

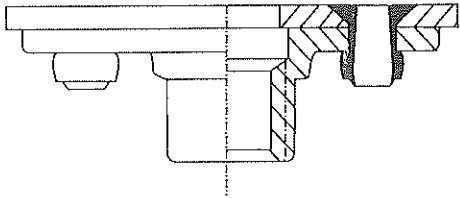
CHERRY® NUT PLATE RIVETS

FEATURES AND SPECIFICATIONS

- Low Cost
- Wide Grip Range
- Meets NASM25027
- Three Head Styles
- Single Action Tooling

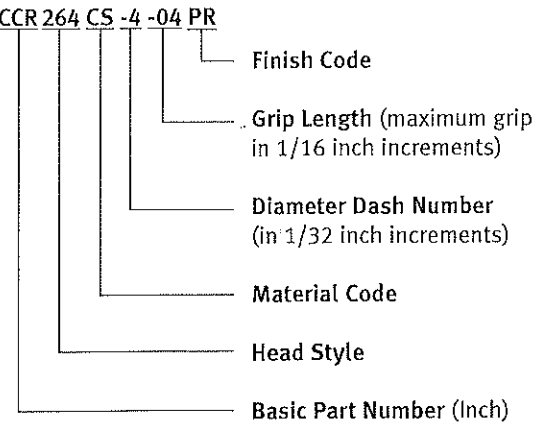


The Cherry Nut-Plate family of fasteners offers an extensive range of head styles in a low cost, pull through style rivet. Rivet heads include the CCR/CCMR274, "Universal", CCR/CCMR264, 100° Flush, and the CCR/CCMR244, 100° Reduced Flush head (NAS 1097). Sleeve materials include C1018 steel or A-286 CRES stainless steel. Single action installation tools are all that is required to complete this low cost fastening system. Recommended installation tools include the G29 hand tool, which is sold complete with pulling head, or the G902/G902-15 lightweight power tool with pulling heads sold separately.

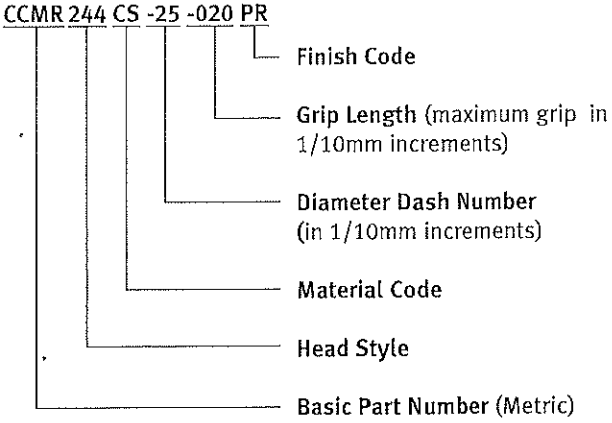


NUMBERING SYSTEM

Cherry Part Number Example (Inch):



Cherry Part Number Example (Metric):



CHERRY® NUT PLATE RIVETS

TECHNICAL DATA

FINISHES

FINISH CODE	SLEEVE	STEM
STAINLESS STEEL PRODUCTS	A-286 CRES PER AMS 5731	305 CRES PER ASTM A-493
NONE (NO SUFFIX)	SOLID FILM LUBE PER AS5272 PASSIVATE PER AMS 2700	PASSIVATE PER AMS 2700
IPR	CAD PLATE PER AMS QQ-P-416 TYPE II CL.2 GREEN PAR 90	PASSIVATE PER AMS 2700 PAR 90
P1	ALUMINUM COAT PER NAS 4006	PASSIVATE PER AMS 2700
PR	PASSIVATE PER AMS 2700 PAR 90 OR BARE	PASSIVATE PER AMS 2700 PAR 90 OR BARE
RK	RIVET KOTE® ICS201	PASSIVATE PER AMS 2700 PAR 90
T2	PASSIVATE PER AMS 2700 TIOLUBE 460	PASSIVATE PER AMS 2700 TIOLUBE 460
XL	PASSIVATE PER AMS 2700	PASSIVATE PER AMS 2700 LUBECO 905
ZN	NON LUBRICATED ZINC NICKEL PLATE PER BAC5637 TYPE II, CLASS 2 OR AMS2417 TYPE 2	PASSIVATE PER AMS 2700
STEEL PRODUCTS	C1018 STEEL PER ASTM A-510 ANNEALED	CARBON STEEL PER ASTM A-510
NONE (NO SUFFIX)	CAD PLATE PER AMS QQ-P-416 TYPE II CL.2	AS REQUIRED FOR CORROSION PROTECTION
P1	ALUMINUM COAT PER NAS4006	AS REQUIRED FOR CORROSION PROTECTION
C	CAD PLATE PER AMS QQ-P-416 TYPE II CL.2	CAD PLATE PER AMS QQ-P-416 , TYPE II CL.2
CPR	CAD PLATE PER AMS QQ-P-416 TYPE II CL.2 GREEN PAR 90	CAD PLATE PER AMS QQ-P-416 , TYPE II CL.2 PAR 90 OR BARE

TABLE 1

Strength requirements – CCR274 (Class 1), CCR264 (Class 2), CCR244 (Class 3)

Rivet Material	Head Class	Minimum Shear (lbs.)		Minimum Tensile (lbs.)		Minimum Torque Out (in-lbs.)		Minimum Push Out (lbs.)	
		-3	-4	-3	-4	-3	-4	-3	-4
SS (1018 Steel)	1 & 2	105	185	155	270	100	240	125	125
	3	105	185	100	225	100	240	125	125
CS (A-286)	1 & 2	105	185	155	270	100	240	125	125
	3	105	185	155	270	100	240	125	125

TABLE 2

Strength values – CCMR274 (Class 1),
CCMR264 (Class 2), CCMR244 (Class 3)

Nominal Diameter Size	Minimum Shear Strength (all classes)		Minimum Tensile Strength (all classes)	
	(Pounds)	(Newtons)	(Pounds)	(Newtons)
	-25	115	510	168
-30	166	735	242	1075
-35	225	1000	329	1460

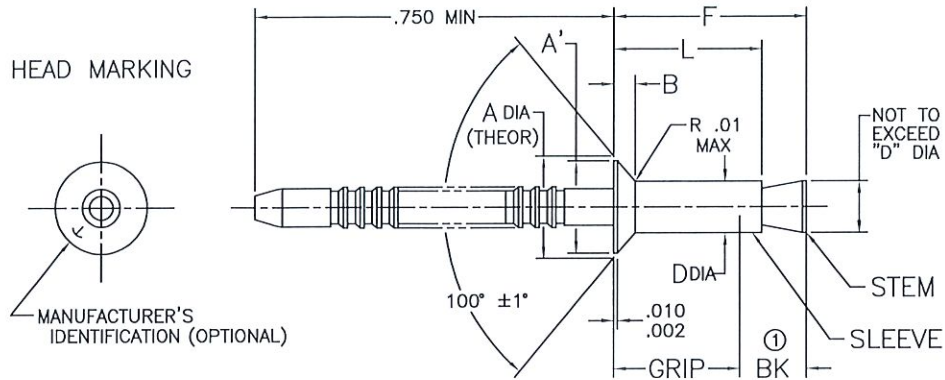
TABLE 3

Nut Plate Materials

Part Number	CS		SS	
	Sleeve	Stem	Sleeve	Stem
CCR274 CCR264 CCR244 CCMR274 CCMR264 CCMR244	A-286 PER AMS 5731	305 CRES PER ASTM A-493	C-1018 STEEL PER ASTM A-510	CARBON STEEL PER ASTM A-510

CHERRY® NUT PLATE RIVETS

CCR264/NASM20426 100° FLUSH HEAD



Diameter Dash No.	A Max	A' Actual Min	B Ref	D		BK ^①	Hole Size	
				Min	Max		Min	Max
-3	.179	.151	.036	.092	.097	.140	.097	.101
-4	.225	.197	.042	.123	.128	.170	.129	.132

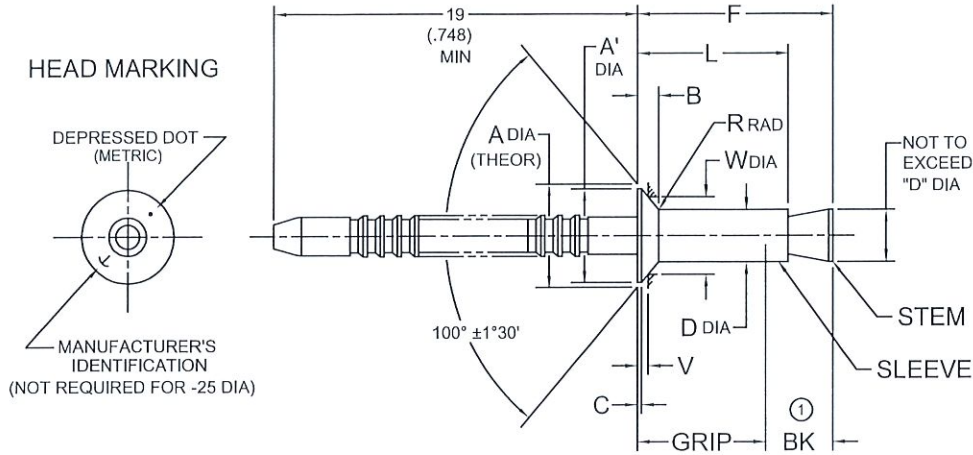
Grip Dash Number	Grip range		-3 Diameter				-4 Diameter			
			L Max	F Max	Installed Weight per 1000 pcs		L Max	F Max	Installed Weight per 1000 pcs	
	kgs	lbs			kgs	lbs				
-01	.046	.062	.140	.218	.068	.15	.170	.256	.231	.51
-02	.063	.125	.203	.281	.100	.22	.232	.318	.281	.62
-03	.126	.187	.265	.343	.132	.29	.295	.381	.331	.73
-04	.188	.250	.328	.405	.163	.36	.357	.443	.381	.84
-05	.251	.312	.390	.468	.195	.43	.420	.506	.431	.95
-06	.313	.375	.453	.530	.227	.50	.482	.568	.476	1.05
-07	.376	.437	.515	.592	.259	.57	.544	.630	.526	1.16
-08	.438	.500	.578	.655	.290	.64	.607	.693	.576	1.27
-09 ^②	.501	.562	.640	.718	—	—	.670	.755	—	—
-10 ^②	.563	.625	.703	.780	—	—	.732	.818	—	—
-11 ^②	.626	.687	.765	.843	—	—	.795	.899	—	—
-12 ^②	.688	.750	.828	.905	—	—	.857	.961	—	—

① "BK" is the minimum blind side clearance needed for satisfactory installation.

② Available on special order only.

METRIC NUT-PLATE RIVETS®

CCMR264/NASM20426 100° FLUSH HEAD



Diameter Dash No.	Nominal Diameter	A' Max	A' Actual Min	B Ref	BK ^①	C Min	D		R		V Protruding +0,00 (.000) -0,08 (.003)	W Gage	Hole Size
							Min	Max	Min	Max			
-25	2,5 (.098)	4,65 (.183)	4,15 (.163)	0,91 (.036)	4,2 (.165)	0,05 (.0020)	2,420 (.095)	2,480 (.098)	0,1 (.004)	0,3 (0.12)	0,32 (.013)	3,86 (.152)	2,560-2,500 mm (.101-.098")
-30	3,0 (.118)	5,55 (.219)	4,95 (.195)	1,07 (.042)	4,6 (.181)	0,06 (.0025)	2,920 (.115)	2,980 (.117)	0,2 (.008)	0,4 (0.16)	0,44 (.017)	4,50 (.177)	3,060-3,000 mm (.120-.118")
-35	3,5 (.138)	6,50 (.256)	5,80 (.228)	1,26 (.050)	4,9 (.193)	0,07 (.0028)	3,400 (.134)	3,470 (.137)	0,2 (.008)	0,4 (0.16)	0,56 (.022)	5,14 (.202)	3,575-3,500 mm (.141-.138")

Grip range 2 mm Range		Grip Dash Number	-25 (2.5 mm) Diameter			-30 (3.0 mm) Diameter			-35 (3.5 mm) Diameter		
Min	Max		L Max	F Max	Weight kgs per 1000 pcs	L Max	F Max	Weight kgs per 1000 pcs	L Max	F Max	Weight kgs per 1000 pcs
1,17 (.046)	2,00 (.079)	-020	3,76 (.148)	5,99 (.236)	0,114	4,19 (.165)	6,38 (.251)	0,187	4,52 (.178)	7,42 (.292)	0,293
2,01 (.079)	4,00 (.157)	-040	5,74 (.226)	7,95 (.313)	0,154	6,10 (.240)	8,33 (.328)	0,245	6,48 (.255)	9,37 (.369)	0,376
4,01 (.158)	6,00 (.236)	-060	7,72 (.304)	9,96 (.392)	0,194	8,13 (.320)	10,34 (.407)	0,302	8,48 (.344)	11,38 (.448)	0,458
6,01 (.237)	8,00 (.315)	-080	9,75 (.384)	11,99 (.472)	0,234	10,16 (.400)	12,37 (.487)	0,360	10,52 (.414)	13,41 (.528)	0,541
8,01 (.315)	10,00 (.394)	-100	11,79 (.464)	14,02 (.552)	0,273	12,19 (.480)	14,40 (.567)	0,418	12,55 (.494)	15,44 (.608)	0,624
10,01 (.394)	12,00 (.472)	-120	13,82 (.544)	16,05 (.632)	0,313	14,22 (.560)	16,43 (.647)	0,476	14,58 (.574)	17,48 (.688)	0,707
12,01 (.473)	14,00 (.551)	-140	15,85 (.624)	18,08 (.712)	0,353	16,26 (.640)	18,47 (.727)	0,533	16,61 (.654)	19,51 (.768)	0,789
14,01 (.552)	16,00 (.630)	-160	17,88 (.704)	20,12 (.792)	0,393	18,29 (.720)	20,50 (.807)	0,591	18,64 (.734)	21,54 (.848)	0,872
16,01 (.631)	18,00 (.709)	-180	19,91 (.784)	22,15 (.872)	0,433	20,32 (.800)	22,53 (.887)	0,649	20,68 (.814)	23,57 (.928)	0,955
18,01 (.710)	20,00 (.788)	-200	21,95 (.864)	24,18 (.952)	0,473	22,35 (.880)	24,56 (.967)	0,706	22,71 (.894)	25,60 (1.008)	1,037

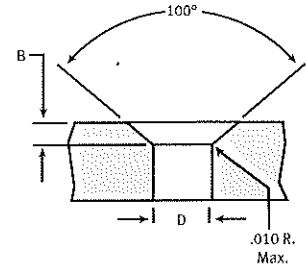
① "BK" is the minimum blind side clearance needed for satisfactory installation.

CHERRY® NUT PLATE RIVETS

HOLE PREPARATION AND TOOL SELECTION

HOLE PREPARATION

Rivet Type	B Dimension (Min in inches)					D Dimension (Min/Max in inches)				
	-3	-4	2.5mm	3.0mm	3.5mm	-3	-4	2.5mm	3.0mm	3.5mm
CCR244	.021	.028	—	—	—	.097/.101	.129/.132	—	—	—
CCR264	.036	.042	—	—	—	.097/.101	.129/.132	—	—	—
CCR274	—	—	—	—	—	.097/.101	.129/.132	—	—	—
CCMR244	—	—	.024	.029	.033	—	—	.098/.101	.118/.120	.138/.141
CCMR264	—	—	.036	.042	.050	—	—	.098/.101	.118/.120	.138/.141
CCMR274	—	—	—	—	—	—	—	.098/.101	.118/.120	.138/.141



TOOL SELECTION

Tools shown in the chart below will install the diameter rivets indicated by the shaded areas.

Tool	Pulling Head	-3(3/32"), 2.5mm	-4(1/8"), 3mm, 3.5mm
G29	INCLUDED		
G902	H902-3NPR		
	H902-4NPR		
G902-15	H9015-3C		
	H9015-4C		
G746A	H902-3NPR		
	H902-4NPR		
	H9015-3C ①		
	H9015-4C ①		
G702A	H702-3NPR ②		

① Uses 704A9 adapter, sold separately.

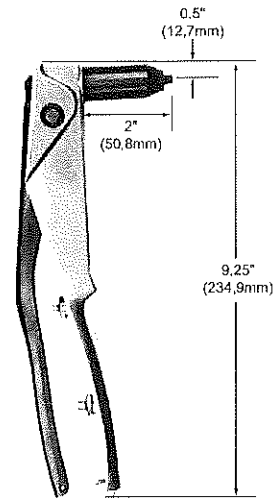
② Uses 728A9-104 & 728A9-3 nosepiece, included with pulling head.

CHERRY® NUT PLATE RIVETS

INSTALLATION TOOLING

G29 HAND RIVETER

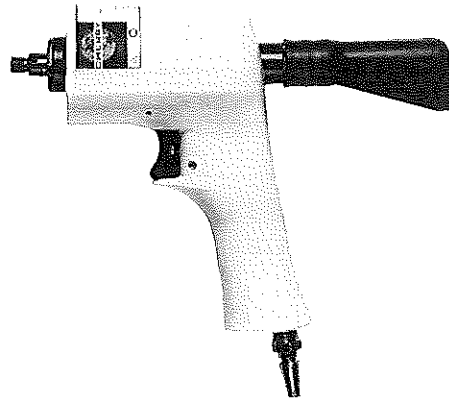
The Cherry G29 Hand Riveter is designed as an efficient, compact, lightweight tool for installing Cherry Nut-plate Rivets where access or power limitations prevent the use of power tools. It comes equipped with a 728A9-3 nosepiece for installing 3/32" rivets and a 728A9-104 nosepiece for installing 1/8" rivets. Overall length of the G29 is 9 1/4", and weighs just 13 oz. The pulling head is an integral part of the tool.



G902 POWER RIVETER

The Cherry G902 is a pneumatic tool designed specifically for the most efficient installation of Cherry Nut-plate Rivets. It weighs just over 2 lbs. and can be operated in any position with one hand. It has a 3/4" stroke and a rated pull load of 550 lbs. on 90psi and 730 lbs. on 120psi air pressure at the air inlet. Stems feed through this tool system.

Pulling heads are not furnished with this riveter and must be ordered separately.



G902-15 POWER RIVETER

The Cherry G902-15 is a pneumatic tool designed specifically for the most efficient installation of Cherry Nut-plate Rivets. It weighs just over 2 lbs. and can be operated in any position with one hand. It has a 3/4" stroke and a rated pull load of 550 lbs. on 90psi and 730 lbs. on 120psi air pressure at the air inlet. Stems are side ejected with this tool system.

Pulling heads are not furnished with this riveter and must be ordered separately.

