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CherryMAX® Rivet CR3212-5-05

CR3212-5-05 is a 5/32" diameter blind rivet from the CherryMAX® series featuring a 100° flush countersunk head and a mechanically locked stem. It is designed for medium-to-long grip range structural applications in aerospace, providing secure, vibration-resistant fastening with blind-side access.

Basic Specifications

- Shank Diameter: 5/32 inch (≈0.156 inch)
- Grip Range: 0.251 – 0.312 inch
- Overall Length: 0.437 – 0.457 inch
- Head Diameter: ≈0.281 inch
- Head Height: ≈0.052 inch
- Head Style: 100° flush countersunk
- Sleeve — Aluminum alloy 5056, anodized or chromate conversion coated
- Mandrel — Alloy steel 8740, cadmium plated
- Standards Compliance: NAS9302B, MS20600, MIL-SPEC (AS), BACR15FR5
- Manufacturer: Cherry Aerospace, USA.

Material Thickness Selection Guidelines

- Recommended for material stack thickness between 6.4 – 7.9 mm
- Use CR3212-5-04 or shorter variants for thinner structures
- Use CR3212-5-06 or longer variants for thicker assemblies
- Compatible with Cherry G747, G27, G704B, or equivalent pneumatic riveters.

Part Identification and Marking Structure

- CR — CherryMAX series
- 32 — Rivet type
- 12 — 100° flush head configuration
- 5 — Nominal diameter 5/32 inch
- 05 — Length code for 0.251 – 0.312 inch grip range.

Key Features and Installation Characteristics

- 100° flush countersunk head for aerodynamic surface finish
- Recommended hole diameter: 0.161 – 0.164 inch
- Mechanically locked stem provides audible “click” during installation.
- Stem remains fully captured inside sleeve — no mandrel protrusion
- Blind installation possible with access from one side only.

Coating and Visual Identification Notes

- Sleeve finish: gold (chromate) or silver (anodized)
- Mandrel: cadmium-plated, silver-gray
- Typical part markings: CR3212-5-05, AF3212-5-05, NAS9302B-5-05
- Always verify parts by number, not color alone.

Additional Technical Characteristics

- Shear Strength: up to 58,000 PSI
- Tensile Strength: up to 85,000 PSI
- Operating Temperature Range: -65°F to +250°F (-54°C to +121°C)
- Minimum Countersink Depth: 0.040 inch
- Head Seat Radius: 0.110 – 0.130 inch
- Installation Air Pressure: 90 psi nominal
- Typical Installation Time: ≤ 1.5 seconds.

Practical Notes from Technician

- Minor play before installation is expected and acceptable
- Ensure hole diameter is tightly controlled (0.161–0.164 inch)
- Do not use lubricants — may interfere with mechanical lock
- Use reduced force when installing in composite materials
- Tools must be properly maintained and clean
- Minimum air pressure: 85 psi
- Audible “click” confirms complete stem locking
- Stem tail must 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.

