

CHERRY® 1900 BULBING BLIND RIVET



CHERRY®
AEROSPACE
SPS Fastener Division, a PCC Company

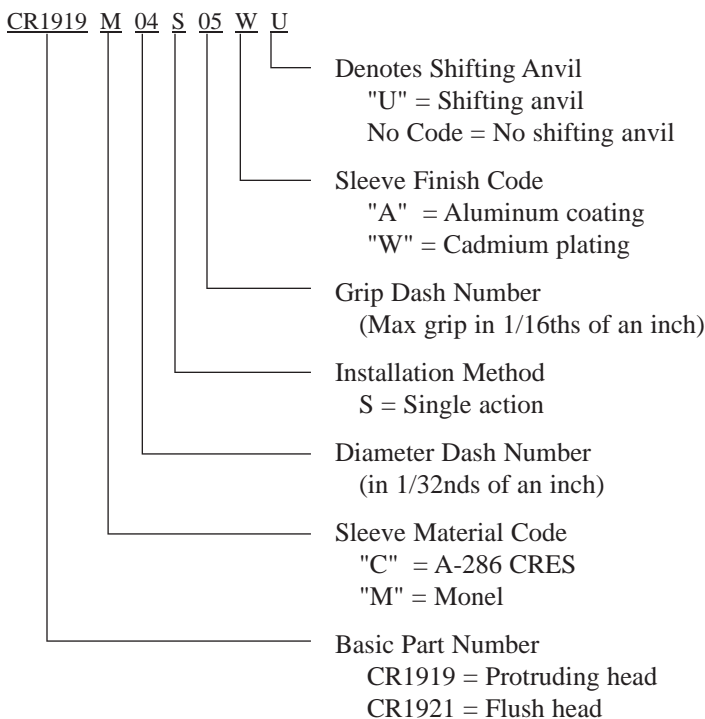
CHERRY® 1900 Bulbing Blind Rivet

FEATURES AND BENEFITS

- Manufactured to NAS1919 and NAS1921 industry standards.
- Meets or exceeds NAS1900 procurement specification.
- Available in Monel and A-286 stainless steel.
- Large blind side footprint is suitable for composite structures.
- Uses existing single action tooling and Cherry "One Tool Concept"
- Available with Cherry shift washer for consistent fastener installations and extended tool life.
- Flush break eliminates need for shaving.
- Visible/Inspectable mechanical lock.



CHERRY PART NUMBER EXAMPLE:



INSTALLATION TOOLING

Fastener Diameter	Installation Tool	Pulling Head†
-04, -05	G704B	H747-456
-04, -05, -06	G83/G84	H1900-456

† Additional tip needed for non-washer version.

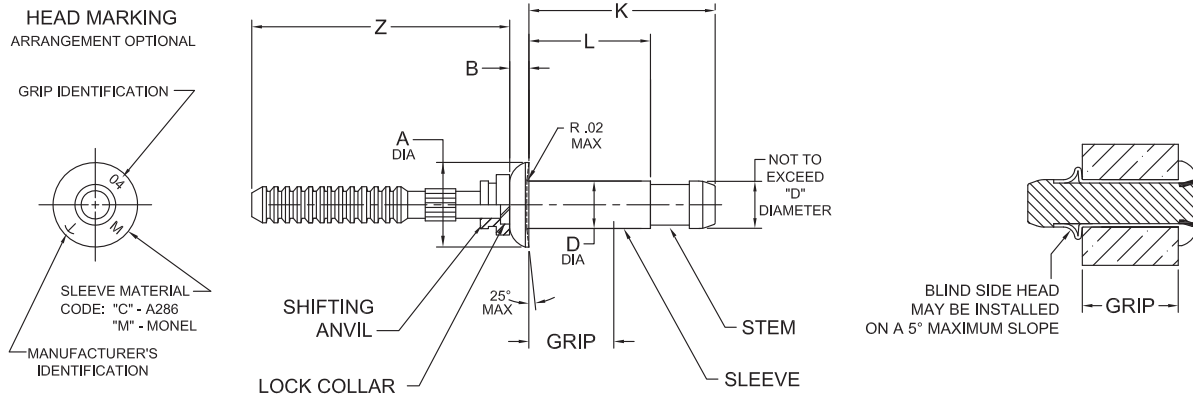


H1900-456
Straight Pulling Head



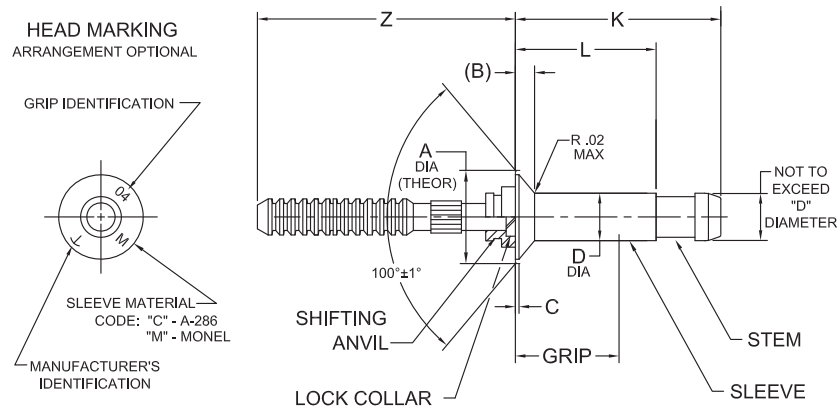
G704B

CHERRY® 1919/1921



CR1919 PROTRUDING HEAD

Diameter Dash No.	A	B +.010 -.000	D +.0035 -.0010	Z Min	Recommended Hole Limits	Minimum Installed Strength			
						A-286 Sleeve		Monel Sleeve	
						Single Shear	Tensile	Single Shear	Tensile
-04	.250±.012	.054	.1250	.788	.129/.132	1090	675	1020	675
-05	.312±.016	.067	.1560	.788	.160/.164	1670	1050	1565	1050
-06	.375±.019	.080	.1870	.788	.192/.196	2400	1500	2260	1500



CR1921 100° FLUSH HEAD

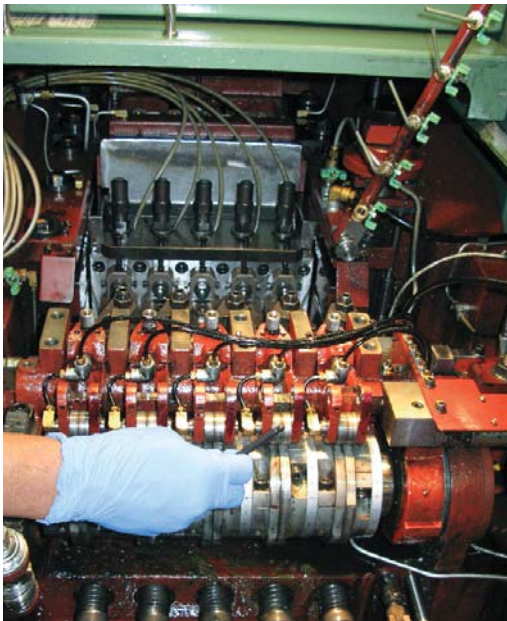
Diameter Dash No.	A ±.004	B Ref	C	D +.0035 -.0010	Z Min	Recommended Hole Limits	Minimum Installed Strength			
							A-286 Sleeve		Monel Sleeve	
							Single Shear	Tensile	Single Shear	Tensile
-04	.225	.042	.002	.1250	.788	.129/.132	1090	675	1020	675
-05	.286	.055	.015	.1560	.788	.160/.164	1670	1050	1565	1050
-06	.353	.070	.015	.1870	.788	.192/.196	2400	1500	2260	1500

CR1919/CR1921 MATERIAL & FINISH

Basic Part Number	Material			Finish		
	Sleeve	Stem	Lock Collar	Sleeve	Stem	Lock Collar
CR1919C (NAS1919C)	A-286 CRES per AMS 5737	A-286 CRES per AMS 5737	A-286 CRES per AMS 5737	No Code: Passivate per AMS 2700 "A": Aluminum Coat per NAS 4006 "W": Cad. Plate per QQ-P-416, Type II, CL.3	Passivate per AMS 2700	Passivate per AMS 2700
CR1921C (NAS1921C)						
CR1919M (NAS1919M)	Monel per QQ-N-281	A-286 CRES per AMS 5737	A-286 CRES per AMS 5737 or Monel per QQ-N-281 or 316 CRES per AMS 5690	No Code: None "A": Aluminum Coat per NAS 4006 "W": Cad. Plate per QQ-P-416, Type II, CL.3	Passivate per AMS 2700	Passivate per AMS 2700 for CRES or None for Monel
CR1921M (NAS1921M)						

Notes:

- .001 Shank diameter increase permissible within .100 from base of head as shown.
- "D" diameter may be .001 smaller beyond minimum grip as shown.
- "D" diameter may be .001 larger than shown for cadmium-plated or aluminum-coated sleeves.
- Lubricants may be applied to any or all components if required for performance unless prohibited by the governing specification.
- Rivets for use with single-action (non-shifting) tooling shall be identified with a depressed "S" on spindle head or color-coded yellow on spindle, location optional.
- Head angle for rivets with an "S" in part number may be 108° maximum and are for installation in countersinks of 100° ± 1.0°.



Cherry's state-of-the-art manufacturing facility built for the fabrication of Cherry 1900 rivets.



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