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CherryMAX® Rivet CR3212-4-04

CR3212-4-04 is a high-strength, flush-head rivet from the CherryMAX® series, designed for use in aerospace applications. With its mechanically locked stem and 100° flush countersunk head, it provides reliable blind-side installation and visually inspectable locking. Full compliance with aerospace standards (NAS, MIL-SPEC).

Basic Specifications

- Shank Diameter: 1/8 inch (≈ 0.125 inch)
- Grip Range: 0.188 – 0.250 inch
- Overall Length: 0.313 – 0.333 inch
- Head Diameter: ≈ 0.229 inch
- Head Height: ≈ 0.041 inch
- Head Style: 100° flush countersunk
- Sleeve — Aluminum alloy 5056
- Mandrel — Steel 8740, cadmium plated
- Standards Compliance: NAS9302B, MIL-SPEC
- Manufacturer: Cherry Aerospace, USA.

Material Thickness Selection Guidelines

- Suitable for stack thickness between 4.8 and 6.35 mm
- For thinner materials, use CR3212-4-02 or CR3212-4-03
- For greater thickness, use CR3212-4-05
- Recommended installation tool: Cherry G27 or equivalent pneumatic riveter.

Part Identification and Marking Structure

- CR — CherryMAX series (mechanically locked stem)
- 32 — Rivet type (universal series)
- 12 — Flush head configuration
- 4 — Nominal shank diameter 1/8 inch
- 04 — Length code for grip range 0.188 – 0.250 inch.

Key Features and Installation Characteristics

- 100° flush countersunk head designed for countersunk holes
- Recommended hole diameter: 0.129 – 0.132 inch
- Mechanically locked stem with audible and visible “click” confirmation
- Blind installation without backside access
- Stem remains captured inside the sleeve with no protrusion after installation.

Coating and Visual Identification Notes

- Sleeve has chromate conversion coating with a golden tint
- Mandrel has cadmium coating in a silver-gray color
- Markings may include: CR3212-4-04 or AF3212-4-04 (equivalent).

Additional Technical Characteristics

- Body Material: Aluminum 5056
- Mandrel Material: Alloy Steel 8740
- Shear Strength: up to 50,000 PSI
- Tensile Strength: up to 75,000 PSI
- Operating Temperature Range: -54°C to $+120^{\circ}\text{C}$
- Minimum Countersink Depth: 0.030 inch
- Head Seat Radius: 0.090 – 0.110 inch
- Installation Time at 90 psi Air Pressure: ≤ 1.2 seconds.

Practical Notes from an Experienced Technician

- Slight movement of the rivet before setting is normal and acceptable
- Minimum air pressure required: 85 psi
- A clear “click” indicates successful stem lock
- Stem tail should be flush with the sleeve surface ± 0.005 inch tolerance.

Note: This technical information is based on the official documentation provided by Cherry Aerospace and is intended solely for reference in product selection and specification.