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CherryMAX® Rivet CR3213-4-08

CR3213-4-08 is a 1/8" diameter blind rivet from the CherryMAX® series. It features a universal (protruding) head and a mechanically locked stem, making it ideal for aerospace assemblies requiring blind-side installation and a long grip range.

Basic Specifications

- Shank Diameter: 1/8 inch (\approx 0.125 inch)
- Grip Range: 0.438 – 0.500 inch
- Overall Length: 0.640 – 0.665 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: 11.13 – 12.7 mm
- Use CR3213-4-07 for thinner stack-ups
- Use CR3213-4-09 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: \leq 1.8 seconds.

Key Features

- Universal dome head — suitable for visible fastener surfaces
- Mechanically locked stem ensures high-strength, vibration-resistant fastening
- Stem is fully retained inside sleeve after installation
- Designed for blind-side assembly in structural aerospace applications
- Ideal for use with aluminum, titanium, or composite skins.

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 (gold)
- Mandrel Finish: cadmium-plated (silver-gray)
- Typical Part Numbers: CR3213-4-08, AF3213-4-08, NAS9301B-4-08
- Always verify part number — not finish color.

Installation Notes

- Slight play before installation is normal
- Hole diameter must be between 0.129–0.132 inch
- Lubricants should not be used — may interfere with lock
- Use reduced setting pressure for delicate or composite materials
- Stem tail should be flush within ± 0.005 inch of sleeve.

Advantages

- Long grip universal-head blind rivet for aerospace structures
- Flush, tamper-resistant finish with no stem protrusion
- Fully certified per NAS, MS, MIL, BAC aerospace standards
- Fast, secure, blind-side installation

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.