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CherryMAX® Rivet CR3212-4-08

CR3212-4-08 is a high-strength, 100° flush head blind rivet from the CherryMAX® product line. It features a mechanically locked stem that provides consistent performance in aerospace-grade structures, especially where backside access is not available. It is designed for installation in material stack-ups up to 12.7 mm.

Basic Specifications

- Shank Diameter: 1/8 inch (≈0.125 inch)
- Grip Range: 0.438 – 0.500 inch
- Overall Length: 0.562 – 0.582 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 11.13 – 12.7 mm
- Use CR3212-4-07 or shorter variants for thinner stacks
- Use CR3212-4-09 or longer variants for thicker structures
- Compatible with Cherry G27, G747, G704B pneumatic tools or equivalent.

Part Identification and Marking Structure

CR — CherryMAX series

32 — Rivet type

12 — 100° flush head configuration

4 — Nominal diameter 1/8 inch

08 — Length code for 0.438 – 0.500 inch grip range.

Key Features and Installation Characteristics

- Flush 100° countersunk head suitable for pre-countersunk holes
- Recommended hole diameter: 0.129 – 0.132 inch
- Mechanically locked stem provides positive "click" feedback
- No exposed stem tail — mandrel retained within sleeve
- Blind installation requires access from only one side.

Coating and Visual Identification Notes

- Sleeve color may appear gold (chromate) or silver (clear anodized)
- Mandrel is cadmium-plated, typically silver-gray
- Typical markings: CR3212-4-08, AF3212-4-08, NAS9302B-4-08
- Always verify part number and documentation — not just color.

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
- Typical Installation Time: ≤ 1.7 seconds.

Practical Notes from Technician

- Minor movement before setting is acceptable
- Ensure hole diameter is within specification for proper performance
- Do not apply lubricant — may interfere with stem capture
- Use reduced setting force for composite or thin laminate materials
- Tools must be clean and in good condition, especially the nosepiece
- Minimum operating pressure: 85 psi
- Listen for an audible "click" to confirm complete stem lock
- Mandrel tail must be flush with the sleeve within ± 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.