

DIA. DASH NO.	∅A THEO ±.004	B REF	∅D +.003 - .001	∅P	∅S REF	Z MIN	INSTALLATION HOLE LIMITS	DRILL SIZE NO.
-4	.225	.041	.125	.109-.123	.088	.87	.129-.132	30(.129)
-5	.286	.054	.156	.136-.150	.107	.94	.160-.164	20(.161)
-6	.353	.069	.187	.161-.175	.126	.94	.192-.196	10(.194)
-8	.476	.095	.250	.214-.228	.169	.97	.256-.261	F(.257)

RIVET NO.	MATERIAL			FINISH		
	SLEEVE	STEM	LOCK RING	SLEEVE	STEM	LOCK RING
AF4172 NAS1399D(AB)	2017-T4 QQ-A-430	7075 QQ-A-430	5056-H38 QQ-A-430	MIL-DTL-5541	MIL-DTL-5541	NONE
AF4522P()-() NAS1399MW(AB)	MONEL QQ-N-281	A-286 AMS5731	MONEL QQ-N-281	CADMIUM PLATE AMS-QQ-P-416	PASSIVATE AMS-QQ-P-35	NONE
AF4522S()-() NAS1399MS(AB)	MONEL QQ-N-281	A-286 AMS5731	MONEL QQ-N-281	SILVER PLATE QQ-S-365	PASSIVATE AMS-QQ-P-35	NONE
AF4522()-() NAS1399M(AB)	MONEL QQ-N-281	A-286 AMS5731	MONEL QQ-N-281	DRY FILM LUBE	PASSIVATE AMS-QQ-P-35	NONE
AF4522F()-()	MONEL QQ-N-281	A-286 AMS5731	MONEL QQ-N-281	ALUM. COAT MIL-C-83488 TYPE II CLASS 3	PASSIVATE AMS-QQ-P-35	NONE
AF4622W()-() NAS1399CW(AB)	A-286 AMS5731	A-286 AMS5731	MONEL QQ-N-281	CADMIUM PLATE AMS-QQ-P-416	PASSIVATE AMS-QQ-P-35	NONE
AF4622S()-() NAS1399CS(AB)	A-286 AMS5731	A-286 AMS5731	MONEL QQ-N-281	SILVER PLATE QQ-S-365	PASSIVATE AMS-QQ-P-35	NONE
AF4622()-() NAS1399C(AB)	A-286 AMS5731	A-286 AMS5731	MONEL QQ-N-281	DRY FILM LUBE	PASSIVATE AMS-QQ-P-35	NONE
AF4622F()-() ABS0546D() ()	A-286 AMS5731	A-286 AMS5731	MONEL QQ-N-281	ALUM. COAT MIL-C-83488 TYPE II CLASS 3	PASSIVATE AMS-QQ-P-35	NONE

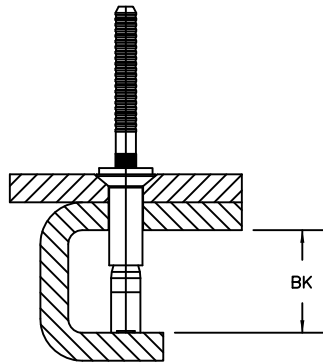
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REV.	DATE	BY	E.O. NO.	AB CODE 100° COUNTERSUNK HEAD LOCKED SPINDLE	PREPARED	CHECKED	APPROVED
Q	07/10/12	P.M.	7804		DANNY BASSETT	APPROVAL	
R	03/05/13	P.M.	8041		03/04/97	ON FILE	
S	06/25/13	P.M.	8171				
T	07/26/13	P.M.	8205				
U	04/22/14	P.M.	8482				
V	01/28/15	P.M.	8849				

ALLFAST

15200 DON JULIAN ROAD . CITY OF INDUSTRY CA. 91745
PHONE: (626) 968-9388

AF4172
AF4522
AF4622
PAGE 1 OF 2



MINIMUM BLIND-SIDE CLEARANCE FOR RIVET INSTALLATION

GRIP DASH NO	GRIP RANGE		DIA DASH NUMBER											
			-4			-5			-6			-8		
			L +.000 -.020	F MAX	BK MIN	L +.000 -.020	F MAX	BK MIN	L +.000 -.020	F MAX	BK MIN	L +.000 -.020	F MAX	BK MIN
-02	.125	.125	.260	.45	.39	.260	.44	.38	.260	.44	.36			
-03	.126	.187	.323	.57	.44	.323	.56	.43	.323	.55	.42	.385	.63	.50
-04	.188	.250	.385	.69	.50	.385	.67	.49	.385	.67	.49	.448	.75	.56
-05	.251	.312	.448	.81	.56	.448	.79	.54	.448	.78	.53	.510	.87	.62
-06	.313	.375	.510	.93	.62	.510	.91	.60	.510	.90	.59	.573	.99	.68
-07	.376	.437	.573	1.05	.67	.573	1.03	.65	.573	1.02	.64	.635	1.11	.73
-08	.438	.500	.635	1.17	.73	.635	1.15	.71	.635	1.14	.70	.698	1.23	.79
-09	.501	.562	.698	1.29	.79	.698	1.27	.77	.698	1.26	.76	.760	1.34	.84
-10	.563	.625	.760	1.41	.85	.760	1.44	.88	.760	1.43	.87	.823	1.52	.96
-11	.626	.687							.823	1.55	.92	.885	1.64	1.01
-12	.688	.750							.885	1.67	.99	.948	1.77	1.09
-13	.751	.812							.948	1.79	1.04	1.010	1.89	1.14
-14	.813	.875							1.010	1.91	1.10	1.073	2.01	1.20

NOTES:

1. COMPOSITION ONLY
2. MAY BE DRY FILM LUBED AT MANUFACTURER'S OPTION
3. HEAD DIAMETER MEASURED TO THEORETICAL SHARP CORNER
4. MIN GRIP: DIAMETER -4 =.063, DIAMETER -5 =.065, DIAMETER -6 =.080
5. ØP ANNEALED
6. EXAMPLE OF PART NUMBER:



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S	06/25/13	P.M.	8171				
T	07/26/13	P.M.	8205	ALLFAST 15200 DON JULIAN ROAD . CITY OF INDUSTRY CA. 91745 PHONE: (626) 968-9388	AF4172 AF4522 AF4622 PAGE 2 OF 2		
U	04/22/14	P.M.	8482				
V	01/28/15	P.M.	8849				