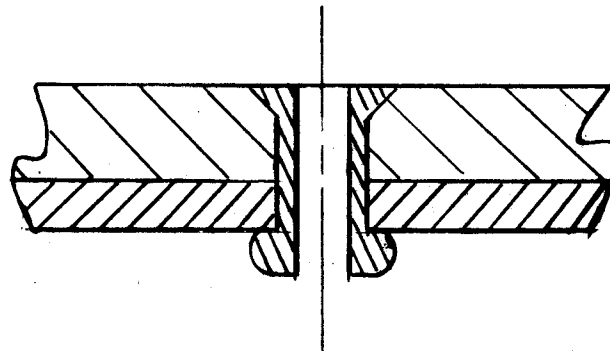
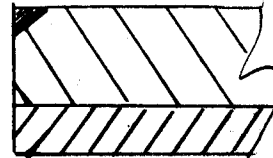
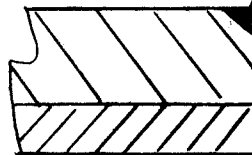


STANDARDS SHEET



1. Install rivet (see table) using adhesive ~~E62216 to PPS 25.52~~
 (A) Loctite Superbonder 430 to PPS 25.56.

Finish rivet flush and apply F1 protective finish.



2. Drill out rivet as shown to original dia.

(B)

For MS20426 C'sk Size	USE
-3	CR116/CR9126-3
-4	CR116/CR9126-4
-5	CR116/CR9126-5
-6	CR116/CR9126-6
-8	CR116/CR9126-8

NOTES:

1. DS102 shall be used when it is necessary to fill a rivet countersink to accommodate added structure while still employing the same hole for fastening.
2. See CSP 390 for C'sk filling plugs for use with screws, lockbolts and rivets in large quantities
3. DS 102 replaces 7Z0245

DRAWN	KRM/KAMD	CLASSIFICATION	STANDARD
CHECKED	P. LAM	REPAIR - COUNTERSUNK RIVET HOLES	DS102
STRESSED	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		

FEB 12 85

CR9126 added as alternative P. Lam 21.04.88

Adhesive changed P. Lam 12.12.85

(A)