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CherryMAX® Rivet CR3213-4-04

CR3213-4-04 is a 1/8" diameter blind rivet from the CherryMAX® series. It features a universal (protruding) head and a mechanically locked stem, making it suitable for structural aerospace assemblies where medium grip range and blind-side installation are required.

Basic Specifications

- Shank Diameter: 1/8 inch (≈0.125 inch)
- Grip Range: 0.188 – 0.250 inch
- Overall Length: 0.400 – 0.425 inch
- Head Style: Universal (Protruding head)
- Head Diameter: ≈0.219 inch
- Head Height: ≈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: 4.8 – 6.35 mm
- Use CR3213-4-03 or shorter for thinner stack-ups
- Use CR3213-4-05 or longer for thicker assemblies.

Hole and Tooling

- Recommended Hole Diameter: 0.129 – 0.132 inch
- Compatible Tools: Cherry G27, G747, G704B or equivalent pneumatic riveters
- Installation Air Pressure: 85 – 90 psi
- Typical Installation Time: ≤ 1.5 seconds.

Key Features

- Universal dome head provides robust external support
- Mechanically locking stem ensures vibration-resistant performance
- Mandrel is retained within the body — no tail protrusion
- Blind-side installation — suitable where rear access is not available
- Reliable in aluminum and mixed-metal assemblies.

Performance

- 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).

Marking and Coating

- Sleeve Finish: anodized (silver) or chromate (gold)
- Mandrel Finish: cadmium-plated, silver-gray
- Typical Markings: CR3213-4-04, AF3213-4-04, NAS9301B-4-04
- Always confirm by part number — do not rely on color alone.

Installation Notes

- Minor play before setting is normal
- Hole must be within 0.129–0.132 inch
- Avoid lubricants — may interfere with stem locking
- Use reduced force when working with composite structures
- Installation tools should be clean and calibrated
- Click sound confirms stem lock engagement
- Stem 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.