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CherryMAX® Rivet CR3212-4-06

CR3212-4-06 is a high-strength 100° flush head rivet from the CherryMAX® series with a mechanically locked stem. It is designed for blind-side installation in critical aerospace structures and provides reliable fastening in material stack thicknesses up to 9.5 mm.

Basic Specifications

- Shank Diameter: 1/8 inch (≈0.125 inch)
- Grip Range: 0.313 – 0.375 inch
- Overall Length: 0.437 – 0.457 inch
- Head Diameter: ≈0.229 inch
- Head Height: ≈0.041 inch
- Head Style: 100° flush countersunk
- Sleeve — Aluminum alloy 5056, anodized or chromate coated
- Mandrel — Alloy steel 8740, cadmium plated
- Standards Compliance: NAS9302B, MS20600, MIL-SPEC (AS), BACR15FR4
- Manufacturer: Cherry Aerospace, USA.

Material Thickness Selection Guidelines

- Recommended for material stack thickness between 7.95 – 9.5 mm
- Use CR3212-4-05 or shorter variants for thinner stack-ups
- Use CR3212-4-07 or longer variants for thicker assemblies
- Compatible with tools: Cherry G27, G747, G704B, or equivalents.

Part Identification and Marking Structure

CR — CherryMAX series

32 — Rivet type

12 — 100° flush head configuration

4 — Nominal diameter 1/8 inch

06 — Length code for 0.313 – 0.375 inch grip range.

Key Features and Installation Characteristics

- Flush head for smooth surface installation
- Recommended hole diameter: 0.129 – 0.132 inch
- Audible “click” confirms full stem lock
- Mandrel remains retained inside, no protrusions
- Blind installation possible with no backside access.

Coating and Visual Identification Notes

- Sleeve: gold or silver appearance depending on coating
- Mandrel: cadmium-plated, silver-gray
- Typical markings: CR3212-4-06, AF3212-4-06, NAS9302B-4-06
- Always verify part numbers — do not rely on color alone.

Additional Technical Characteristics

- Shear Strength: up to 50,000 PSI
- Tensile Strength: up to 75,000 PSI
- Temperature Range: -65°F to +250°F (-54°C to +121°C)
- Minimum Countersink Depth: 0.030 inch
- Head Seat Radius: 0.090 – 0.110 inch
- Nominal Air Pressure: 90 psi
- Typical Installation Time: ≤ 1.5 seconds.

Practical Notes from Technician

- Minor play before installation is normal
- Hole diameter tolerance is critical
- Do not apply lubricants — may cause installation failure
- Reduce force when setting in composite structures
- Use only well-maintained tools and correct nosepieces
- Minimum operating pressure: 85 psi
- Click sound confirms proper stem lock
- Stem tail should be flush with sleeve ± 0.005 inch.

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.