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CherryMAX® Rivet CR3212-5-11

CR3212-5-11 is a high-strength, 5/32" diameter blind rivet from the CherryMAX® series with a 100° flush countersunk head and a mechanically locked stem. It is designed for structural aerospace joints requiring long grip range performance and blind-side installation.

Basic Specifications

- Shank Diameter: 5/32 inch (≈0.156 inch)
- Grip Range: 0.626 – 0.687 inch
- Overall Length: 0.750 – 0.770 inch
- Head Diameter: ≈0.281 inch
- Head Height: ≈0.052 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), BACR15FR5
- Manufacturer: Cherry Aerospace, USA.

Material Thickness Selection Guidelines

- Recommended for material stack thickness between 15.9 – 17.45 mm
- Use CR3212-5-10 or shorter variants for thinner structures
- Use CR3212-5-12 or longer variants for thicker applications
- Compatible with Cherry G747, G27, G704B, or equivalent pneumatic riveters.

Part Identification and Marking Structure

- CR — CherryMAX series
- 32 — Rivet type
- 12 — 100° flush head style
- 5 — Nominal diameter 5/32 inch
- 11 — Length code for 0.626 – 0.687 inch grip range.

Key Features and Installation Characteristics

- Flush 100° countersunk head for aerodynamic applications
- Recommended hole diameter: 0.161 – 0.164 inch
- Mechanical stem lock with clear audible “click” when properly set
- No exposed mandrel — stem is fully retained after installation
- Supports installation from only one accessible side.
- Sleeve may be gold (chromate conversion coating) or silver (anodized)
- Mandrel is cadmium plated with a silver-gray appearance
- Common markings: CR3212-5-11, AF3212-5-11, NAS9302B-5-11
- Part number must be confirmed from markings — not by visual appearance.

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: ≤ 2.0 seconds.

Practical Notes from Technician

- Minor play before setting is expected and acceptable
- Hole diameter should be strictly maintained at 0.161–0.164 inch
- Lubricants should not be used — may compromise performance
- Use reduced setting force in composite materials to avoid damage
- Tooling must be properly maintained and calibrated
- Minimum air pressure: 85 psi
- Click sound signals proper mechanical lock
- Stem tail must sit flush within ±0.005 inch tolerance.

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.