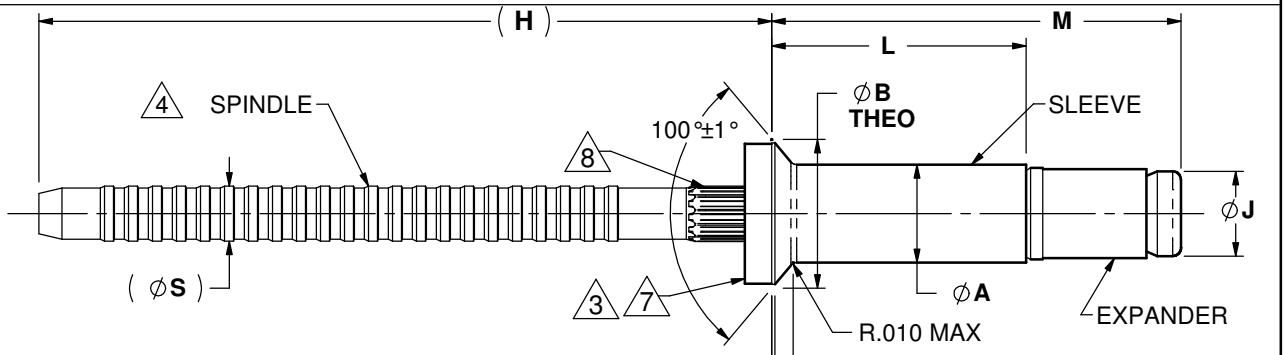
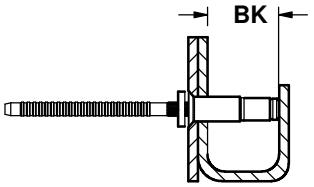
ARCONIC

Arconic Fastening Systems and Rings
Tucson Operations
3724 East Columbia Street
Tucson, Arizona 85714 USA
Phone (520) 519-7400
Fax (520) 519-7454

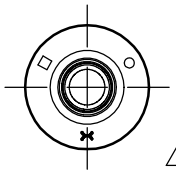
HuckMAX®

ENGINEERING STANDARD



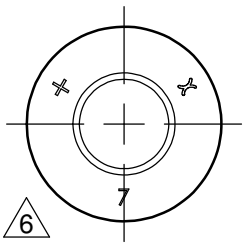


MINIMUM BLIND CLEARANCE FOR SATISFACTORY INSTALLATION



6

4 & 5 DIA. ONLY



6

6 DIA. ONLY

TABLE I

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 (∅6 HEAD STYLE), OR HUCK SYMBOL, A "DOT" (ALUM/CRES MATERIAL) AND A "SQUARE" (∅4 & ∅5 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

K	PER DCN 13721	Current Design Activity CAGE Code OHDW7	PROCUREMENT SPEC NAS1686	DRAWN BY	C. MARTINEZ
				CHECKED BY	SIGNATURE ON FILE
ISSUED	10/8/1993	® HuckMAX , NOMINAL, 100° FLUSH SHEAR HEAD, 5056 ALUMINUM SLEEVE/A-286 STAINLESS STEEL PIN	HR3224-( )-( )		
REVISED	3/27/2015				
PAGE	1 OF 3		BLR139		

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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	.063	.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 I I I

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 REVISED 3/27/2015 PAGE 2 OF 3		® HuckMAX , NOMINAL, 100° FLUSH SHEAR HEAD, 5056 ALUMINUM SLEEVE/A-286 STAINLESS STEEL PIN		**HR3224-( )-( )** **BLR139**

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TABLE I V

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

△A FOR RIVET GRIPS GREATER THAN LISTED, USE HIGHEST VALUE SHOWN FOR THE DIAMETER

△B 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® RIVET

DIMENSIONS IN INCHES

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