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CherryMAX® Rivet CR3212-5-10

CR3212-5-10 is a high-strength, 100° flush head blind rivet from the CherryMAX® series, designed for aerospace structures requiring a 5/32" diameter fastener with a long grip capability. It features a mechanically locked stem that ensures consistent, high-reliability blind installation even in thick material stack-ups, without requiring backside access.

Basic Specifications

- Shank Diameter: 5/32 inch (≈0.156 inch)
- Grip Range: 0.564 – 0.625 inch
- Overall Length: 0.687 – 0.710 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 14.33 – 15.9 mm
- Use CR3212-5-09 or shorter variants for thinner assemblies
- Use CR3212-5-11 or longer variants for thicker structures
- Compatible with pneumatic tools: Cherry G747, G704B, G27, or equivalent.

Part Identification and Marking Structure

- CR — CherryMAX series
- 32 — Rivet type
- 12 — 100° flush head configuration
- 5 — Nominal diameter 5/32 inch
- 10 — Length code for 0.564 – 0.625 inch grip range.

Key Features and Installation Characteristics

- Flush 100° countersunk head suitable for pre-countersunk holes
- Recommended hole diameter: 0.161 – 0.164 inch
- Mechanically locking stem with audible “click” when properly set
- Stem retained inside sleeve after installation — no protrusion
- Ideal for structural joints with access from one side only.

Coating and Visual Identification Notes

- Sleeve appearance may be gold (chromate) or silver (anodized)
- Mandrel is cadmium-plated (silver-gray finish)
- Typical markings: CR3212-5-10, AF3212-5-10, NAS9302B-5-10
- Always verify by part number — color is not sufficient.

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: ≤ 1.9 seconds.

Practical Notes from Technician

- Slight play before setting is acceptable
- Hole diameter must be tightly controlled (0.161–0.164 inch)
- Do not lubricate — may prevent proper stem engagement
- Use lower force for composite or thin-layered materials
- Tools must be clean and in good working order
- Minimum air pressure: 85 psi
- Audible “click” confirms full stem 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.