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CherryMAX® Rivet CR3212-5-06

CR3212-5-06 is a high-performance blind rivet from the CherryMAX® series with a 5/32" diameter and a 100° flush countersunk head. It includes a mechanically locked stem and is designed for aerospace structures where access is limited to one side. This variant supports long grip range installations while maintaining full compliance with aerospace standards.

Basic Specifications

- Shank Diameter: 5/32 inch (≈0.156 inch)
- Grip Range: 0.313 – 0.375 inch
- Overall Length: 0.500 – 0.520 inch
- Head Diameter: ≈0.281 inch
- Head Height: ≈0.052 inch
- Head Style: 100° flush countersunk
- Sleeve — Aluminum alloy 5056, anodized or chromate conversion coated
- Mandrel — Alloy steel 8740, cadmium plated
- Standards Compliance: NAS9302B, MS20600, MIL-SPEC (AS), BACR15FR5
- Manufacturer: Cherry Aerospace, USA.

Material Thickness Selection Guidelines

- Recommended for material stack thickness between 7.95 – 9.5 mm
- Use CR3212-5-05 or shorter variants for thinner stack-ups
- Use CR3212-5-07 or longer variants for thicker joints
- Compatible with pneumatic tools: Cherry G747, G27, G704B, or equivalent.

Part Identification and Marking Structure**

- CR — CherryMAX series
- 32 — Rivet type
- 12 — 100° flush head configuration
- 5 — Nominal shank diameter 5/32 inch
- 06 — Length code for 0.313 – 0.375 inch grip range.

Key Features and Installation Characteristics

- Flush 100° head ensures clean aerodynamic finish
- Recommended hole diameter: 0.161 – 0.164 inch
- Mechanically locking stem provides tactile and audible "click"
- Mandrel is fully retained — no protrusions after installation
- Ideal for blind-side access during aircraft structure assembly.

Coating and Visual Identification Notes

- Sleeve finish may be gold (chromate) or silver (anodized)
- Mandrel is cadmium plated, silver-gray appearance
- Typical markings: CR3212-5-06, AF3212-5-06, NAS9302B-5-06
- Color is not a reliable identifier — confirm by part number.

Additional Technical Characteristics

- Shear Strength: up to 58,000 PSI
- Tensile Strength: up to 85,000 PSI
- Operating Temperature Range: -65°F to +250°F (-54°C to +121°C)
- Minimum Countersink Depth: 0.040 inch
- Head Seat Radius: 0.110 – 0.130 inch
- Installation Air Pressure: 90 psi nominal
- Typical Installation Time: ≤ 1.6 seconds.

Practical Notes from Technician

- Slight play prior to installation is acceptable and expected
- Ensure hole diameter is within the 0.161–0.164 inch range
- Do not use lubricants — may interfere with mechanical lock
- Use reduced force for composite or soft-material structures
- Clean and maintain tools regularly for consistent performance
- Minimum air pressure for installation: 85 psi
- Audible "click" confirms 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.