

DIA. DASH NO.	ØA ±.004	B REF	ØD +.003 - .001	ØP	ØS REF	Z MIN	INSTALLATION HOLE LIMITS	DRILL SIZE NO.	SPINDLE RETENTION LBS.	TENSILE LBS. (AF4624)	TENSILE LBS. (AF4524)
-4	.192	.028	.125	.109-.123	.088	.87	.129-.132	30(.129)	85	575	315
-5	.243	.037	.156	.136-.150	.107	.94	.160-.164	20(.161)	120	900	495
-6	.299	.046	.187	.161-.175	.126	.94	.192-.196	10(.194)	175	1350	740

-4 & -5 DIAMETER ONLY

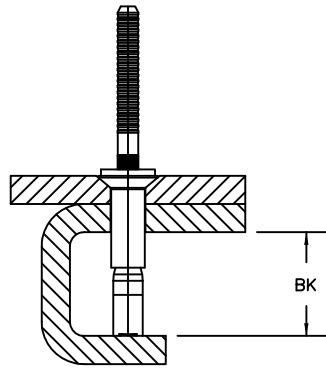
RIVET NO.	MATERIAL $\Delta$			FINISH		
	SLEEVE	STEM	LOCK RING	SLEEVE	STEM	LOCK RING
AF4524P()-()	MONEL QQ-N-281	A-286 AMS5731	MONEL QQ-N-281	CADMIUM PLATE AMS-QQ-P-416 TYPE II CLASS 2	PASSIVATE AMS2700	NONE
AF4524S()-()	MONEL QQ-N-281	A-286 AMS5731	MONEL QQ-N-281	SILVER PLATE QQ-S-365	PASSIVATE AMS2700	NONE
AF4524()-()	MONEL QQ-N-281	A-286 AMS5731	MONEL QQ-N-281	DRY FILM LUBE	PASSIVATE AMS2700	NONE
AF4524F()-()	MONEL QQ-N-281	A-286 AMS5731	MONEL QQ-N-281	ALUM. COAT MIL-DTL-83488 TYPE II CLASS 3	PASSIVATE AMS2700	NONE
AF4624W()-()	A-286 AMS5731	A-286 AMS5731	MONEL QQ-N-281	CADMIUM PLATE AMS-QQ-P-416 TYPE II CLASS 2	PASSIVATE AMS2700	NONE
AF4624S()-()	A-286 AMS5731	A-286 AMS5731	MONEL QQ-N-281	SILVER PLATE QQ-S-365	PASSIVATE AMS2700	NONE
AF4624()-()	A-286 AMS5731	A-286 AMS5731	MONEL QQ-N-281	PASSIVATE AMS2700 DRY FILM LUBE	PASSIVATE AMS2700	NONE
AF4624F()-()	A-286 AMS5731	A-286 AMS5731	MONEL QQ-N-281	ALUM. COAT MIL-DTL-83488 TYPE II CLASS 3	PASSIVATE AMS2700	NONE
AF4624F()-()PR $\Delta$	A-286 AMS5731	A-286 AMS5731	MONEL QQ-N-281	ALUM. COAT MIL-DTL-83488 TYPE II CLASS 3	PASSIVATE AMS2700	NONE
AF4624EA()-()	A-286 AMS5731	A-286 AMS5731	A-286 AMS5731	PASSIVATE AMS2700	PASSIVATE AMS2700	PASSIVATE AMS2700

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WILL NOT BE KEPT UP TO DATE**

REV.	DATE	BY	E.O. NO.	AB CODE NAS1097 100° SHEAR HEAD LOCKED SPINDLE	PREPARED	CHECKED	APPROVED
NC	07/11/11	P.M.	7374		PHILIP MCCURRIE		<b>APPROVAL</b>
A	07/10/12	P.M.	7804		07/11/11	<b>ON FILE</b>	
B	04/22/14	P.M.	8482				
C	06/05/15	P.M.	9048				

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

AF4524  
AF4624

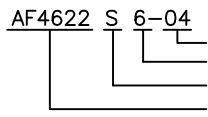


MINIMUM BLIND-SIDE CLEARANCE FOR RIVET INSTALLATION

GRIP DASH NO	GRIP RANGE		DIA DASH NUMBER								
			-4			-5			-6		
			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	.30	.263	.45	.28	.287	.48	.26
-03	.126	.187	.323	.57	.35	.326	.57	.34	.350	.60	.32
-04	.188	.250	.385	.69	.41	.388	.69	.39	.412	.72	.37
-05	.251	.312	.448	.81	.46	.451	.81	.45	.475	.83	.43
-06	.313	.375	.510	.93	.52	.513	.93	.50	.537	.95	.48
-07	.376	.437	.573	1.05	.57	.576	1.05	.56	.600	1.07	.54
-08	.438	.500				.638	1.15	.62	.662	1.19	.60
-09	.501	.562				.701	1.27	.67	.725	1.31	.65
-10	.563	.625				.763	1.44	.78	.787	1.48	.76
-11	.626	.687							.850	1.60	.82
-12	.688	.750							.912	1.72	.88
-13	.751	.812							.975	1.83	.94
-14	.813	.875							1.037	1.95	1.00

NOTES:

1. MATERIAL DESIGNATION REFERS TO CHEMICAL 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. PARTS ARE MANUFACTURED BARE. IF LUBE IS REQUIRED, USE AF90 ONLY.
7. AN INCREASE OF .001 IS PERMISSIBLE WITHIN .100 OF BASE OF HEAD.
8. SHEET THICKNESS FOR MACHINE COUNTERSUNK HOLES SHALL NOT BE LESS THAN "B" +.010.
9. GOLD COLORED DRIVING ANVILS IDENTIFIES NOMINAL DIAMETER RIVETS.
10. RECOMMENDED MINIMUM BLIND SIDE MATERIAL AND THICKNESS:  
MATERIAL: 7075 ALUMINUM OR STRONGER  
THICKNESS: 1/3 DIAMETER MINIMUM
11. PROCUREMENT SPECIFICATION: NAS1400, CLASS 2 REQUIREMENT UNLESS OTHERWISE NOTED.  
SHAVED SPINDLE RETENTION DOES NOT APPLY.
12. 100° ANGLE AND "A" THEORETICAL ARE MEASURED BEFORE FINISH AND LUBRICATION.
13. EXAMPLE OF PART NUMBER:



GRIP LENGTH IN 16THS  
NOMINAL DIAMETER IN 32NDS.  
FINISH CODE.  
BASIC PART NUMBER.

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C	06/05/15	P.M.	9048		AF4524 AF4624		
				15200 DON JULIAN ROAD . CITY OF INDUSTRY CA. 91745			
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