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CherryMAX® Rivet CR3212-6-02

CR3212-6-02 is a 3/16" diameter blind rivet from the CherryMAX® series, designed for short grip-range aerospace applications where one-sided access is required. Featuring a 100° flush countersunk head and a mechanically locked stem, this rivet ensures consistent, secure, and tamper-proof installation.

Basic Specifications

- Shank Diameter: 3/16 inch (≈0.187 inch)
- Grip Range: 0.063 – 0.125 inch
- Overall Length: 0.375 – 0.395 inch
- Head Diameter: ≈0.344 inch
- Head Height: ≈0.062 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), BACR15FR6
- Manufacturer: Cherry Aerospace, USA.

Material Thickness Selection Guidelines

- Recommended for material stack thickness between 1.6 – 3.2 mm
- Use CR3212-6-01 or shorter variants for minimal grip
- Use CR3212-6-03 or longer variants for medium grip
- Compatible with Cherry G747, G83, G84, G704B pneumatic installation tools or equivalent.

Part Identification and Marking Structure

- CR — CherryMAX series
- 32 — Rivet type
- 12 — 100° flush head configuration
- 6 — Nominal shank diameter 3/16 inch
- 02 — Length code for 0.063 – 0.125 inch grip range.

Key Features and Installation Characteristics

- Flush 100° countersunk head suitable for aerodynamic surface requirements
- Recommended hole diameter: 0.192 – 0.195 inch
- Mechanically locked stem with audible “click” confirms complete setting
- Stem remains fully captured — no exposed mandrel
- Blind-side installation capability — no backside access needed.

Coating and Visual Identification Notes

- Sleeve may be gold (chromate) or silver (anodized)
- Mandrel is cadmium plated, silver-gray finish
- Typical markings: CR3212-6-02, AF3212-6-02, NAS9302B-6-02
- Always verify using part number — not color alone.

Additional Technical Characteristics

- Shear Strength: up to 68,000 PSI
- Tensile Strength: up to 95,000 PSI
- Operating Temperature Range: -65°F to +250°F (-54°C to +121°C)
- Minimum Countersink Depth: 0.050 inch
- Head Seat Radius: 0.130 – 0.150 inch
- Installation Air Pressure: 90 psi nominal
- Typical Installation Time: ≤ 1.4 seconds.

Practical Notes from Technician

- Slight play before installation is normal
- Hole diameter must be within 0.192–0.195 inch
- Lubrication is not recommended — may hinder mechanical locking
- Use reduced setting force in composite or thin structures
- Installation tools must be clean and properly calibrated
- Minimum air pressure: 85 psi
- “Click” sound confirms proper stem engagement
- Stem tail must be flush with sleeve within ±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.