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CherryMAX® Rivet CR3213-4-06

CR3213-4-06 is a 1/8" diameter blind rivet from the CherryMAX® series. It features a universal (protruding) head and a mechanically locked stem, engineered for blind-side structural aerospace applications requiring extended grip range and high vibration resistance.

Basic Specifications

- Shank Diameter: 1/8 inch (≈0.125 inch)
- Grip Range: 0.313 – 0.375 inch
- Overall Length: 0.520 – 0.545 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: 7.95 – 9.5 mm
- Use CR3213-4-05 for thinner stack-ups
- Use CR3213-4-07 or longer for thicker assemblies.

Hole and Tooling

- Recommended Hole Diameter: 0.129 – 0.132 inch
- Compatible Tools: Cherry G27, G747, G704B or equivalent
- Installation Air Pressure: 85 – 90 psi
- Typical Installation Time: ≤ 1.6 seconds.

Key Features

- Universal dome head — ideal for legacy aircraft paneling and skin fastening
- Mechanically locked stem ensures high-strength, fatigue-resistant hold
- Mandrel fully retained — no protruding metal after installation
- Blind-side installation — requires access from only one side
- Performs consistently in aluminum, composite, and hybrid structures.

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 Part Numbers: CR3213-4-06, AF3213-4-06, NAS9301B-4-06
- Always verify part by number — color is not a reliable indicator.

Installation Notes

- Slight pre-set play is acceptable
- Hole size must be maintained at 0.129–0.132 inch
- Do not lubricate before setting — may impair locking function
- Use reduced setting force for composites and sandwich materials
- Tools must be properly calibrated and clean
- “Click” sound confirms mechanical stem lock
- 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.