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CherryMAX® Rivet CR3213-4-02

CR3213-4-02 is a 1/8" diameter blind rivet from the CherryMAX® series, equipped with a universal (protruding) head and a mechanically locked stem. Designed for use in thin-sheet aerospace assemblies, it ensures a high-strength, fatigue- and vibration-resistant joint in applications where access is only available from one side.

Basic Specifications

- Shank Diameter: 1/8 inch (\approx 0.125 inch)
- Grip Range: 0.063 – 0.125 inch
- Overall Length: 0.280 – 0.305 inch
- Head Style: Universal (Protruding head)
- Head Diameter: \approx 0.219 inch
- Head Height: \approx 0.068 inch
- Sleeve Material: Aluminum alloy 5056
- Mandrel Material: Alloy steel 8740, cadmium plated
- Standards Compliance: NAS9301B, MS20470, MIL-SPEC (AS), BACR15FR4
- Manufacturer: Cherry Aerospace, USA.

Material Thickness Guidelines

- Recommended for material stack: 1.6 – 3.2 mm
- Use CR3213-4-01 for thinner applications
- Use CR3213-4-03 or longer variants for thicker assemblies.

Hole and Tooling

- Recommended Hole Diameter: 0.129 – 0.132 inch
- Compatible Tools: Cherry G27, G747, G704B or equivalent pneumatic installation tools
- Installation Air Pressure: 85 – 90 psi
- Typical Installation Time: \leq 1.4 seconds.

Key Features

- Universal dome head — classic protruding design
- Mechanically locking stem with audible/tactile “click”
- Blind-side installation for hard-to-reach areas
- Stem is retained inside — no exposed mandrel tail
- Designed for lightweight aerospace sheet materials.

Performance

- Shear Strength: up to 50,000 PSI
- Tensile Strength: up to 75,000 PSI
- Operating Temperature Range: -65°F to $+250^{\circ}\text{F}$ (-54°C to $+121^{\circ}\text{C}$).

Marking and Coating

- Sleeve Finish: anodized (silver) or chromate-coated (gold)
- Mandrel Finish: cadmium-plated (silver-gray)
- Typical Part Numbers: CR3213-4-02, AF3213-4-02, NAS9301B-4-02
- Always verify by part number — not visual appearance.

Installation Notes

- Slight pre-set play is normal
- Hole must be within 0.129–0.132 inch for proper locking
- Do not use lubricants — may impair mechanical retention
- Use reduced force for composite materials
- Click sound confirms full stem lock
- Stem must be flush with sleeve within ± 0.005 inch.

Advantages

- Reliable short-range blind rivet with universal head
- Suitable for use in standard, oversized, or slightly oval holes
- Compliant with aerospace standards: NAS, MS, MIL, BAC.

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.