

SLOVENSKI STANDARD

SIST EN 2552:2001

01-januar-2001

Aerospace series - Rivets, solid, 100° normal countersunk head with dome, in aluminium alloy 2117, anodized or chromated, inch based series

Aerospace series - Rivets, solid, 100° normal countersunk head with dome, in aluminium alloy 2117, anodized or chromated, inch based series

Luft- und Raumfahrt - Vollniete, mit 100° normalem Senkkopf mit Dom, aus Aluminiumlegierung 2117, anodisiert oder chromatiert, Inch-Reihe

Série aérospatiale - Rivets ordinaires, a tête fraisée 100° normale avec dôme, en alliage d'aluminium 2117, anodisés ou chromatés, série base inches

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Ta slovenski standard je istoveten z: EN 2552:1992

ICS:

49.025.20	Aluminij	Aluminium
49.030.60	Kovice	Rivets

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en

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EUROPEAN STANDARD

EN 2552:1992

NORME EUROPÉENNE

EUROPÄISCHE NORM

November 1992

UDC 629.7:621.884.091.6-034.71

Descriptors: Aircraft industry, full rivet, countersunk head rivet, aluminium alloy, anodized metal, dimension, designation, marking

English version

**Aerospace series - Rivets, solid, 100° normal
countersunk head with dome, in aluminium alloy
2117, anodized or chromated, inch based series**

Série aéronautique - Rivets ordinaires, à tête
fraisée 100° normale avec dôme, en alliage
d'aluminium 2117, anodisés ou chromatisés, série
base inches

Luft- und Raumfahrt - Vollniete, mit 100°
normalem Senkkopf mit Dom, aus
Aluminiumlegierung 2117, anodisiert oder
chromatisiert, Inch-Reihe

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This European Standard was approved by CEN on 1992-11-16. CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration.

Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

The European Standards exist in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

CEN

European Committee for Standardization
Comité Européen de Normalisation
Europäisches Komitee für Normung

Central Secretariat: rue de Stassart, 36 B-1050 Brussels

Foreword

This European Standard has been prepared by the European Association of Aerospace Manufacturers (AECMA).

After inquiries and votes carried out in accordance with the rules of this Association, this Standard has successively received the approval of the National Associations and the Official Services of the member countries of AECMA, prior to its presentation to CEN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by May 1993, and conflicting national standards shall be withdrawn at the latest by May 1993.

According to the CEN/CENELEC Internal Regulations, the following countries are bound to implement this European Standard :

Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

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ALINEVO IS PARTICULAR
THOSE IN TECHNICAL SPECIFICATIONS
of technical specifications of EN 2552
ANALISU

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SYMBOLIC NOTION OF TRAVEL

1 Scope

This standard specifies the characteristics of solid rivets, with 100° normal countersunk head, inch based series, in aluminium alloy, anodized or chromated, for maximum operating temperature 120 °C.

2 Normative references

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies.

- EN 2000, Aerospace series - Quality assurance - EN aerospace products - Approval of the quality system of manufacturers
- EN 2101, Aerospace series - Chromic acid anodizing of aluminium and wrought aluminium alloys
- EN 2284, Aerospace series - Sulphuric acid anodizing of aluminium and wrought aluminium alloys
- EN 2345, Aluminium and aluminium alloy rivets - Technical specification - Aerospace series ¹⁾
- EN 2424, Aerospace series - Identification marking of standard fasteners ¹⁾
- EN 2437, Aerospace series - Chromatic conversion coatings (yellow) for aluminium and aluminium alloys ²⁾
- FED QQ-A-430, Federal specification - Identification alloy rod and wire - For rivets and cold heading ³⁾

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3 Required characteristics

3.1 Configuration - Dimensions - Masses

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See figure 1 and tables 2 and 3. Dimensions and tolerances are expressed in millimetres. They apply after surface treatment.

3.2 Material

Aluminium alloy 2117-H13 according to QQ-A-430 ($1,6 \text{ mm} \leq D \leq 10 \text{ mm}$).

The rivet shall be delivered in T4 condition.

3.3 Surface treatment

See table 1.

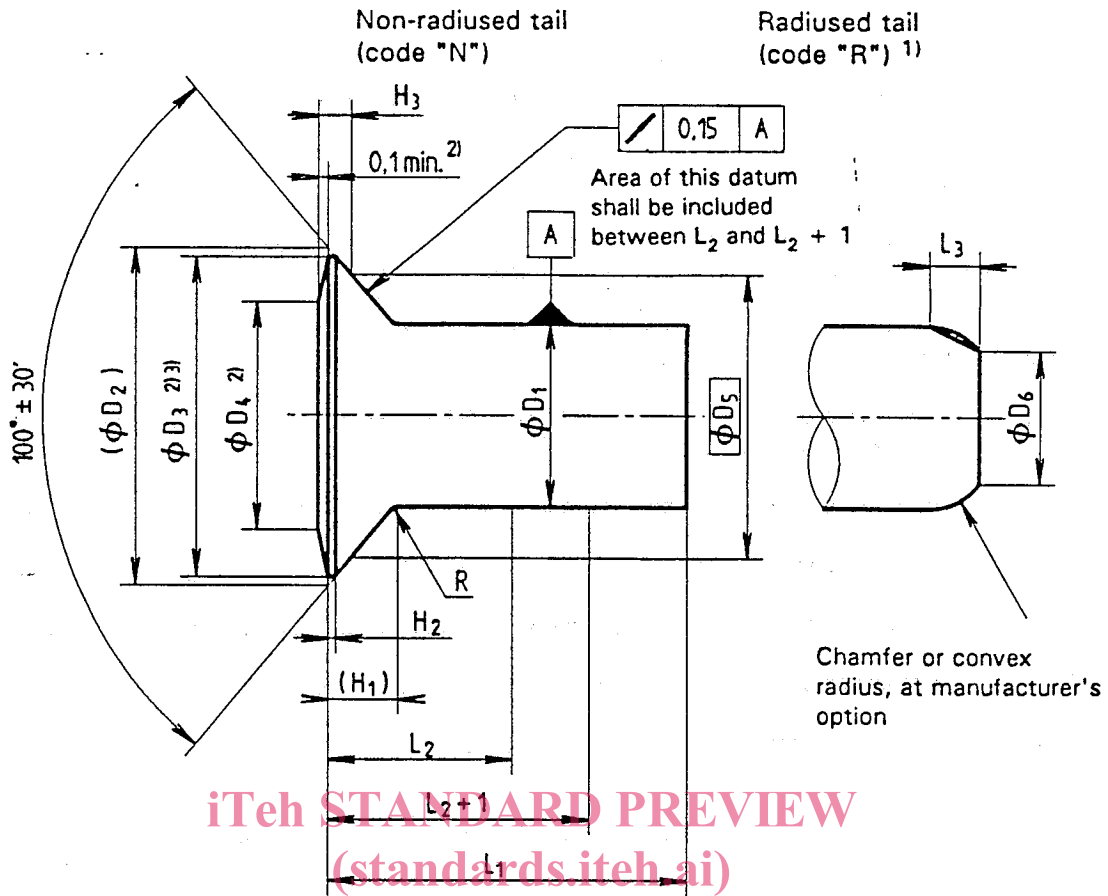
Table 1

Surface treatment		Code
EN 2284B		A
EN 2437-2A		B
EN 2101B ¹⁾	Not colored rivets	— (hyphen)
	Violet-colored rivets	F
1) Specified in the AECMA standard (prEN 2552). Shall be replaced by EN 2284B.		

1) Published as AECMA standard at the date of publication of the present standard

2) In preparation at the date of publication of the present standard

3) This specification is published by Superintendent of Documents, US Government Printing office, Washington, DC 20402, United States.



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- 1) The length range is limited (see table 2).
- 2) Shape optional (except concave) within limiting dimensions.
- 3) Blended convex form permissible within limiting dimensions

Figure 1

Table 1

Diameter code	$D_1^{1)}$		$D_2^{2)}$	D_3 min.	D_4		D_5	D_6		H_1	H_2 min.	H_3		L_2	L_3		R $\pm 0,08$
	max.	min.			max.	min.		max.	min.			max.	min.		max.	min.	
016	1,65	1,55	3	2,65	2,4	1,6	2,46	—	—	0,6	0,03	0,33	0,25	2,1	—	—	0,15
024	2,45	2,35	4,65	4,2	3,6	2,4	3,84	1,9	1,6	0,9	0,05	0,44	0,36	2,4	0,8	0,5	
032	3,25	3,15	5,8	5,3	4,8	3,2	4,88	2,6	2,3	1,1	0,06	0,49	0,41	2,6	1	0,7	
040	4,05	3,94	7,35	6,8	6	4	6,17	3,2	2,8	1,4	0,08	0,6	0,52	3	1,2	0,8	0,25

1) D_1 max. may increase by 0,03, over length $(L_2 - H_1)$.
2) Maximum condition

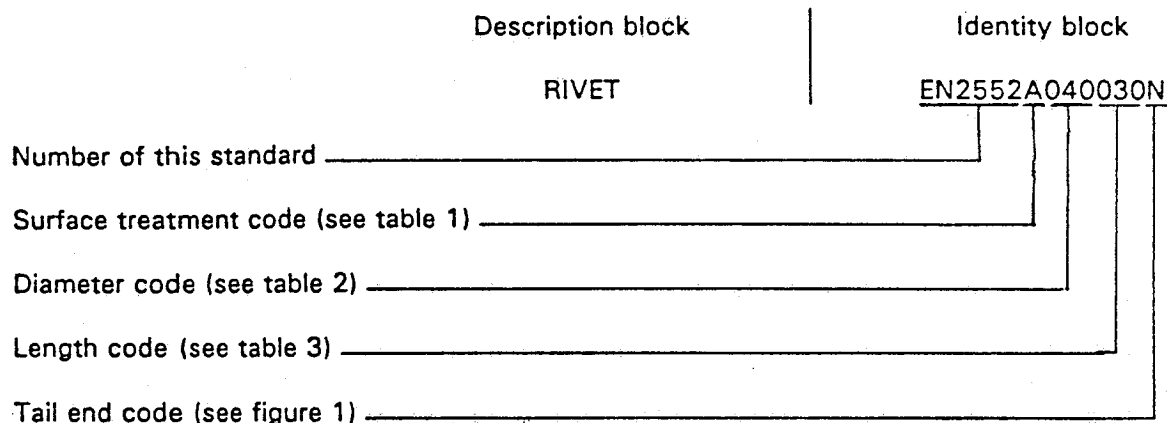
Table 2

Diameter code		016			024			032			040		
Length		1)		Mass ²⁾	1)		Mass ²⁾	1)		Mass ²⁾	1)		Mass ²⁾
Code	$L_1 + 0,5$ 0	N	R	kg/1000 pieces	N	R	kg/1000 pieces	N	R	kg/1000 pieces	N	R	kg/1000 pieces
003	3	x		0,026			—			—			—
004	4	x		0,032	x	x	0,080	x	x	0,147			—
005	5	x		0,038	x	x	0,093	x	x	0,170			—
006	6	x		0,044	x	x	0,106	x	x	0,193	x	x	0,323
007	7	x		0,050	x	x	0,119	x	x	0,216	x	x	0,358
008	8	x		0,056	x	x	0,132	x	x	0,239	x	x	0,394
009	9	x		0,062	x	x	0,145	x	x	0,261	x	x	0,430
010	10	x		0,067	x	x	0,158	x	x	0,284	x	x	0,465
011	11	x		0,073	x	x	0,171	x	x	0,307	x	x	0,500
012	12	x		0,079	x	x	0,184	x	x	0,330	x	x	0,536
014	14	x		0,091	x	x	0,210	x	x	0,376	x	x	0,607
016	16	x		0,103	x	x	0,236	x	x	0,422	x	x	0,678
018	18			—	x		0,262	x	x	0,467	x	x	0,750
020	20			—	x		0,288	x		0,513	x	x	0,820
022	22			—	x		0,314	x		0,559	x	x	0,891
024	24			—	x		0,340	x		0,605	x	x	0,962
026	26			—	x		0,366	x		0,651	x		1,033
028	28			—	x		0,392	x		0,696	x		1,105
030	30			—	x		0,418	x		0,742	x		1,176
032	32			—	x		0,444	x		0,788	x		1,247
035	35			—	x		0,483	x		0,856	x		1,353
040	40			—			—	x		0,971	x		1,531
045	45			—			—	x		1,085	x		1,709
050	50			—			—			—	x		1,886

1) Tail end code (see figure 1)
2) Approximate values, calculated on the basis of 2,76 kg/dm³, given for information purpose only

4 Designation

Example:



Note: If necessary, the originator code I9005 shall be placed between the description block and the identity block.

5 Marking

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5.1 Rivet identification

EN 2424, style G

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5.2 Material identification

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See figure 2 and table 3.

Symbol at manufacturer's option

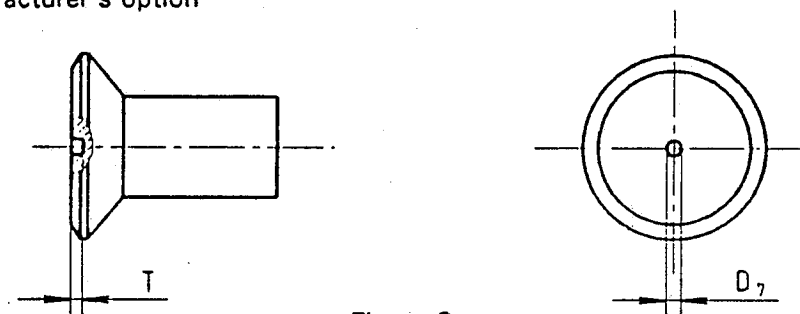


Figure 2

Table 3

Diameter code	016	024	032	040
T ± 0,05	0,13			0,15
D ₇ max.	0,8			

6 Technical specification

EN 2345 except for approval of manufacturers, see EN 2000.