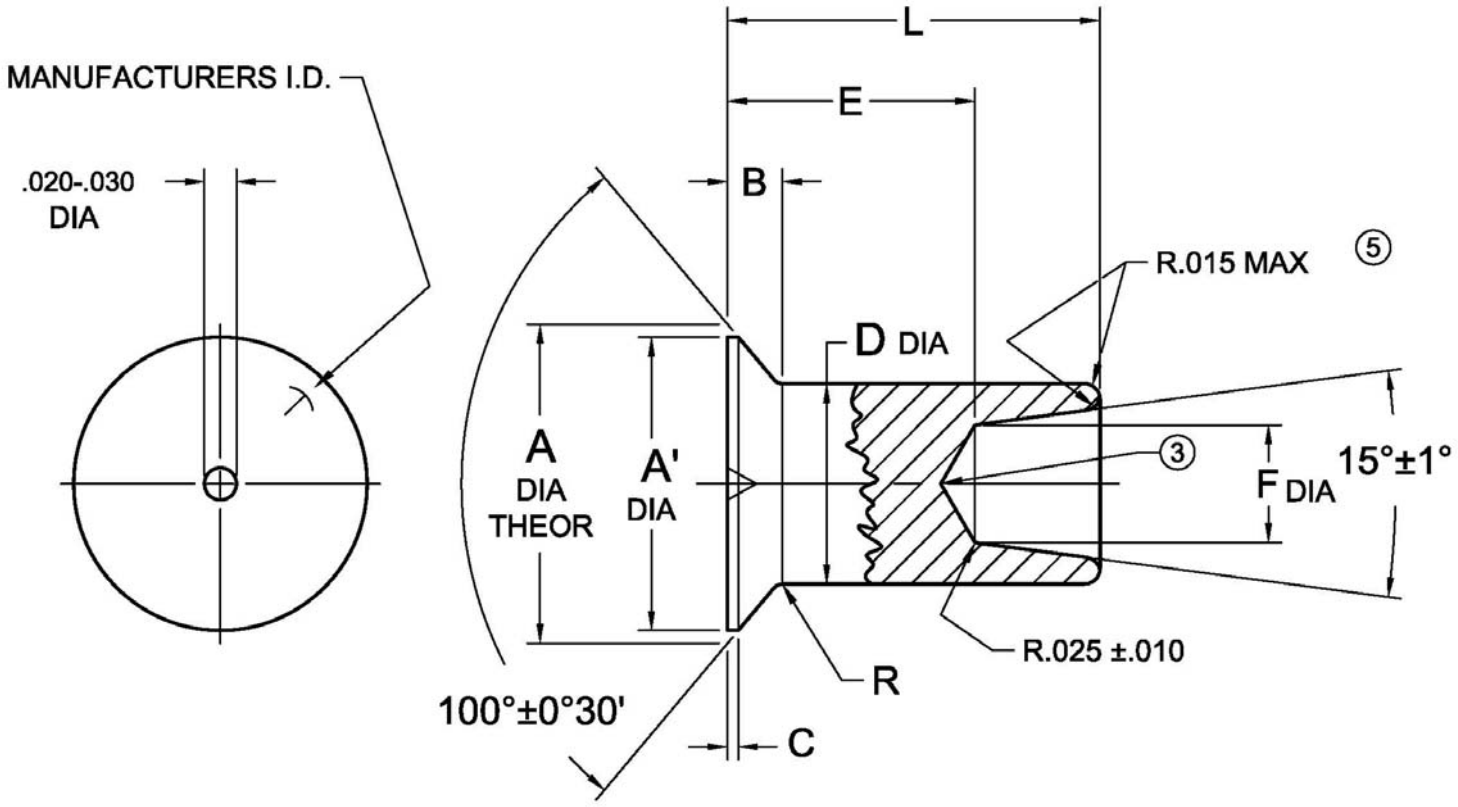


TABLE I

DIA. DASH NO.	A ±.004	A' MIN	B REF	C MAX	D +.003 -.001	F ±.005	R ±.005
-5	.286	.263	.055	.010	.156	.091	.020

NOTICE: ALL DIMENSIONS ARE IN INCHES AND APPLY AFTER FINISH AND BEFORE LUBRICATION UNLESS OTHERWISE SPECIFIED.

WARNING: FASTENERS MAY NOT PERFORM PROPERLY IF ALTERED FROM THE MANUFACTURER'S AS-SHIPPED CONDITION OR INSTALLED IN CONDITIONS OTHER THAN SPECIFIED HEREIN.

PROCUREMENT SPECIFICATION:	CHERRY® HOLLOW-ENDED E-Z BUCK® 100° FLUSH HEAD	SHEET 1 OF 3			PART NUMBER
PS-HEEZB-900		ISSUE	04-19-95		CSR90233
NAS 523 CODE:		REV.	G	7-30-15	

TABLE II

FINISH CODE	FINISH	LUBRICATION
- - -	NONE	NONE
E ⑦	ALUMINUM COATING PER NAS 4006	
F	PHOSPHATE FLUORIDE PER BAC 5861	
G ⑦	IVD ALUMINUM COATING PER MIL-DTL-83488	
W	ANODIZE BLUE PER ISO 8080	
GE ⑦ ⑨	ALUMINUM COATING PER NAS 4006 CLASS NC	
GG ⑦ ⑨	IVD ALUMINUM COATING PER MIL-DTL-83488 CL 3 TYPE II (SUPPLEMENTAL: MIL-DTL-5541 CL 1A, TYPE II)	

TABLE III

GRIP DASH NO.	GRIP RANGE		-5 DIA	
	MIN	MAX	L ±.010	E ±.005
-6	.157	.187	.218	.079
-7	.188	.219	.250	.110
-8	.220	.250	.281	.141
-9	.251	.281	.312	.172
-10	.282	.312	.343	.203
-11	.313	.343	.375	.235
-12	.344	.375	.406	.266
-13	.376	.407	.437	.297
-14	.408	.438	.468	.328
-15	.439	.469	.500	.360
-16	.470	.500	.531	.391
-17	.501	.531	.562	.422
-18	.532	.562	.593	.453
-19	.563	.594	.625	.485
-20	.595	.625	.656	.516
-21	.626	.656	.687	.547
-22	.657	.687	.718	.578
-23	.688	.719	.750	.610
-24	.720	.750	.781	.641
-25	.751	.781	.812	.672
-26	.782	.812	.843	.703
-27	.813	.843	.875	.735
-28	.844	.875	.906	.766
-29	.876	.907	.937	.797
-30	.908	.938	.968	.828
-31	.939	.969	1.000	.860
-32	.970	1.000	1.031	.891

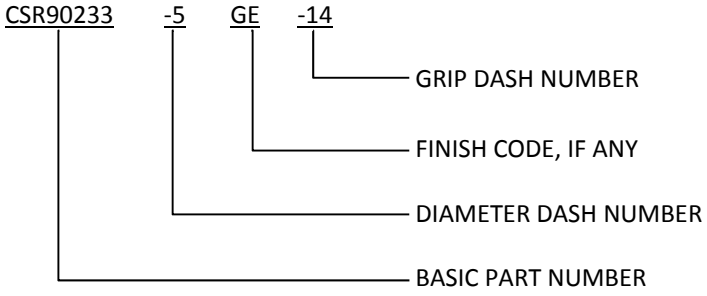
MATERIAL : 55 Ti-45 Cb TITANIUM ALLOY; CHEMICAL COMPOSITION PER AMS 4982.
HYDROGEN CONTENT OF FINISHED PRODUCT TO BE 85 PPM MAXIMUM.

HEAT TREAT : ANNEALED

NOTES:

1. A .001 INCREASE IN "D" DIAMETER IS PERMISSIBLE WITHIN .100 OF THE BASE OF THE HEAD.
2. CONICAL SURFACE OF HEAD AND RECESS TO BE CONCENTRIC TO "D" DIAMETER WITHIN .005 F.I.M.
3. BOTTOM CONFIGURATION OF RECESS IS OPTIONAL.
4. HEAD COCKING ANGLE RELATIVE TO AXIS OF RIVET 1/2° MAXIMUM.
5. FREE FLOW OF MATERIAL IN THIS AREA MAY BE ROUND, FLAT OR CHAMFERED.
6. RECESS CONFIGURATION IS COVERED UNDER BOEING PATENT #4,221,041 AND LICENSE AGREEMENT BETWEEN CHERRY AEROSPACE LLC AND THE BOEING COMPANY.
7. DIMENSIONS APPLY AFTER PLATING AND COATING, BUT ARE EXCLUSIVE OF LUBRICATION.
8. LOCALIZED UNDERFILL ON END OF RIVET NOT TO EXCEED .005 BELOW MINIMUM LENGTH.
9. FINISH CODES WITH THE PREFIX "G" INDICATE REACH COMPLIANT COATING.

EXAMPLE OF CHERRY PART NUMBER:



STANDARDS PAGE REVISION LOG CSR90233

REV LTR	DATE	DCR NUMBER	REVISION DESCRIPTION	COMP. BY
G	7-30-15	15-0731	• REMOVED NOTE 7 • RENUMBERED REMAINING NOTES	MC