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CherryMAX® Rivet CR3213-5-04

CR3213-5-04 is a nominal-diameter, universal-head CherryMAX® structural blind rivet intended for aerospace assemblies that require one-side (blind) access. The CherryMAX® design incorporates a locking collar / mechanically retained stem system, and the installed rivet remains visually inspectable because the head markings and lock collar are visible after installation.

Basic Specifications

- Shank Diameter: 5/32 in (D = 0.157 in, +0.003/–0.001)
- Grip Range: 0.188 – 0.250 in (Grip Dash -04)
- Overall Length (L): 0.355 in (+0.000/–0.030)
- K (Max): 0.59 in
- Head Diameter (A): 0.312 in ± 0.010
- Head Height (B): 0.067 in (+0.010/–0.000)
- Head Style: Universal Head (protruding/button head)
- Hole Limits (Min/Max): 0.160 – 0.164 in
- Minimum Blind-Side Clearance (BK min): 0.370 in
- Procurement Specification: PS-CMR-3000
- Manufacturer: Cherry Aerospace, USA.

Material Thickness Selection Guidelines

- Select CR3213-5-04 when the total stack thickness is within 0.188–0.250 in.
- The grip dash number follows 1/16 in increments (the dash indicates the maximum grip in sixteenths).

Key Features and Installation Characteristics

- Visible inspection feature: head markings + locking collar are observable after set.
- Gold-colored driving anvil identifies nominal diameter rivets
- Satisfactory installation requires meeting the specified hole limits and BK minimum clearance.

Coating and Visual Identification Notes

- Sleeve: 5056 Aluminum (QQ-A-430).
- Stem: 8740 Steel (AMS6322).
- Lock Collar: A-286 CRES (AMS 5731 / AMS 5737).
- Typical standard finish set (— / ARN): sleeve chemical film per MIL-DTL-5541 (plain color), stem cadmium plate per AMS-QQ-P-416 Type II Class 2, lock collar passivated per AMS 2700.
- Always verify by full part number + finish code; color alone is not a reliable identifier.

Part Identification and Marking Structure

- CR3213 — CherryMAX® universal-head, nominal-diameter rivet family.
- -5 — diameter dash number (nominal diameter in 1/32 in increments; -5 = 5/32").
- -04 — grip dash number (grip system in 1/16 in increments).
- Head markings and lock collar remain visible after installation for inspection.

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.