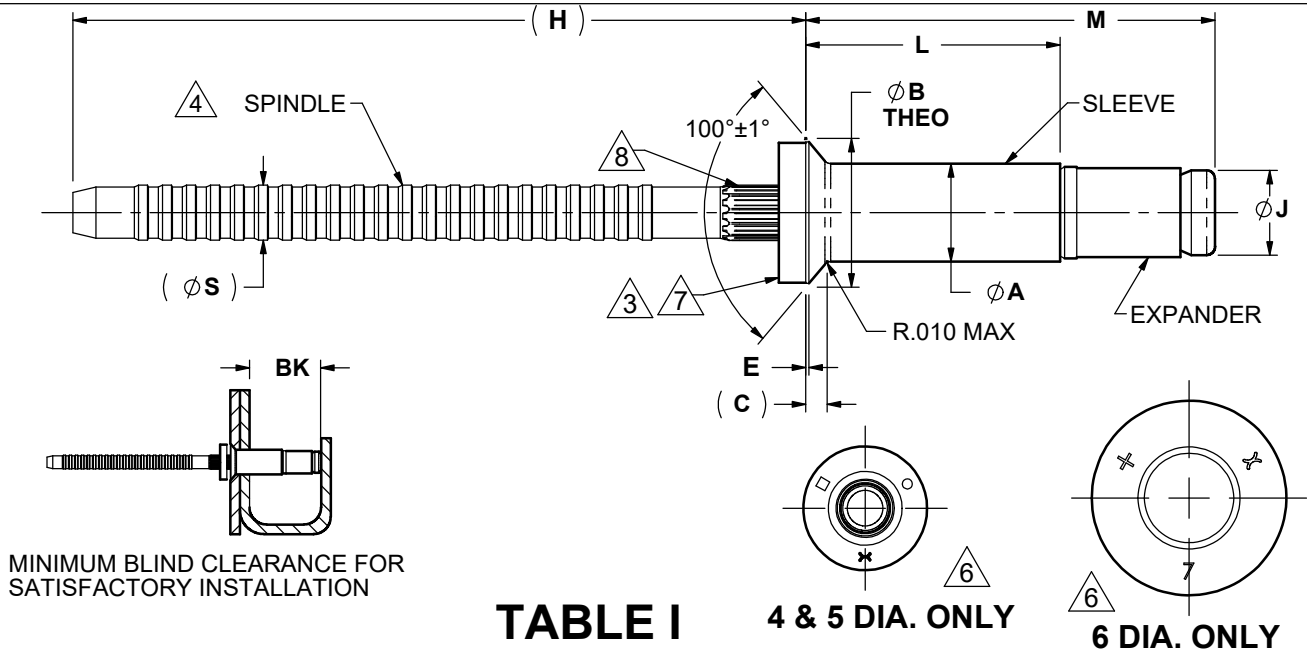




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**HuckMAX<sup>®</sup>**  
**ENGINEERING  
STANDARD**



**TABLE I**

**4 & 5 DIA. ONLY**

**6 DIA. ONLY**

NOMINAL PART NUMBER	NOM. DIA. NO.	Ø A +.003 -.001	Ø B THEO DIA. ±.004	BK MIN.	( C )	E	( H )	Ø J MAX	( Ø S )	SINGLE SHEAR 1	TENSILE 1 5	INSTALLED SPINDLE RETENTION	HOLE LIMITS
HR3224-4-( )	-4	.126	.192	.355	.028	.010 .002	.870	.129	.081	SEE SHEET THREE	250	125	.132 .129
HR3224-5-( )	-5	.157	.243	.370	.037	.012 .002	.940	.160	.100		390	200	.164 .160
HR3224-6-( )	-6	.189	.299	.415	.046	.012 .002	.940	.192	.117		560	290	.196 .192

**NOTES:**

1. MINIMUM ULTIMATE SHEAR AND TENSILE STRENGTH, IN POUNDS, OF INSTALLED RIVET.
2. LUBRICATION: LUBRICATE PER NAS 1686
3. GOLD COLOR DRIVING ANVIL IDENTIFIES NOMINAL DIAMETER RIVET.
4. SPINDLE CONFIGURATION - PULLING SERRATION DIMENSIONS SHALL BE PER NAS 9315.
5. APPLIES TO GRIPS 4-03 MAX, 5-03 MAX, 6-04 MAX AND UP.
6. IDENTIFICATION: HUCK SYMBOL, "+" SIGN AND GRIP NUMBER (Ø6 HEAD STYLE), OR HUCK SYMBOL, A "DOT" (ALUM/CRES MATERIAL) AND A "SQUARE" (Ø4 & Ø5 HEAD STYLE). LOCATION AND DIRECTION OPTIONAL.
7. WASHER ANVIL MAY BE LOCATED IN THIS AREA AND IS NOT PART OF THE INSTALLED FASTENER.
8. OPTIONAL SPLINE CONFIGURATION. KNURLED TO RETAIN FASTENER ASSEMBLY. NOT PART OF INSTALLED FASTENER.
9. STYLE A, CLASS 3, CODE E PER NAS 1686.

DIMENSIONS IN INCHES

M	PER ECN 15111: CORRECTED MINIMUM GRIP FOR -5-02.		CURRENT DESIGN ACTIVITY CAGE CODE 0HDW7		PROCUREMENT SPEC NAS1686	DRAWN BY C. MARTINEZ	
			HuckMAX®, NOMINAL 100° FLUSH SHEAR HEAD, 5056 ALUMINUM SLEEVE/A-286 STAINLESS STEEL PIN		CHECKED BY	SIGNATURE ON FILE	
ISSUED	10/8/1993	HR3224-( )-( )					
REVISED	07/27/2022						
PAGE	1 OF 3	BLR139					

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**TABLE II**

GRIP DASH NO.	HR3224-4 (.126 DIA.)				HR3224-5 (.157 DIA.)				HR3224-6 (.189 DIA.)			
	DESIGN GRIP RANGE		L +.000 -.030	M MAX	DESIGN GRIP RANGE		L +.000 -.030	M MAX	DESIGN GRIP RANGE		L +.000 -.030	M MAX
	MIN.	MAX.			MIN.	MAX.			MIN.	MAX.		
02	.045*	.125	.224	.45	.065	.125	.230	.47	.080	.125	.262	.51
03	.126	.187	.287	.51	.126	.187	.293	.53	.126	.187	.325	.57
04	.188	.250	.349	.57	.188	.250	.355	.59	.188	.250	.387	.64
05	.251	.312	.412	.63	.251	.312	.418	.65	.251	.312	.450	.70
06	.313	.375	.474	.70	.313	.375	.480	.72	.313	.375	.512	.76
07	.376	.437	.537	.76	.376	.437	.543	.77	.376	.437	.575	.82
08	.438	.500	.599	.82	.438	.500	.605	.84	.438	.500	.637	.88
09	.501	.562	.662	.88	.501	.562	.668	.90	.501	.562	.700	.95
10					.563	.625	.730	.96	.563	.625	.762	1.01
11					.626	.687	.793	1.02	.626	.687	.825	1.07
12									.688	.750	.887	1.13

\* FOR FASTENERS MANUFACTURED PRIOR TO 1-1-04, MIN GRIP WAS .063

**TABLE III**

INSTALLED WEIGHT-LBS/1000 PCS					
HR3224-4		HR3224-5		HR3224-6	
02	.73	02	1.14	02	1.75
03	.88	03	1.36	03	2.07
04	1.01	04	1.58	04	2.40
05	1.15	05	1.80	05	2.73
06	1.28	06	2.02	06	3.06
07	1.42	07	2.24	07	3.39
08	1.55	08	2.46	08	3.72
09	1.69	09	2.68	09	4.05
		10	2.90	10	4.38
		11	3.12	11	4.71
				12	5.04

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ISSUED	10/8/1993	HuckMAX®, NOMINAL 100° FLUSH SHEAR HEAD, 5056 ALUMINUM SLEEVE/A-286 STAINLESS STEEL PIN				HR3224-( )-( )
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

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**TABLE I V**

SINGLE SHEAR STRENGTH			SINGLE SHEAR STRENGTH			SINGLE SHEAR STRENGTH		
NOMINAL DIAMETER	GRIP DASH NO. 	MINIMUM SINGLE SHEAR STRENGTH (LBS)	NOMINAL DIAMETER	GRIP DASH NO. 	MINIMUM SINGLE SHEAR STRENGTH (LBS)	NOMINAL DIAMETER	GRIP DASH NO. 	MINIMUM SINGLE SHEAR STRENGTH (LBS)
.126	-02	411	.157	-02		.189	-02	
	-03	531		-03	714		-03	918
	-04	651		-04	862		-04	1095
	-05	664		-05	1010		-05	1310
				-06	1030		-06	1455
							-07	1480

-  FOR RIVET GRIPS GREATER THAN LISTED, USE HIGHEST VALUE SHOWN FOR THE DIAMETER
-  PARTS TOO SHORT TO BE TESTED.

**TABLE V**

RIVET COMPONENTS	MATERIAL	FINISH
SLEEVE	5056 ALUMINUM PER QQ-A-430	CLEAR CHROMATE PER MIL-DTL-5541, TYPE 1, CLASS 1A
SPINDLE	A-286 STAINLESS STEEL AMS 5737	PASSIVATE PER AMS-QQ-P-35 AND AMS2700 METHOD 1, TYPE 2 OR 8, CLASS 1
EXPANDER	A-286 STAINLESS STEEL AMS 5737	PASSIVATE PER AMS-QQ-P-35 AND AMS2700 METHOD 1, TYPE 2 OR 8, CLASS 1
WASHER	ALLOY STEEL	GOLD CHROMATE
LOCK RING	A-286 STAINLESS STEEL AMS 5731	PASSIVATE PER AMS-QQ-P-35 AND AMS2700 METHOD 1, TYPE 2 OR 8, CLASS 1

PART NUMBER EXAMPLE:

HR 32 24-5-( )

- MAX GRIP LENGTH IN 1/16 INCH INCREMENTS
- RIVET DIAMETER IN 1/32 INCH INCREMENTS
- HEAD TYPE: NAS 1097 100° FLUSH HEAD RIVET
- SLEEVE DIA. AND PIN MATERIAL: NOMINAL DIA./A-286 STAINLESS STEEL PIN
- MATERIAL COMBINATION: 5056 ALUMINUM SLEEVE/A-286 STAINLESS STEEL PIN
- HuckMAX<sup>®</sup> RIVET

DIMENSIONS IN INCHES

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