



Aerospace  
Fastening  
Systems

Cherry Division  
of Textron Inc.



**CHERRY AEROSPACE PRODUCTS**



# BLIND FASTENERS

## 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 tooling provides the simplest, most trouble-free installation tooling system. CherryMAX

fasteners are currently available in 1/8" through 1/4" diameters in both nominal (NAS1400 sizes) and 1/64" oversize diameters (NAS1740 sizes). The rivets conform to MIL-R-007885 specifications and applicable slash sheets and the riveting tools conform to MIL-R-85188, utilizing one pulling head to install many diameters and head configurations and material combinations. Use with G704 CherryMAX installation tools.



## Wiredraw CherryMAX® 'A' Rivets

CherryMAX® 'A' rivets are shank expansion, locked-spindle, flush fracturing rivets exceeding the requirements of NAS1400 specifications

and conforming to NAS1398A/1399A code standard pages, but offering non-shift tooling installation without changing pulling head or tool adjustment. Use with CherryMAX tooling.



## Cherry® Blind Bolt

The Cherry Blind Bolt alloy steel and A-286CRES conforms to MS90353/90354, and MS21140/MS21141, and exceeds the requirements of MIL-F-81177 and MIL-F-8975C and is listed in QPL851177

and QPL8985. The superior performance of the Cherry Blind Bolt can be directly attributed to the use of laser selective annealing of the blind head, thereby providing flusher stem protrusion and consistently higher joint pre-load. Use with Cherry tools.



## Bulbed Cherrylock® Rivets

The Bulbed Cherrylock is a high strength blind rivet system particularly suitable for high vibration areas and dimpled applications, with the strength of a solid rivet. Available in 1/8" through 3/16"

diameters, several head styles and various material strengths and combinations. Conforms to NAS1740 specification and NAS1738/1739 standards pages. Use with G-700 and G-784 Cherrylock hydroshift tools.



## 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 NAS1400 specification and NAS1398/1399 standards pages. Use with G-700 and G-784 hydroshift tools.



## Cherry® MS Rivets

Cherry MS self plugging pull through rivets and tooling systems have been a reliable standard of the industry since their introduction in 1937. Although superseded

in 1960 by the new locked-spindle specifications NAS1400 and 1740, Cherry MS rivets are still widely used under MS20600/01/04/05 part numbers. Use G-715 and G-700 installation tools.



## 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 MIL-N-25027 requirements, with one operator. There are no blind side or limited accessibility problems, no damage or

distortion to the surrounding material and no banged-up anchor nut baskets from misplaced bucking bars when attached with Cherry Nut-plate rivets. They are available in pull-through or self-plugging styles and may be installed with hand or pneumatic tools. Use G-702 power or G-29 hand tools or hydroshift tools.





## CherryBUCK® 95 KSI One-Piece Shearpin Pat. No. 4,688,317

The CherryBUCK® shear pin is a bi-metal, one piece fastener which combines a 95ksi shear 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. Now available for two-step Hi-Fatigue auto riveting installations to eliminate the problems of two-piece shear pins. The Cherry E-Z BUCK® is a 50ksi ductile Ti/Cb titanium alloy solid rivet. The ductility of Ti/Cb eliminates the sheet distortion with solid monel rivets.



## Cherry® Lockbolts

Cherry Lockbolts are available in pull or stump type; 1/8" through 3/8" diameters, nominal and oversize; in aluminum, steel and CRES materials and in countersunk or protruding head styles. The simplicity, consistency and speed of lockbolt

installation provides increased production rates, better fastened joints and lower installed costs. Grooved pins are available for sealant applications all meeting NAS standard pages. Use Cherry G85 and G87 lockbolt tools.



## C-LOK™

The C-LOK hex drive shear pin can be installed by hand in tight areas or by using automatic equipment. The mating part can be a torque controlled collar or a nut

using a torque controlled tool. It is featured in 6AL-4V titanium material and has 95 ksi shear strength. Other materials are available upon request.



## FASTENERS FOR COMPOSITES

### 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.



### CherryBUCK® With Washer

The CherryBUCK® 95ksi one-piece shearpin can be successfully installed against composites by upsetting the

ductile tail against a titanium or CRES washer.



### 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

composite structure assembly. It features a "soft" upset that prevents damage to the composite material.



## SELF-LOCKING NUTS

Cherry Self-locking Nuts are produced in two basic configurations: Wrenchable Nuts and Anchor Nuts (or Nut-plates). The wrenchable nuts are offered in 12 pt or hex; in alloy steel or CRES and in thread sizes from 2-56 (.086-56) through 3/8-24 (.3750-24).

Cherry Anchor Nuts are offered in a variety of floating and non-floating styles; in alloy steel or CRES and in thread sizes from 4-40 (.1120-40) through 3/8-24 (.3750-24). The Cherry Standoff Bracket nut is available in three stand off dimensions.





# INSTALLATION TOOLS

Cherry Installation Tools are manufactured to provide maximum service with minimum care. They are offered in a wide variety of hand, pneumatic and pneumatic/hydraulic versions, with optional accessories to permit their use in difficult and limited access areas. The size and type of fastener being installed dictates the type of tool to be used. See individual Cherry catalogs for details.



G-704



G-744



G-740



G-689



G-749



G-846



G-702



G-784



G-85

**CHERRY  
TEXTRON**

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