

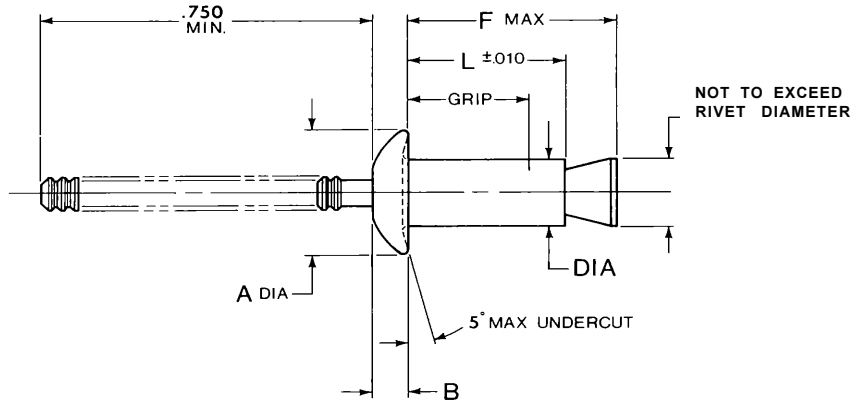
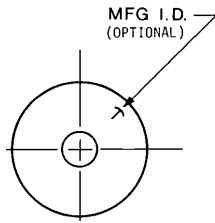
# NUT-PLATE RIVETS



**TEXTRON** Aerospace Fasteners

# NUT-PLATE RIVETS

## UNIVERSAL HEAD / CCR274SS & CS



DIA DASH NO.	DIA MIN./MAX.	A MIN./MAX.	B MIN./MAX.
-3	.092/.097	.178/.196	.040/.050
-4	.123/.128	.238/.262	.054/.064

	①		②	
CCR274SS	C-1018 STEEL per ASTM A-510	CARBON STEEL per ASTM A-510	CADIUM PLATE per QQ-P-416 TYPE II, Class 2	RUST PREVENTATIVE COATING
CCR274CS (MS20604R)	A-286 per AMS 5731	305 CRES per ASTM A-493	SOLID FILM LUBE per MIL-L-46010	PASSIVATE per QQ-P-35

All fasteners should be specified and used in accordance with manufacturer's recommendations, using the grip range and hole size information provided in the catalog.

NOMINAL RIVET DIAMETER	HOLE SIZE & DRILL	GRIP RANGE	L ±.010	F MAX	UNIVERSAL HEAD RIVET		INST. WT. #/M
					STEEL	CRES	
3/32" (-3)	.097 (#40)	.046-.062	.130	.218	CCR274SS-3-01	CCR274CS-3-01	.22
		.063-.125	.193	.281	CCR274SS-3-02	CCR274CS-3-02	.29
		.126-.187	.255	.343	CCR274SS-3-03	CCR274CS-3-03	.36
		.188-.250	.318	.405	CCR274SS-3-04	CCR274CS-3-04	.43
		.251-.312	.380	.468	CCR274SS-3-05	CCR274CS-3-05	.50
		.313-.375	.443	.530	CCR274SS-3-06	CCR274CS-3-06	.57
		.376-.437	.505	.592	CCR274SS-3-07	CCR274CS-3-07	.64
		.438-.500	.568	.655	CCR274SS-3-08	CCR274CS-3-08	.71
		.501-.562	.630	.718	CCR274SS-3-09	CCR274CS-3-09	.78
		.563-.625	.695	.780	CCR274SS-3-10	CCR274CS-3-10	.85
		.626-.687	.755	.843	CCR274SS-3-11	CCR274CS-3-11	.92
		.688-.750	.818	.905	CCR274SS-3-12	CCR274CS-3-12	.99

NOMINAL RIVET DIAMETER	HOLE SIZE & DRILL	GRIP RANGE	L ±.010	F MAX	UNIVERSAL HEAD RIVET		INST. WT. #/M
					STEEL	CRES	
1/8" (-4)	.129 (#30)	.046-.062	.160	.256	CCR274SS-4-01	CCR274CS-4-01	.86
		.063-.125	.222	.318	CCR274SS-4-02	CCR274CS-4-02	.97
		.126-.187	.285	.381	CCR274SS-4-03	CCR274CS-4-03	1.08
		.188-.250	.347	.443	CCR274SS-4-04	CCR274CS-4-04	1.19
		.251-.312	.410	.506	CCR274SS-4-05	CCR274CS-4-05	1.30
		.313-.375	.472	.568	CCR274SS-4-06	CCR274CS-4-06	1.41
		.376-.437	.534	.630	CCR274SS-4-07	CCR274CS-4-07	1.52
		.438-.500	.597	.711	CCR274SS-4-08	CCR274CS-4-08	1.63
		.501-.562	.660	.774	CCR274SS-4-09	CCR274CS-4-09	1.74
		.563-.625	.722	.836	CCR274SS-4-10	CCR274CS-4-10	1.85
		.626-.687	.785	.899	CCR274SS-4-11	CCR274CS-4-11	1.96
		.688-.750	.847	.961	CCR274SS-4-12	CCR274CS-4-12	2.07

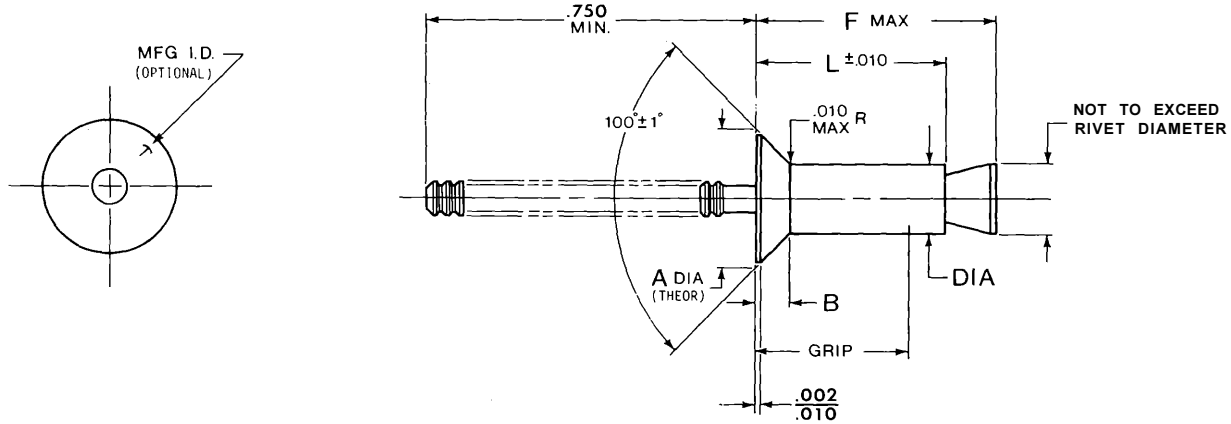
Grips in shaded areas are available on special order only.

① Material designation refers to chemical composition only.

② See Technical Data Section for Special Finish Codes.

# NUT-PLATE RIVETS

## NAS1097 100° FLUSH HEAD | CCR244SS & CS



DIA DASH NO.	DIA MIN./MAX.	A (MAX)	B (REF)
-3	.092/.097	.148	.021
-4	.123/.128	.196	.028

All fasteners should be specified and used in accordance with manufacturer's recommendations, using the grip range and hole size information provided in the catalog.

PART NUMBER	MATERIAL		FINISH	
	SLEEVE	STEM	SLEEVE	STEM
CCR244SS	C-1018 STEEL per ASTM A-545	STEEL	CADMIUM PLATE per QQ-P-416 TYPE II, Class 2	RUST PREVENTATIVE COATING
CCR244CS	A-286 per AMS 5731	305 CRES per ASTM A-493	SOLID FILM LUBE per MIL-L-46010	PASSIVATE per QQ-P-35

NOMINAL RIVET DIAMETER	HOLE SIZE & DRILL	GRIP RANGE	L ±.010	F MAX	COUNTERSUNK HEAD RIVET		INST. WT. #/M
					STEEL	CRES	
3/32" (-3)	.097 (#40)	.046-.062	.130	.250	CCR244SS-3-01	CCR244CS-3-01	.13
		.063-.125	.193	.313	CCR244SS-3-02	CCR244CS-3-02	.20
		.126-.187	.255	.375	CCR244SS-3-03	CCR244CS-3-03	.27
		.188-.250	.318	.437	CCR244SS-3-04	CCR244CS-3-04	.34
		.251-.312	.380	.500	CCR244SS-3-05	CCR244CS-3-05	.41
		.313-.375	.443	.562	CCR244SS-3-06	CCR244CS-3-06	.48
		.376-.437	.505	.625	CCR244SS-3-07	CCR244CS-3-07	.55
		.438-.500	.568	.688	CCR244SS-3-08	CCR244CS-3-08	.62

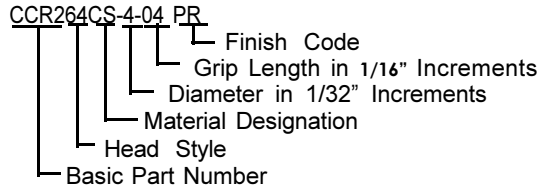
NOMINAL RIVET DIAMETER	HOLE SIZE & DRILL	GRIP RANGE	L ±.010	F MAX	COUNTERSUNK HEAD RIVET		INST. WT. #/M
					STEEL	CRES	
1/8" (-4)	.129 (#30)	.046-.062	.160	.343	CCR244SS-4-01	CCR244CS-4-01	.49
		.063-.125	.222	.406	CCR244SS-4-02	CCR244CS-4-02	.60
		.126-.187	.285	.468	CCR244SS-4-03	CCR244CS-4-03	.71
		.188-.250	.347	.531	CCR244SS-4-04	CCR244CS-4-04	.82
		.251-.312	.410	.593	CCR244SS-4-05	CCR244CS-4-05	.93
		.313-.375	.472	.656	CCR244SS-4-06	CCR244CS-4-06	1.04
		.376-.437	.535	.718	CCR244SS-4-07	CCR244CS-4-07	1.14
		.438-.500	.597	.781	CCR244SS-4-08	CCR244CS-4-08	1.25

① Material designation refers to chemical composition only.

② See Technical Data Section for Special Finish Codes.

# TECHNICAL DATA

## PART NUMBER EXAMPLE



## PHYSICAL PROPERTIES

Cherry Nut-plate Rivets are designed to meet or exceed the torque-out and push-out strength values as defined by Nut-plate Specification Mil-N-25027 shown.

PART NO.	SINGLE SHEAR (LBS.)		TENSILE (LBS.)	
	-3	-4	-3	-4
CCR244SS	105	185	100	225
CCR264SS	105	185	155	270
CCR274SS	105	185	155	270
CCR244CS	105	185	155	270
CCR264CS	105	185	155	270
CCR274CS	105	185	155	270

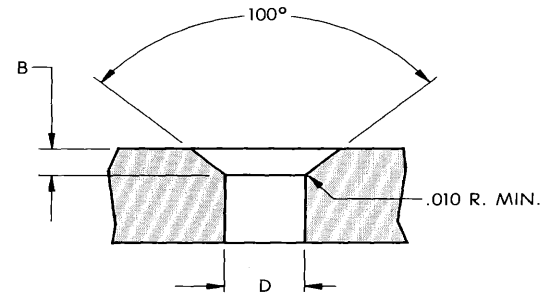
See Cherry Specification PS-NPR-200 for details

NUT-PLATE THREAD SIZE	TORQUE-OUT INCH/LBS.	PUSH-OUT LBS.
4	20	40
6	30	60
8	45	80
10	60	100
1/4	100	125
5/16	160	125
3/8	240	125

## HOLE PREPARATION

	B (Ctsk. Depth*)		D (Diameter)	
	-3 Min.	-4 Min.	-3 Min. Max.	-4 Min. Max.
CCR244	.021	.028	.097 - .101	.129 - .132
CCR264	.036	.042	( #40 Drill )	( #30 Drill )
CCR274	N/A	N/A		

\*Minimum depth required to insure flushness.



## INSTALLATION

1. Drill holes to sizes listed above. Countersink holes for flush rivets to dimensions listed.
2. Position nut plate and insert Cherry Nut-plate Rivets through holes.
3. Select desired installation tool.  
(See back page for recommended tools.)
4. Place tool on rivet and activate tool.  
Use 728A9-3 nosepiece for -3 (3/32") rivets and 728A9-104 nosepiece for -4 (1/8") rivets.

## FINISH CODES

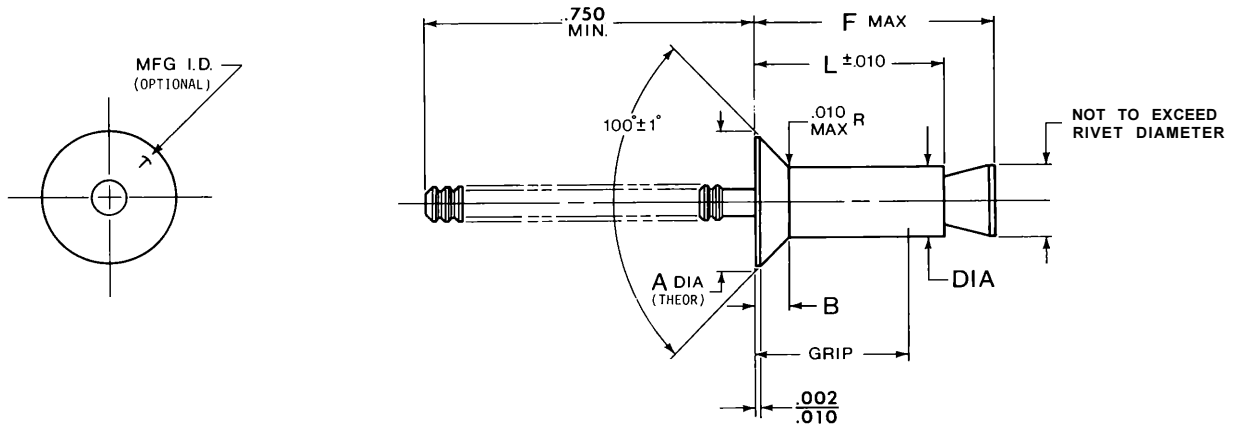
FINISH CODE	SLEEVE FINISH	STEM FINISH
PR ①	PASSIVATE per QQ-P-35 and PAR 90	PASSIVATE per QQ-P-35 and PAR 90
IPR ①	CADMIUM PLATE per QQ-P-416, TYPE II, CLASS 2 and PAR 90 with GREEN DYE	PASSIVATE per QQ-P-35 and PAR 90
T2	PASSIVATE per QQ-P-35 and TIOLUBE 460	PASSIVATE per QQ-P-35 and TIOLUBE 460
P1	ALUMINUM COAT per NAS4006	PASSIVATE per QQ-P-35
C ②	CADMIUM PLATE per QQ-P-416 TYPE II, CLASS 2	CADMIUM PLATE per QQ-P-416 TYPE II, CLASS 2

① Replaces Translube. Translube discontinued 1/1/92.

② C Code meets MS20604S and MS20605S for CCR264SS and CCR274SS types.

# NUT-PLATE RIVETS

## MS20426 100° FLUSH HEAD I CCR264SS & CS



DIA DASH NO.	DIA MIN./MAX.	A (MAX)	B (REF)
-3	.092/.097	.183	.036
-4	.123/.128	.229	.042

All fasteners should be specified and used in accordance with manufacturer's recommendations, using the grip range and hole size information provided in the catalog.

PART NUMBER	MATERIAL j		FINISH k	
	SLEEVE	STEM	SLEEVE	STEM
CCR274SS	C-1018 STEEL per ASTM A-510	CARBON STEEL per ASTM A-510	CADMIUM PLATE per QQ-P-416 TYPE II, Class 2	RUST PREVENTATIVE COATING
CCR274CS (MS20604R)	A-286 per AMS 5731	305 CRES per ASTM A-493	SOLID FILM LUBE per MIL-L-46010	PASSIVATE per QQ-P-35

NOMINAL RIVET DIAMETER	HOLE SIZE & DRILL	GRIP RANGE	L ±.010	F MAX	COUNTERSUNK HEAD RIVET		INST. WT. #/M
					STEEL	CRES	
3/32" (-3)	.097 .101 (#40)	.046-.062	.130	.218	CCR264SS-3-01	CCR264CS-3-01	.15
		.063-.125	.193	.281	CCR264SS-3-02	CCR264CS-3-02	.22
		.126-.187	.255	.343	CCR264SS-3-03	CCR264CS-3-03	.29
		.188-.250	.318	.405	CCR264SS-3-04	CCR264CS-3-04	.36
		.251-.312	.380	.468	CCR264SS-3-05	CCR264CS-3-05	.43
		.313-.375	.443	.530	CCR264SS-3-06	CCR264CS-3-06	.50
		.376-.437	.505	.592	CCR264SS-3-07	CCR264CS-3-07	.57
		.438-.500	.568	.655	CCR264SS-3-08	CCR264CS-3-08	.64
		.501-.562	.630	.718	CCR264SS-3-09	CCR264CS-3-09	.71
		.563-.625	.695	.780	CCR264SS-3-10	CCR264CS-3-10	.78
		.626-.687	.755	.843	CCR264SS-3-11	CCR264CS-3-11	.85
		.688-.750	.818	.905	CCR264SS-3-12	CCR264CS-3-12	.92

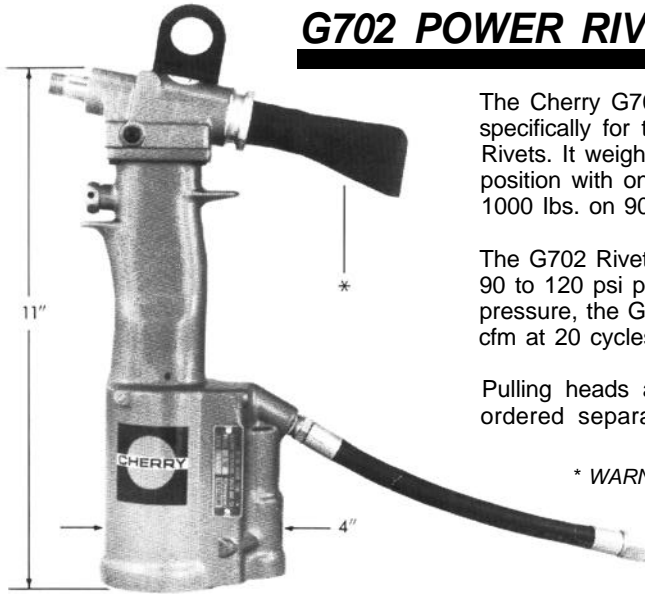
NOMINAL RIVET DIAMETER	HOLE SIZE & DRILL	GRIP RANGE	L ±.010	F MAX	COUNTERSUNK HEAD RIVET		INST. WT. #/M
					STEEL	CRES	
1/8" (-4)	.129 .132 (#30)	.046-.062	.160	.256	CCR264SS-4-01	CCR264CS-4-01	.51
		.063-.125	.222	.318	CCR264SS-4-02	CCR264CS-4-02	.62
		.126-.187	.285	.381	CCR264SS-4-03	CCR264CS-4-03	.73
		.188-.250	.347	.443	CCR264SS-4-04	CCR264CS-4-04	.84
		.251-.312	.410	.506	CCR264SS-4-05	CCR264CS-4-05	.95
		.313-.375	.472	.568	CCR264SS-4-06	CCR264CS-4-06	1.05
		.376-.437	.534	.630	CCR264SS-4-07	CCR264CS-4-07	1.16
		.438-.500	.597	.711	CCR264SS-4-08	CCR264CS-4-08	1.27
		.501-.562	.660	.774	CCR264SS-4-09	CCR264CS-4-09	1.38
		.563-.625	.722	.836	CCR264SS-4-10	CCR264CS-4-10	1.49
		.626-.687	.785	.899	CCR264SS-4-11	CCR264CS-4-11	1.60
		.688-.750	.847	.961	CCR264SS-4-12	CCR264CS-4-12	1.71

Grips in shaded areas are available on special order only.

- ① Material designation refers to chemical composition only.
- ② See Technical Data Section for Special Finish Codes.

# INSTALLATION TOOLS

## G702 POWER RIVETER



The Cherry G702 is a pneumatic/hydraulic tool designed specifically for the most efficient installation of Cherry Nut-plate Rivets. It weighs just over 3½ lbs. and can be operated in any position with one hand. It has a ¾" stroke and a rated pull load of 1000 lbs. on 90 psi air pressure at the air inlet.

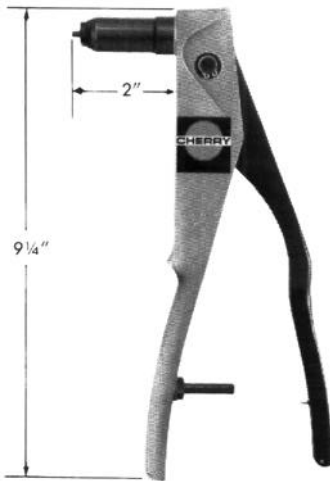
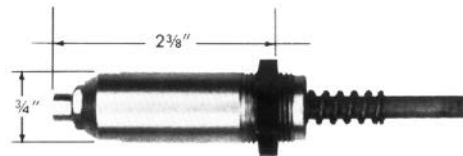
The G702 Riveter operates on a wide range of air pressure with 90 to 120 psi providing the maximum efficiency. At 90 lbs. air pressure, the G702 does not exceed 85dB(A) and consumes 2 cfm at 20 cycles per minute.

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

*\* WARNING: Operating these tools with a damaged or missing stem deflector, or using deflector as a handle may result in severe personal injury.*

## H702-3NPR PULLING HEAD

The H702-3NPR Pulling Head fits directly on the G702 Power Riveter. It comes equipped with a 728A9-3 nosepiece for installing 3/32" rivets and a 728A9-104 nosepiece for installing 1/8" rivets.



## 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 1/32" rivets and a 728A9-104 nosepiece for installing 1/8" rivets.

Overall length of the G29 is 9¼ , and weighs just 13 ozs. The pulling head is an integral part of the tool.

### NATIONAL STOCK NUMBER

5120001929966

### WARRANTY

Textron Aerospace Fasteners, a Division of Textron Inc. (hereinafter "TAF"), hereby warrants to the initial retail customer ("Warrantee") only that its products will be free from defects in material and workmanship, provided that the products are used in accordance with TAF's instruction as to maintenance, operation and use. The foregoing warranty is limited to products that are in the original container and the duration of the warranty is limited to 90 days from the date of first use by the Warrantee.

This Warrantee's only remedy and TAF's only obligation in the event of a defect or failure in the products, is that TAF will, at its sole option, repair, replace, or rework the products, but in no case shall the cost of the foregoing exceed the invoice price of the products.

This Warranty shall be void if any person seeking to make a claim for defective or failed products fails to notify TAF within thirty (30) days after receipt of evidence that the product is defective or has failed, or if said person fails to provide TAF with

such evidence as is reasonably requested concerning the defect or failure, including without limitation, evidence of the date of purchase and date of installation.

THIS WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. TAF EXPRESSLY DISCLAIMS LIABILITY FOR ALL INCIDENTAL, CONSEQUENTIAL, OR SPECIAL DAMAGES ARISING FROM ANY DEFECT OR FAILURE IN ITS PRODUCTS. TAF FURTHER DISCLAIMS ALL LIABILITY RESULTING FROM THE USER'S CHOICE OF ITS PRODUCTS FOR ANY PARTICULAR APPLICATION.

The properties, strengths, dimensions, installed characteristics and all other information in this catalog is for guidance only to aid in the correct selection of the products described herein and is not intended or implied as part of the above warranty. All applications should be evaluated by the user of the products for functional suitability and evaluations.

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**CHERRY**

**Avdel**