

**INSTALLATION TOOLS**

**NON-SHIFTING RIVETERS**



G704B

G746A

G747

G704B-40SH

G704B-SR

**NON-SHIFTING LOCKBOLT RIVETERS  
(Power Assisted Piston Return)**



G83A

G84

G84-LS

G87D

G85D-S

**SHIFTING (DOUBLE ACTION) CHERRYLOCK RIVETERS**



G686B-S

G689

G784

G700

**PULLING HEADS**



H701B-456  
STRAIGHT

H747-456  
UNIVERSAL  
STRAIGHT

H782  
OFFSET

H781A-456  
SINGLE JAW  
OFFSET

H753A-456  
RIGHT ANGLE

**CHERRY® AEROSPACE PRODUCTS**



## BLIND FASTENERS

For product catalogs, process manuals, procurement specifications and other details please check our website at <http://cherryaerospace.com/support/mastercatalog>

### BULBED CHERRYMAX® RIVETS



Bulbed CherryMAX® is a high stem retention lock spindle blind rivet with a visibly inspectable mechanical locking device. CherryMAX® blind rivet system retains the large blind head of the Bulbed CherryLOCK® rivet. Each rivet is supplied with its own installation anvil which eliminates the problems resulting from worn anvils. CherryMAX® fasteners are currently available in 1/8" through 1/4" diameter in both nominal and 1/64" oversize diameters. The tools utilize one pulling head to install many diameters, head configurations and material combinations.

### WIREDRAW CHERRYMAX® 'AB' RIVETS



CherryMAX® 'AB' rivets are shank expanding, locked-spindle, flush fracturing rivets meeting the requirements of NAS 1400 specification and conforming to NAS 1398/1399 'AB' code standard pages, but offering non-shift tooling installation without changing pulling heads.

### CHERRY MAXIBOLT® BLIND BOLTS



The Cherry MaxiBOLT® Blind Bolt alloy steel and A286 CRES conforms to NAS M90353/90354 and NAS M21140/21141, and meets the requirements of MIL-F-81177 and MIL-F-8975 and is listed in QPL81177 and QPL8975.

### BULBED CHERRYLOCK® RIVETS



The Bulbed CherryLOCK® is a high strength bulb rivet system with a visible, inspectable locking collar. Available in 1/8" through 3/16" diameters, several head styles and various material strengths and combinations. Conforms to NAS 1740 specification and NAS 1738/1739 standards pages.

### WIREDRAW CHERRYLOCK® RIVETS



Wiredraw holefilling CherryLOCK® rivets offer the widest range of sizes (3/32" through 1/4" diameters), materials and strength levels of any blind fastening system. Conforms to NAS 1400 specification and NAS 1398/1399 standards pages.

### CHERRY® NUT-PLATE RIVETS



Cherry® Nut-plate blind rivets are manufactured in 3/32" and 1/8" diameters, steel or CRES, for quickly and economically installing nut-plates to NAS M25027 requirements, with one operator. There are no blind side or limited accessibility problems, no damage or distortion to the surrounding material or nut baskets. They are available in pull-through or self-plugging styles and may be installed with hand or pneumatic tools.

### CHERRY® MS RIVETS



Cherry® MS self-plugging and pull-through rivets and tooling systems have been a reliable standard of the industry since their introduction. Although superseded by the locked-spindle specifications NAS 1400 and NAS 1740, Cherry® MS rivets are still widely used under MS20600/01/04/05 part numbers.

### CHERRY SST® BLIND RIVETS



The Cherry SST® Blind Rivet System was designed to solve many of the blind fastening problems associated with aircraft assemblies requiring superior sheet take-up. Installation of the SST Blind Rivet System ensures consistent and permanent fastening of difficult assemblies with inherent gapping or slightly misaligned holes. The SST Blind Rivet System can be installed with standard CherryMAX® tooling with no adjustments needed. Eliminate sheet gaps in your toughest assemblies. Nominal and oversize in -4, -5, and -6 diameters are available in three head styles, universal, 100° flush and 100° reduced flush (NAS 1097).

### SELF-PLUGGING RIVET (SPR®)



Cherry® 3/32" Self Plugging, locked spindle blind rivets are designed for the attachment of nut plates and other applications requiring the use of a 3/32" diameter, aluminum sleeve, self plugging rivet. They meet and exceed strength requirements of Mil-N-25027 for torque-out and push-out of nut plates.

### TACKING RIVET



The Cherry® CCR284 Tacking Rivet is designed to improve drill-out by using external splines on the rivet shank to prevent rotation. The Cherry® Blind Tacking Rivet System is available with a 5056 sleeve and a C-1018 steel stem. Sleeve finishes include clear, red or black anodize.

### CHOBERT®



The Chobert® speed fastening design provides customers with a rapid assembly system. Chobert® rivets are installed by the customer on a re-usable mandrel. The installation process is simple and efficient; successive rivets are installed in pre-drilled holes on each cycle of the installation tool's trigger.

### MBC®



The industry approved MBC® system is one of the industry's simplest and most versatile riveting systems available today. This lightweight high-strength riveting system features a flush breaking stem. The mechanically locked stem contributes substantially to the integrity and performance of the fastener.

### SP



The SP rivet provides the aerospace customer with a reliable and time-proven self-plugging blind fastener. The SP products are qualified to SBAC standards

### LOCKBOLT PINS AND COLLARS



The Cherry Lockbolt Pins and Collars are two piece structural fasteners available in a variety of materials and configurations. The pins are available as "pull" or "stump" types in 1/8" through 3/8 diameters (nominal and oversize). They are manufactured to applicable NAS standards from Aluminum, CRES or Steel with protruding and flush head styles. Our Collars conform to NAS1080 and are manufactured from Steel, CRES, Monel or Aluminum."

## SHEAR PIN FASTENERS

### CHERRYBUCK® 95 KSI ONE-PIECE SHEAR PINS



The CherryBUCK® shear pin is a bi-metal, one piece fastener which combines a 95ksi shear 6Al-4V titanium shank with a ductile Ti/Cb tail to provide weight savings over two-piece, pin and collar, shear pin fasteners and reduce installation costs through one-piece automated riveting equipment.

### CHERRY E-Z BUCK® SHEAR PINS



Cherry E-Z BUCK® is a 50 ksi ductile Ti/Cb alloy solid rivet. Its ductility eliminates the sheet distortion found when using monel rivets. The Ti/Cb alloy provides weight savings of 33% over monel and 26% over A-286 CRES rivets. Cherry E-Z BUCK® titanium alloy rivets are complementary to CherryBUCK® bimetallic titanium rivets.

## FASTENERS FOR COMPOSITE

### CHERRY® 1900



The Cherry 1900 is manufactured to meet NAS1919 and NAS1921 and is available in all sizes and materials. This fastener has become a fastener of choice in many aircraft designs because of the increased use of composites. Our "Shift Washer" design extends the tool life and utilizes the Cherry "one tool concept" making the logistics of installing different sizes and types of fasteners much simpler.

### TITANIUM MAXIBOLT®



Titanium MaxiBOLT® Blind Bolts feature expanded performance capabilities for metallic and composite blind fastening applications. They provide a flush, burr-free installation with no shaving required. The Titanium MaxiBOLT® offers fast and consistent installation by utilizing single action tooling with a patented shift washer design. The all titanium sleeve and stem are compatible with exotic composite materials, they cause no delamination of the exit side of the structure during installation and offer a blindside slope tolerance up to 7°.

### TUFTHANE COATED BLIND RIVETS



Tufthane coated Cherry® rivets are designed for use in composites. The Tufthane coating is applied directly to aluminum or other sleeve material fasteners to provide a barrier against corrosion attack.

### CHERRY HOLLOW END E-Z BUCK®



The Cherry HOLLOW END E-Z BUCK® is a double flush, cavity type rivet of Ti/Cb material uniquely designed for use in a "soft" upset that prevents damage to the composite material.

## INSTALLATION TOOLS

For over 70 years, the Cherry installation tools have been used by aircraft manufacturers and repair facilities throughout the world. Ergonomics, reliability and robustness backed by the Cherry Warranty and Technical Assistance are the leading characteristics of our tools. There are four types of riveters also available in a "split" version, in which a light hand held unit is connected by hoses to a remote power unit.

- Non-shifting riveters: only the active piston stroke provides power
- Lockbolt Riveters: both the active and the return piston stroke provide power
- Shifting (Double Action) Riveters: these Cherrylock™ riveters have two pistons working together to complete the fastener installation.
- Hand Powered Riveters: Operated by hand power, our G800 weighs less than 2 Lbs. and provides up to 5000 Lbs. of pull force.

We also offer a wide variety of straight, offset and right angle pulling heads, adaptors, tool and service kits. For assistance please contact us at 714-545-5511; we would be happy to help.

### HAND RIVETERS

#### G30



#### G800



#### G800 CMR KIT



(continued on back cover)