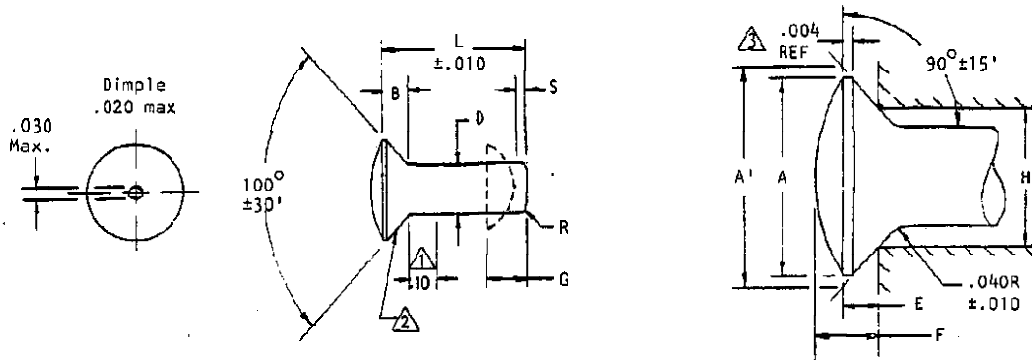


STANDARDS SHEET



Dash No.	A' 	A 	B 	D 	E 	F 	G	H	R	S
	To Sharp Corner Max.	Max. Min.	Max.	+ .003 - .001	Max. Min.	Max. Min.	REF	Max. Min.	Rad ± .010	+ .000 - .010
-4	.230	.221 .214	.045	.125	.0110 .0017	.017 .015	.188	.1992 .1990	.039	.031
-5	.292	.282 .275	.058	.156	.0130 .0018	.019 .017	.234	.2560 .2558	.049	.039
-6	.358	.348 .341	.073	.187	.0150 .0019	.022 .019	.281	.3174 .3172	.059	.047

DIA \ L	LENGTH AND DASH NUMBER													
	.187	.250	.312	.375	.437	.500	.562	.625	.750	.875	1.000	1.125	1.250	
.125	4-3	4-4	4-5	4-6	4-7	4-8	5-9	4-10	4-12	4-14	4-16	4-18	4-20	
.156		5-4	5-5	5-6	5-7	5-8	5-9	5-10	5-12	5-14	5-16	5-18	5-10	
.187			6-5	6-6	6-7	6-8	6-9	6-10	6-12	6-14	6-16	6-18	6-20	

- NOTES:
-  Max. D + .001 permissible within .10 inch of base of head.
 -  Concentricity: Conical surface of head to shank within .005 TIR.
 -  Actual land width resulted from dimensions A and E.
 -  Dimensions A' and B are for reference only and not for inspection purposes.
 -  Shank diameter tolerance: Hold to within .10 inch of base of head.
 -  Dimensions A, E and F define rivet head profile.
 - Head cocking angle relative to axis of rivet 1/2° max.
 - In order that the CSP 310 rivet can be installed .002/.005 proud as required, a slightly larger CSK is necessary (than would be for MS20426 rivets) to accommodate the head/shank radius 'R'. This increased CSK diameter translates into a .007 deeper CSK and this may be of concern in thin gauges.
 - It is good practice to have grip lengths no more than 4X rivet diameter.

Procurement Specification: MIL-R-5674 except as noted.

Material: 2117-T4 per QQ-A-430, material code 'AD'.

Finish: Anodize to MIL-A-8625 Type II, Class 2 colour gold to Sandoz dye #201 with concentration 3 grams per litre or equivalent.

Example of part number: CSP 310AD5-6 = 2117-T4 rivet, .156 dia., .375 long.

Fastener Code: 'XA'

DRAWN	KROMKAMP	CLASSIFICATION	STANDARD
CHECKED	SCHRATTNER	RIVET, SOLID - 100° FLUSH HEAD, ALUMINUM ALLOY	CSP 310
STRESSED	KARBE		
APPROVED	J. THOMPSON		

Redrawn, head geometry redefined P. LAM. 04.02.88

(K)