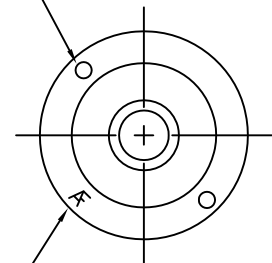


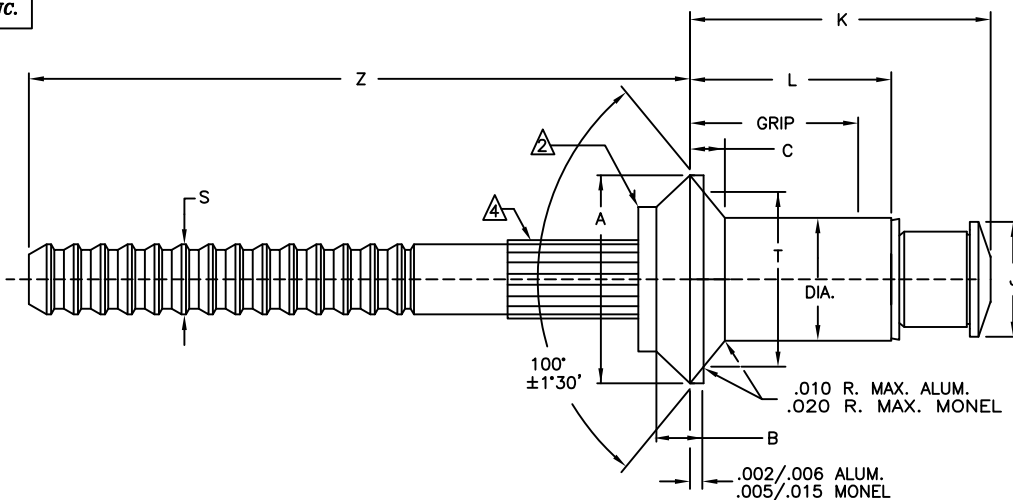
# ALLFAST

FASTENING SYSTEMS, Inc.

MATERIAL CODE  
TWO DOTS FOR MONEL/15-7  
ONE DOT FOR ALUM./15-7  
NO DOT FOR ALUM./STEEL



ALLFAST I.D.



LUBRICATION: AS REQUIRED FOR PERFORMANCE.  $\Delta$

DIA. DASH NO.	DIA. +.003 - .001	A ±.010	B +.010 - .000	C REF.	J MIN.	S REF.	T ±.005	Z MIN.	HOLE LIMITS	DRILL SIZE NO.
-4	.140	.220	.022	.011	.115	.081	.165	.87	.143-.146	27
-5	.173	.286	.030	.015	.140	.100	.208	.94	.176-.180	16
-6	.201	.353	.040	.023	.160	.117	.255	.94	.205-.209	5

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.
.033 .062	-01	.170	.39				
.063 .125	-02	.213	.43	.246	.46	.265	.50
.126 .187	-03	.276	.50	.309	.52	.328	.56
.188 .250	-04	.338	.56	.371	.59	.390	.62
.251 .312	-05	.401	.62	.434	.65	.453	.68
.313 .375	-06	.463	.68	.496	.71	.515	.75
.376 .437	-07	.526	.74	.559	.77	.578	.81
.438 .500	-08	.588	.80	.621	.83	.640	.87

AF3245 (X) X -X S  $\Delta$   
 INDICATES STRIP LOADED.  
 GRIP LENGTH IN 16THS.  
 NOMINAL DIAMETER IN 32NDS.  
 FINISH CODE.  
 BASIC PART NUMBER.

RIVET NO.	MATERIAL			FINISH		
	SLEEVE	STEM	LOCK RING	SLEEVE	STEM	LOCK RING
AF3245 9306B	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
AF3255 9306E	5056 ALUM. ALLOY QQ-A-430	PH 15-7 MO. CRES AMS 5657	A-286 CRES AMS 5731	MIL-DTL-5541 PLAIN COLOR	NONE	PASSIVATE AMS2700
AF3555 9312M	MONEL QQ-N-281	PH 15-7 MO. CRES AMS 5657	A-286 CRES AMS 5731	NONE	NONE	PASSIVATE AMS2700
AF3555P 9312MN	MONEL QQ-N-281	PH 15-7 MO CRES AMS 5657	A-286 CRES AMS 5731	ALUM. COAT NAS 4006	NONE	PASSIVATE AMS2700
AF3555F 9312ML	MONEL QQ-N-281	PH 15-7 MO CRES AMS 5657	A-286 CRES AMS 5731	MIL-C-83488 ALUM. COAT	NONE	PASSIVATE AMS2700
$\Delta$ AF3555R	MONEL QQ-N-281	PH 15-7 MO CRES AMS 5657	A-286 CRES AMS 5731	NONE	AF90	PASSIVATE AMS2700

NOTES:

2. DO NOT CLEAN OR DEGREASE PRIOR TO INSTALLATION.

$\Delta$  ADD LETTER "T" TO BASIC PART NUMBER TO DESIGNATE TRANSLUBE DRY FILM LUBRICANT ONLY.  
 EXAMPLE: AF3245T4-3

$\Delta$  GOLD COLORED DRIVING ANVIL IDENTIFIES NOMINAL DIAMETER RIVETS.

$\Delta$  HEAD MARKING VISIBLE AFTER INSTALLATION.

$\Delta$  SPIRAL KNURL OPTIONAL.

$\Delta$  "R" CODE-PARTS MAY HAVE AF90 OR MOLYBDENUM DISULFIDE AT MANUFACTURER'S OPTION ON STEM ONLY. AF90 IS A DRY FILM LUBRICANT.

$\Delta$  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.	FLANGED DOME HEAD LOCKED SPINDLE OVERSIZE DIAMETER	STANDARD	
DRAWN BY: L. VARGAS	02/17/89	G	L.D.	04/16/07	6066		AF 3245	AF 3255
CHECKED: <b>APPROVAL</b>		H	L.D.	06/22/07	6114		AF 3555	
APPROVED: <b>ON FILE</b>		J	P.M.	06/04/08	6432			