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## CherryMAX® Rivet CR3212-4-07

CR3212-4-07 is a high-strength, 100° flush head blind rivet from the CherryMAX® series, featuring a mechanically locked stem for maximum strength and durability. It is designed for blind-side installation in aerospace structures with total material stack thicknesses up to 11 mm. This rivet delivers high performance and full compliance with industry standards.

### Basic Specifications

- Shank Diameter: 1/8 inch (≈0.125 inch)
- Grip Range: 0.376 – 0.437 inch
- Overall Length: 0.500 – 0.520 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 9.55 – 11.1 mm
- Use CR3212-4-06 or shorter variants for thinner stack-ups
- Use CR3212-4-08 or longer variants for thicker assemblies
- Compatible with installation 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

07 — Length code for 0.376 – 0.437 inch grip range.

## Key Features and Installation Characteristics

- Flush 100° head designed for countersunk installation
- Recommended hole diameter: 0.129 – 0.132 inch
- Mechanical stem lock with audible “click”
- Stem remains fully retained inside the rivet body
- No backside access required for installation.

## Coating and Visual Identification Notes

- Sleeve appearance: gold or silver, depending on coating
- Mandrel: cadmium-plated, silver-gray tone
- Typical markings: CR3212-4-07, AF3212-4-07, NAS9302B-4-07
- Visual color may vary — always confirm by part number.

## Additional Technical Characteristics

- Shear Strength: up to 50,000 PSI
- Tensile Strength: up to 75,000 PSI
- Operating 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
- Installation Air Pressure: 90 psi nominal
- Installation Time: ≤ 1.6 seconds.

## Practical Notes from Technician

- Slight rivet play before setting is normal and intentional
- Hole diameter must be within 0.129–0.132 inch
- Do not use lubricants — may interfere with stem locking
- Use lower setting force for composite materials
- Keep installation tools clean and well-maintained
- Minimum air pressure: 85 psi
- Audible “click” confirms proper stem engagement
- Stem tail must be flush with sleeve within  $\pm 0.005$  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.