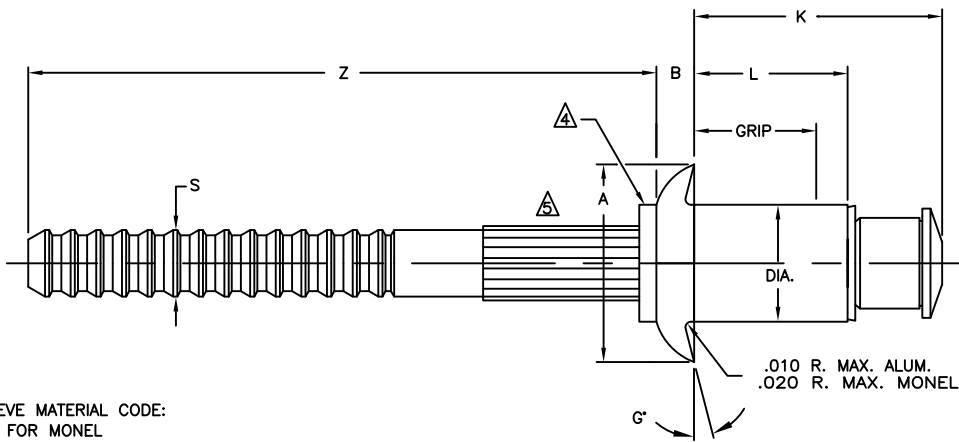
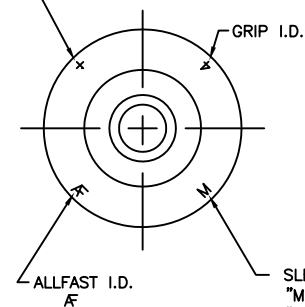


ALLFAST

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 -0.001	A DIA. ±.010	B ±.005	S DIA. REF.	Z MIN.	HOLE LIMITS	DRILL SIZE NO.	G MAX.
-4	.140	.250	.059	.081	.87	.143-.146	27	8"
-5	.173	.312	.072	.100	.94	.176-.180	16	8"
-6	.201	.375	.085	.117	.94	.205-.209	5	8"

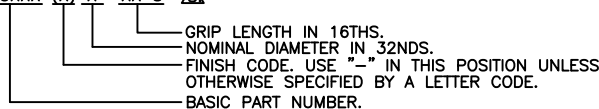
GRIP LIMITS MIN. MAX.	GRIP DASH NO.	-4 DIA.		-5 DIA.		-6 DIA.	
		L +.000 -0.025	K MAX.	L +.000 -0.030	K MAX.	L +.000 -0.030	K MAX.
.062	-01	.175	.37	.203	.43	.242	.45
.063	-125	.238	.46	.246	.47	.265	.50
.126	-187	.300	.52	.309	.53	.328	.55
.188	-250	.363	.58	.371	.60	.390	.62
.251	-312	.425	.65	.434	.66	.453	.68
.313	-375	.488	.71	.496	.72	.515	.74
.376	-437	.550	.78	.559	.79	.578	.82
.438	-500	.613	.84	.621	.85	.640	.89
.501	-562	.675	.90	.684	.91	.703	.95
.563	-625	.738	.96	.746	.98	.765	1.01
.626	-687			.809	1.04	.828	1.07
.688	-750					.890	1.14

RIVET NO.	MATERIAL			FINISH		
	SLEEVE	STEM	LOCK RING	SLEEVE	STEM	LOCK RING
AF3243 NAS9304B BACR15FR(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
AF3243A	5056 ALUM. ALLOY QQ-A-430	8740 ALLOY STEEL AMS 6322	A-286 CRES AMS 5731	MIL-DTL-5541 GOLD COLOR	CAD PLATE AMS-QQ-P-416 TYPE II CLASS II	PASSIVATE AMS2700
AF3253 NAS9304E BACR15FR(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
AF3553 NAS9310M BACR15FR(M)	MONEL QQ-N-281	PH 15-7 MO. CRES AMS 5657	A-286 CRES AMS 5731	NONE	PASSIVATE AMS2700	PASSIVATE AMS2700
AF3553R	MONEL QQ-N-281	PH 15-7 MO. CRES AMS 5657	A-286 CRES AMS 5731	NONE	PASSIVATE AMS2700	PASSIVATE AMS2700
AF3553P NAS9310MN BACR15FR(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
AF3553F NAS9310ML	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
AF3853 NAS9310C	INCONEL 600 AMS 5687	INCONEL X-750 AMS 5698	A-286 CRES AMS 5731	NONE	PASSIVATE AMS2700	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: AF3243T4-3
- ADD LETTERS "TL" TO BASIC PART NUMBER TO DESIGNATE TIO-LUBE 460
EXAMPLE: AF3253TL4-03
- SILVER COLORED DRIVING ANVIL IDENTIFIES OVERSIZE DIAMETER RIVETS.
- 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	R	P.M.	10/22/12	7935	AF3243	AF3553
CHECKED: APPROVAL		S	P.M.	10/08/14	8699	AF3253	AF3853
APPROVED: ON FILE		T	P.M.	07/21/17	9823	ALLMAX RIVET UNIVERSAL HEAD, LOCKED SPINDLE OVERSIZE DIAMETER	