

5 YfcbUj h\_U!`NU\_cj bY'a UhWZgUa cnUdJfUbYZdfYa ] bYZgUa cj Ufcj UbYŽ  
Xj cglfUbg\_YŽ]n`Y[ JfUbY[ U`Y`UŽdfYj`Y YbY'g`\_UXa JYa žbUa UnUbY'n`AcG&ž  
a Ylfg\_UgYfJ`U!`?`UgJZ\_UWU`- \$\$`ADUfJfJ`hYa dYfUi fJ`c\_c`JWt#&' )`š7

Aerospace series - Nuts, anchor, self-locking, floating, self-aligning, two lug, in alloy steel, cadmium plated, MoS2 lubricated, metric series - Classification: 900 MPa (at ambient temperature) / 235 °C

Luft- und Raumfahrt - Annietsmuttern, selbstsichernd, schwenkbar, beiderseitiger Flansch, aus legiertem Stahl, verkadmet, MoS2-geschmiert, metrische Reihe - Klasse: 900 MPa (bei Raumtemperatur) / 235 °C

Série aéronautique - Écrous à riveter, à freinage interne, flottants, orientables, double patte, en acier allié, cadmiés, lubrifiés MoS2, série métrique - Classification: 900 MPa (à température ambiante) / 235 °C

**Ta slovenski standard je istoveten z: EN 2680:2006**

**ICS:**

49.030.30 Matice Nuts

**SIST EN 2680:2009 en,de**

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EUROPEAN STANDARD  
NORME EUROPÉENNE  
EUROPÄISCHE NORM

**EN 2680**

May 2006

ICS 49.030.30

English Version

**Aerospace series - Nuts, anchor, self-locking, floating, self-aligning, two lug, in alloy steel, cadmium plated, MoS2 lubricated  
- Classification: 900 MPa (at ambient temperature) / 235 °C**

Série aérospatiale - Écrous à river, à freinage interne, flottants, orientables, double patte, en acier allié, cadmiés, lubrifiés MoS2, série métrique - Classification: 900 MPa (à température ambiante) / 235 °C

Luft- und Raumfahrt - Annietsmuttern, selbstsichernd, schwenkbar, beiderseitiger Flansch, aus legiertem Stahl, verkadmet, MoS2-geschmiert - Klasse: 900 MPa (bei Raumtemperatur) / 235 °C

This European Standard was approved by CEN on 3 February 2006.

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.

This European Standard exists 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, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.



EUROPEAN COMMITTEE FOR STANDARDIZATION  
COMITÉ EUROPÉEN DE NORMALISATION  
EUROPÄISCHES KOMITEE FÜR NORMUNG

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## Foreword

This European Standard (EN 2680:2006) has been prepared by the European Association of Aerospace Manufacturers - Standardization (AECMA-STAN).

After enquiries and votes carried out in accordance with the rules of this Association, this Standard has 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 November 2006, and conflicting national standards shall be withdrawn at the latest by November 2006.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN [and/or CENELEC] shall not be held responsible for identifying any or all such patent rights.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and the United Kingdom.

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## EN 2680:2006 (E)

## 1 Scope

This standard specifies the characteristics of self-locking, floating, self-aligning, two lug anchor nuts, in alloy steel, cadmium plated, MoS<sub>2</sub>-lubricated, metric series.

Classification: 900 MPa <sup>1)</sup> / 235 °C <sup>2)</sup>

## 2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 5855-2, *Aerospace — MJ threads — Part 2: Limit dimensions for bolts and nuts.*

ISO 5858, *Aerospace — Nuts, self-locking, with maximum operating temperature less than or equal to 425 °C — Procurement specification.*

ISO 8788, *Aerospace — Nuts, metric — Tolerances of form and position.*

ISO 12273, *Aerospace — Nuts, anchor, self-locking, floating, self-aligning, two lug, with MJ threads, classifications: 900 MPa (at ambient temperature)/235 °C, 900 MPa (at ambient temperature)/315 °C and 900 MPa (at ambient temperature)/425 °C — Dimensions.*

EN 2133, *Aerospace series — Cadmium plating of steels with specified tensile strength ≤ 1 450 MPa, copper, copper alloys and nickel alloys.*

EN 2424, *Aerospace series — Marking of aerospace products.*

EN 2491, *Aerospace series — Molybdenum disulphide dry lubricants — Coating methods.*

EN 9100, *Aerospace series — Quality management systems — Requirements (based on ISO 9001:2000) and Quality systems — Model for quality assurance in design, development, production, installation and servicing (based on ISO 9001:1994).*

EN 9133, *Aerospace series — Quality management systems — Qualification Procedure for aerospace standard parts.*

TR 3791, *Aerospace series — Materials for self-locking nuts, threaded inserts and screw thread inserts of temperature classes ≤ 425 °C.<sup>3)</sup>*

## 3 Required characteristics

### 3.1 Configuration – Dimensions – Masses

See Figure 1 and Table 1.

1) Corresponds to the minimum tensile stress which the nut is able to withstand at ambient temperature without breaking or cracking when tested with a bolt of a higher strength class.

2) Maximum temperature that the nut is able to withstand, without permanent alteration to its original characteristics, after ambient temperature has been restored. The maximum temperature is conditioned by the cadmium plating.

3) Published as AECMA Technical Report at the date of publication of this standard.

Dimensions and tolerances are in conformity with ISO 12273, expressed in millimetres and apply after cadmium plating but before MoS<sub>2</sub> lubrication.

Details of form not stated are at the manufacturer's option.

### **3.2 Tolerances of form and position**

See ISO 8788.

### **3.3 Materials**

See TR 3791.

### **3.4 Surface treatments**

EN 2133, 5 µm min. on threads and all surfaces which can be contacted by a 20 mm diameter ball. On all other surfaces, a continuous deposit shall be present.

EN 2491, thickness not specified, mandatory on threads, optional on other surfaces

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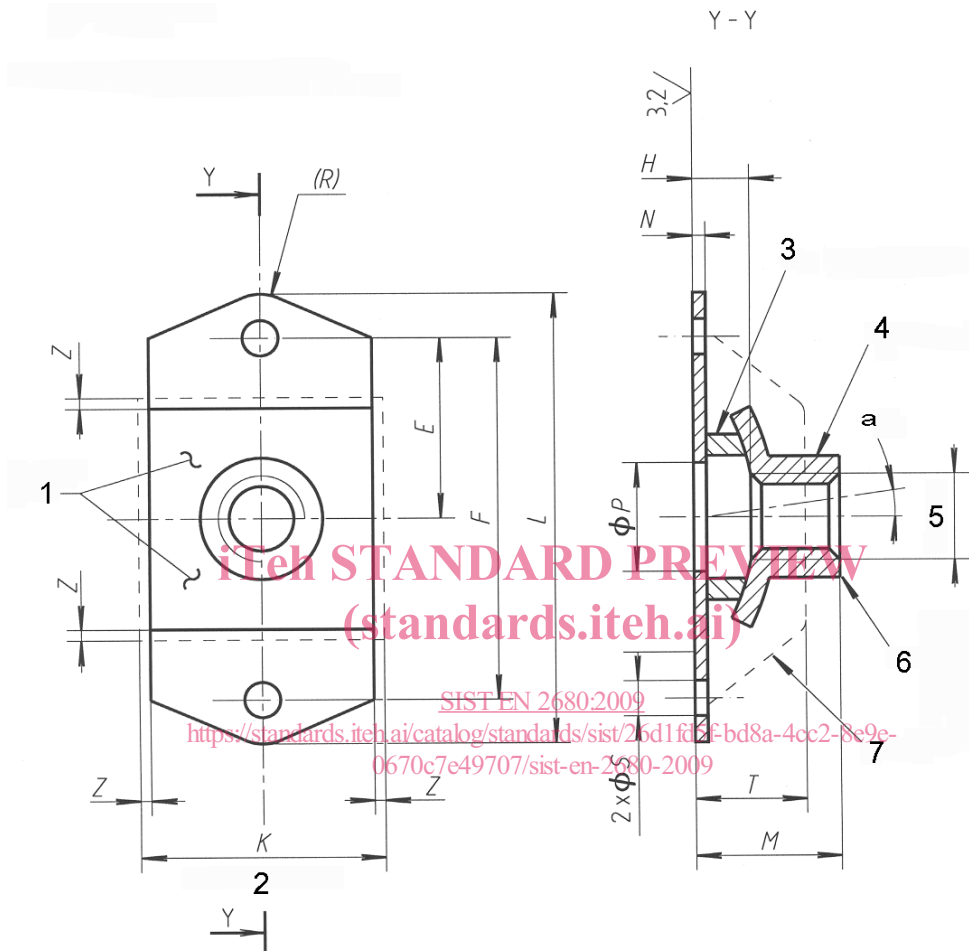
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## EN 2680:2006 (E)



These values in micrometres apply before surface treatment. They do not apply to threads, punched holes or sheared edges, the surface texture of which will be as achieved by usual manufacturing methods.

Remove sharp edges 0,1 to 0,4.



## Key

- 1 Marking
- 2 Float inclusive
- 3 Convex washer
- 4 Threaded element
- 5 Thread
- 6 Form-out-round in this area to achieve the self-locking torque requirement. Tooling marks are permitted in this area.
- 7 Cage
- <sup>a</sup> 8° minimum alignment in any direction from central position

Figure 1