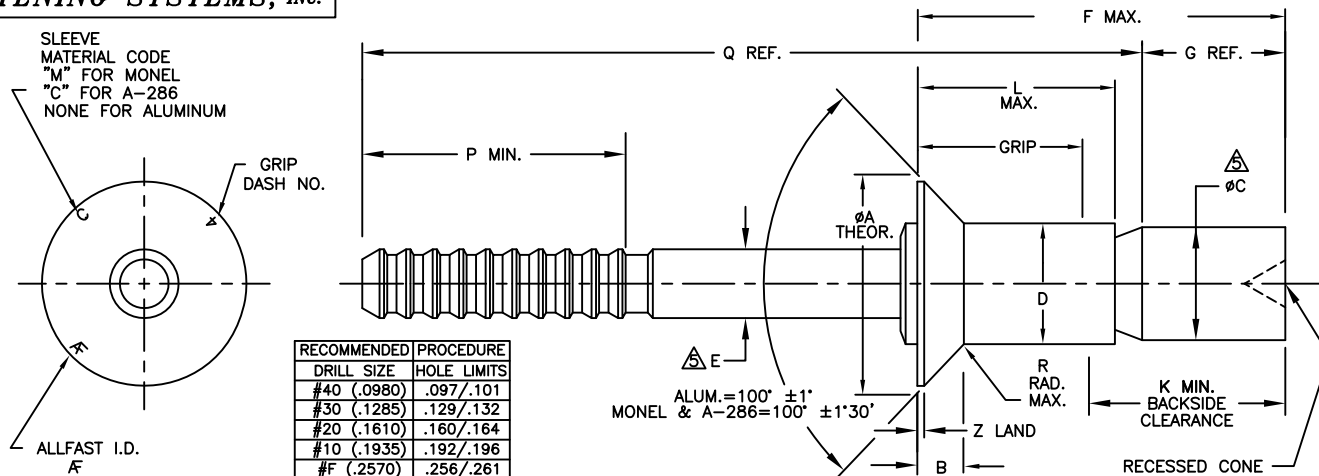


# ALLFAST

FASTENING SYSTEMS, INC.



RECOMMENDED DRILL SIZE	PROCEDURE HOLE LIMITS
#40 (.0980)	.097/.101
#30 (.1285)	.129/.132
#20 (.1610)	.160/.164
#10 (.1935)	.192/.196
#F (.2570)	.256/.261

DIA. DASH NO.	NOM. DIA.	A DIA. THEOR.	B REF.	C DIA.	D DIA.	E DIA.	P MIN.	R. RAD.		Z LAND	
								ALUM.	MONEL A-286	ALUM.	MONEL A-286
-3	3/32	.179 ±.004	.036		.097/.093		.375	.010	.020		
-4	1/8	.225 ±.004	.042		.128/.124		.375	.010	.020		
-5	5/32	.286 ±.004	.055	△	.159/.155		.375	.010	.020	.006	.015
-6	3/16	.353 ±.004	.070	△	.190/.186	△	.375	.010	.020	.002	.005
-8	1/4	.476 ±.004	.095		.253/.249		.375	.010	.020		

GROUP	Q REF.				
	-3	-4	-5	-6	-8
A	1.78	1.79	1.81	1.85	1.97
B			2.06	2.10	2.22
C				2.35	2.47

GRIP LIMITS	RIVET GROUP	GRIP DASH NO.	-3 DIA.			-4 DIA.			-5 DIA.			-6 DIA.			-8 DIA.									
			F MAX.	G REF.	K L MAX.	F MAX.	G REF.	K L MAX.	F MAX.	G REF.	K L MAX.	F MAX.	G REF.	K L MAX.	F MAX.	G REF.	K L MAX.							
.125	A	-2	.39	.131	.22	.219	.45	.147	.30	.260	.44	.127	.28	.263	.48	.107	.27	.287						
.126		-3	.49	.172	.26	.281	.57	.203	.35	.323	.56	.183	.34	.325	.60	.163	.32	.350	.63	.179	.32	.385		
.188		-4	.59	.211	.30	.344	.69	.259	.41	.385	.67	.239	.39	.388	.72	.219	.37	.412	.75	.235	.37	.448		
.251		-5	.70	.254	.35	.406	.81	.315	.46	.448	.79	.295	.45	.451	.83	.275	.43	.475	.87	.291	.43	.510		
.313		-6	.81	.295	.39	.469	.93	.371	.52	.510	.91	.351	.50	.513	.95	.331	.48	.537	.99	.347	.48	.573		
.376		-7	.965	.386	.590	.542	1.05	.437	.57	.563	1.03	.407	.56	.576	1.07	.387	.54	.600	1.11	.403	.54	.635		
.438		-8	1.080	.449	.643	.605	1.17	.493	.63	.625	1.15	.463	.62	.638	1.19	.443	.60	.662	1.23	.459	.60	.698		
.501		-9	1.195	.511	.695	.668	1.290	.605	.790	.698	1.27	.519	.67	.701	1.31	.499	.65	.725	1.34	.515	.65	.760		
.563		B	-10																					
.626	-11														1.60	.611	.76	.850	1.64	.627	.76	.885		
.688	-12														1.72	.667	.82	.912	1.77	.683	.82	.948		
.751	-13																		1.89	.739	.87	1.010		
.813	C	-14																	2.01	.795	.93	1.073		

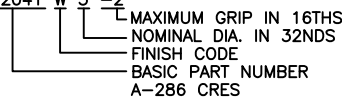
BASIC PART NO.	MATERIAL			FINISH		
	SLEEVE	STEM	LOCK RING	SLEEVE	STEM	LOCK RING
AF2001()-() NAS1399D()-()	2017-T4 QQ-A-430	7075 QQ-A-430	5056-H38 QQ-A-430	CHEM FILM GOLD PER MIL-DTL-5541	CHEM FILM GOLD PER MIL-DTL-5541	NONE
AF2051()-() NAS1399B()-()	5056-F QQ-A-430	7075 QQ-A-430	5056-H38 QQ-A-430	CHEM FILM ORANGE PER MIL-DTL-5541		
AF2091()-() NAS1399M()-()	MONEL QQ-N-281	MONEL QQ-N-281 OR A-286 AMS 5731	MONEL QQ-N-281	CAD PLATE PER AMS-QQ-P-416 TYPE II, CLASS 2 WHEN SPECIFIED BY CODE LETTER "W" OR SILVER PLATE PER QQ-S-365 WHEN SPECIFIED BY CODE LETTER "S"	MONEL:NONE A286:PASSIVATE PER AMS2700	NONE
AF2041()-() NAS1399C()-()	A-286 AMS5731	A-286 AMS5731	MONEL QQ-N-281			
AF2471()-()	7050-T73 QQ-A-430	A-286 AMS5731	MONEL QQ-N-281	CHEM FILM GOLD PER MIL-DTL-5541		

PROCUREMENT SPEC: NAS1400 AS APPLICABLE.

NOTES:

DIA. DASH NO.	MIN. GRIP
-3	.063
-4	.063
-5	.075
-6	.080
-8	.125

PART NUMBER CODE: AF2041 W 5 -2



- △ LUBRICATION: AS REQUIRED FOR PERFORMANCE, UNPLATED MONEL OR A-286 COMPONENTS MAY BE LUBRICATED WITH SOLID FILM (MoS ) LUBRICANT.
- △ AFTER BASIC PART NO., ADD "FC" TO INDICATE CHEMICAL FILM TREATMENT, "P" TO INDICATE ANODIZE, "W" TO INDICATE CADMIUM PLATE, "S" TO INDICATE SILVER PLATE FINISH ON SLEEVES, "TL" TO INDICATE DRY FILM LUBE ONLY, "WTL" TO INDICATE CADMIUM PLATE WITH DRY FILM LUBE ONLY, "PR" TO INDICATE AF90 DRY FILM LUBE ONLY, "WPR" TO INDICATE CADMIUM PLATED SLEEVE WITH AF90 DRY FILM LUBE ONLY.
- △ RIVET GROUP REFERS TO SHIFT POINT SETTING.
- △ NOT TO EXCEED RIVET DIAMETER.
- △ LENGTHS BELOW HEAVY LINE ARE NOT SHOWN ON NAS1399.
- △ FOR GRIP LENGTHS LONGER THAN SHOWN IN TABLE REFER TO AF2041-3 PART STANDARD.

**UNCONTROLLED COPY  
WILL NOT BE KEPT UP TO DATE**

FED. IDENT. CODE 53551

BY:	DATE:	REVISION	BY:	DATE:	E.O. NO.	STANDARD
PREPARED: KURT M. SABIN	06-16-92	J	L.D.	06/22/07	6114	
CHECKED: APPROVAL		K	P.M.	06/17/08	6444	
APPROVED: ON FILE		L	P.M.	12/04/17	10015	

BLIND RIVET  
FLUSH HEAD, LOCKED STEM