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CherryMAX® Rivet CR3212-6-10

CR3212-6-10 is a heavy-duty, 3/16" diameter blind rivet from the CherryMAX® series, engineered for structural aerospace applications. It features a 100° flush countersunk head and a mechanically locked stem, providing maximum reliability in long-grip installations where only one-sided access is available.

Basic Specifications

- Shank Diameter: 3/16 inch (≈0.187 inch)
- Grip Range: 0.564 – 0.625 inch
- Overall Length: 0.750 – 0.770 inch
- Head Diameter: ≈0.344 inch
- Head Height: ≈0.062 inch
- Head Style: 100° flush countersunk
- Sleeve — Aluminum alloy 5056, anodized or chromate coated
- Mandrel — Alloy steel 8740, cadmium plated
- Standards Compliance: NAS9302B, MS20600, MIL-SPEC (AS), BACR15FR6
- Manufacturer: Cherry Aerospace, USA.

Material Thickness Selection Guidelines

- Recommended for material stack thickness between 14.33 – 15.9 mm
- Use CR3212-6-09 or shorter variants for thinner joints
- Use CR3212-6-11 or longer variants for thicker stack-ups
- Compatible with pneumatic tools: Cherry G747, G83, G84, G704B, or equivalent.

Part Identification and Marking Structure

- CR — CherryMAX series
- 32 — Rivet type
- 12 — 100° flush head configuration
- 6 — Nominal shank diameter 3/16 inch
- 10 — Length code for 0.564 – 0.625 inch grip range.

Key Features and Installation Characteristics

- Flush 100° countersunk head provides aerodynamic finish
- Recommended hole diameter: 0.192 – 0.195 inch
- Mechanically locked stem provides visual and audible “click”
- Mandrel is retained inside sleeve — no protruding tail
- Ideal for blind installations in structural aerospace assemblies.

Coating and Visual Identification Notes

- Sleeve may appear gold (chromate) or silver (anodized)
- Mandrel is cadmium plated — silver-gray appearance
- Markings: CR3212-6-10, AF3212-6-10, NAS9302B-6-10
- Always verify by part number — color may vary by finish.

Additional Technical Characteristics

- Shear Strength: up to 68,000 PSI
- Tensile Strength: up to 95,000 PSI
- Operating Temperature Range: -65°F to +250°F (-54°C to +121°C)
- Minimum Countersink Depth: 0.050 inch
- Head Seat Radius: 0.130 – 0.150 inch
- Installation Air Pressure: 90 psi nominal
- Typical Installation Time: ≤ 2.0 seconds.

Practical Notes from Technician

- Minor pre-set play is acceptable before installation
- Hole diameter must be tightly controlled (0.192–0.195 inch)
- Do not lubricate — may affect stem retention
- Use lower force in composite applications
- Keep tooling clean and in calibrated condition
- Minimum air pressure: 85 psi
- Listen for audible “click” to confirm proper locking
- Stem tail should be flush within ± 0.005 inch of sleeve surface.

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.