



SLOVENSKI STANDARD

SIST EN 2752:2001

01-januar-2001

Aerospace series - Nuts, anchor, self locking fixed, two lug, reduced series, with counterbore - Classification : 1100 MPa/235 degree C

Aerospace series - Nuts, anchor, self locking fixed, two lug, reduced series, with counterbore - Classification : 1100 MPa/235 degree C

Luft- und Raumfahrt - Anniemuttern, selbstsichernd, beiderseitiger verkürzter Flansch mit zylindrischer Aussenkung - Klasse : 1100 MPa/235 Grad C

Série aérospatiale - Ecrous a river a freinage interne fixes, a double patte, série réduite avec chambrage - Classification : 1100 MPa/235 degré C

<https://standards.iteh.ai/catalog/standards/sist/582ed943-9f9a-42e3-86dd-60cf5033f6ca/sist-en-2752-2001>

Ta slovenski standard je istoveten z: EN 2752:1989

ICS:

49.030.30 Matice Nuts

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EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

EN 2752

March 1989

UDC : 621.882.39 : 621.882.55 : 629.7

Key words : Aircraft industry - Anchor nuts, counterbore nuts - Self locking nuts, two lug nuts - Specifications, dimensions, designation

English version

**Aerospace series
Nuts, anchor, self locking
fixed, two lug, reduced series,
with counterbore
Classification : 1100 MPa/235 °C**

**Série aérospatiale
Écrous à river à freinage interne
fixes, double patte, série réduite
avec chambrage
Classification : 1100 MPa/235 °C**

**Luft- und Raumfahrt
Anniemuttern, selbstsichernd,
beiderseitiger verkürzter Flansch
mit zylindrischer Aussenkung
Klasse : 1100 MPa/235 °C**

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Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the CEN 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 CEN Central Secretariat has the same status as the official versions.

CEN members are the national standards organizations of Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxemburg, 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 Bréderode 2, B—1000 Bruxelles

Brief history

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

After enquiries 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.

According to the Common CEN/CENELEC Rules, following countries are bound to implement this European Standard: Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxemburg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

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1 Scope

This standard specifies the characteristics of self locking, two lug, fixed, reduced series anchor nuts, with counterbore.

2 Field of application

These nuts are intended for use in aircraft assemblies subjected principally to shear loading.

They are intended to be used with bolts of 1100 MPa tensile strength classification.

The counterbore can accommodate a bolt plain shank in excess of assembly thickness, as well as the incomplete threads.

The cadmium plating restricts the application to temperatures not exceeding 235 °C.

3 References

- ISO 5855/1, Aerospace Construction - MJ Threads - Part 1 : Basic profile
 ISO 5855/2, Aerospace Construction - MJ Threads - Part 2 : Dimensions for bolts and nuts
- ISO 5858, Aerospace - Self locking nuts, maximum operating temperature ≤ 425 °C - Procurement specification 1)
- ISO 8788, Aerospace - Fasteners - Tolerances of form and position for nuts
- EN 2000, Aerospace series - Quality assurance requirements for the manufacture and procurement of EN aerospace standard products
- EN 2133, Cadmium plating of steels with maximum specified tensile strength equal to or less than 1450 MPa, and copper and copper alloys (standards.iteh.ai)
- EN 2424, Aerospace series - Identification marking of standard fasteners
 EN 2491, Aerospace series - Molybdenum disulfide dry film lubricants to removable fasteners in titanium titanium alloy, corrosion resisting steel and cadmium plated steels 1)
- EN 2543, Aerospace series - Steel FE-PL43S - $1250 \leq R_m \leq 1400$ MPa - Sheet and strip - $0,3 \leq a \leq 2$ mm - Only for prevailing torque nuts 1).

4 Required characteristics

4.1 Configuration - Dimensions - Tolerances

The configuration shall correspond with the figure, which does not dictate any particular method of manufacture. Details of form not defined are at manufacturer's option.

Dimensions and tolerances 2) specified in the figure and the table shall apply after cadmium plating, but before application of MoS₂ lubrication.

4.2 Material

Steel EN 2543.

4.3 Surface treatment

- Cadmium plating EN 2133, 5 μ m minimum on the threads and all areas which can be contacted by a 20 mm diameter ball. On all other areas, a continuous deposit shall be present but no minimum value is specified.

- Lubrication by MoS₂ EN 2491, mandatory on threads, optional on other surfaces.

1) In preparation.

2) In conformity, with ISO 8788 for tolerances of form and position.

6,3√(3,2√)³

Break all corners 0,1 to 0,4 mm

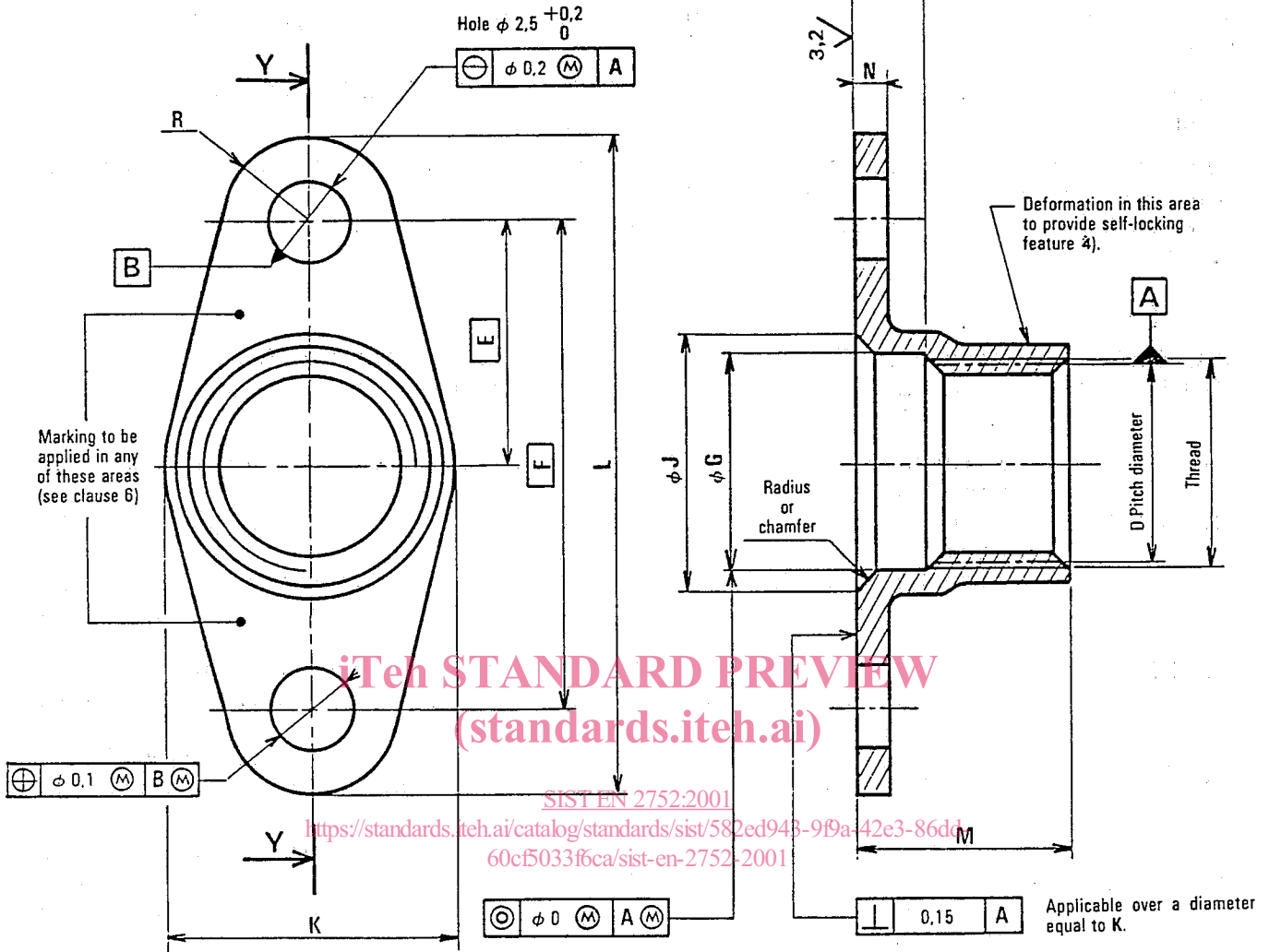


Figure — Configuration

Table — Dimensions and masses

Dimensions in millimetres

| Code | Thread 5) | E | F | G min. | H min. | J 6) max. | K max. | L max. | M max. | N 7) max. | R | Mass kg/1000 pieces max. |
|------|-------------------|---|----|-----------|-----------|--------------|-----------|-----------|-----------|--------------|-----|--------------------------------|
| 040 | MJ 4 × 0,7 - 4H6H | 6 | 12 | 4,4 | 2,2 | 6,2 | 8 | 17,2 | 5,8 | 1,1 | 2,5 | 1,2 |
| 050 | MJ 5 × 0,8 - 4H6H | 7 | 14 | 5,5 | 2,4 | 7,3 | 9 | 19,2 | 6,9 | 1,1 | 2,5 | 1,5 |
| 060 | MJ 6 × 1 - 4H5H | 8 | 16 | 6,5 | 2,7 | 8,7 | 10 | 22,2 | 8,1 | 1,3 | 3 | 2,2 |

3) Values apply prior to cadmium plating and MoS₂ lubrication. They do not apply to the thread, sheared edges and punched edges; the surface roughness will be as achieved by normal methods of manufacture.

4) Tooling marks are permitted in this area.

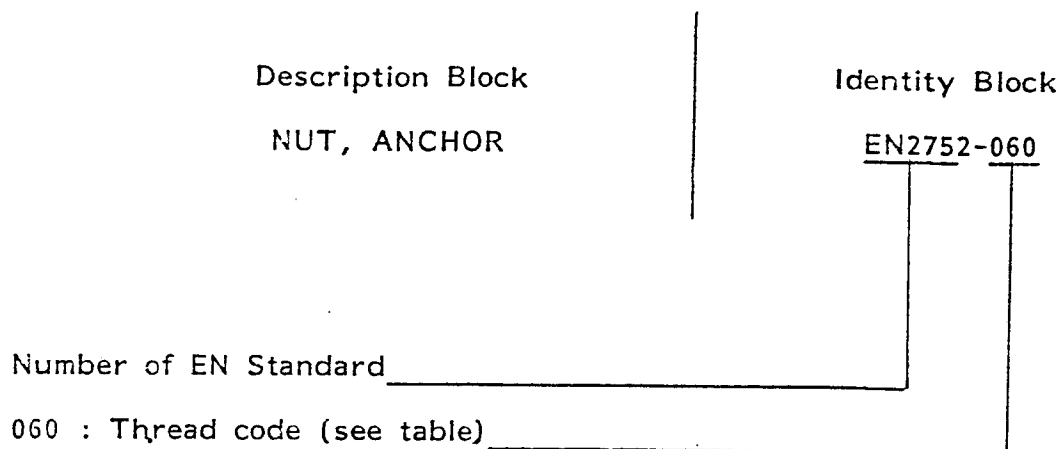
5) In conformity with ISO 5855 parts 1 and 2. In the self locking zone, the tolerances apply before deformation.

6) Is measured at sharp corners (chamfered) or point of tangency (radiused).

7) Is applicable at the rivet hole location.

5 Designation

Each nut shall only be designated as in the following example :



Note : If necessary the originator code S9005 may be introduced between the description block and the identity block.

6 Marking

Each nut shall be marked in any of the positions shown on the figure in accordance with EN 2424, Style F.

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7 Technical specification

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Conforming to ISO 5858 ~~except for certification~~ and quality assurance requirements - see EN 2000.