



SLOVENSKI STANDARD
SIST EN 2898:2008
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Aerospace series - Corrosion and heat resisting steel rivets - Technical specification

Luft- und Raumfahrt - Niete aus hochwarmfesten und korrosionsbeständigen Stählen -
Technische Lieferbedingungen

Série aérospatiale - Rivets en acier résistant à chaud et à la corrosion - Spécification
technique

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EUROPEAN STANDARD

EN 2898

NORME EUROPÉENNE

EUROPÄISCHE NORM

March 2008

ICS 49.030.60

English Version

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la corrosion - Spécification technique

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korrosionsbeständigen Stählen - Technische
Lieferbedingungen

This European Standard was approved by CEN on 12 December 2007.

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 CEN Management Centre 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 CEN Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, 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.

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COMITÉ EUROPÉEN DE NORMALISATION
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Contents

Page

Foreword.....	3
1 Scope	4
2 Normative references	4
3 Terms and definitions	4
4 Required characteristics	5
5 Filing of documents.....	9
6 Certificate of conformity	9

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Foreword

This document (EN 2898:2008) has been prepared by the Aerospace and Defence Industries Association of Europe - Standardization (ASD-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 ASD, 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 September 2008, and conflicting national standards shall be withdrawn at the latest by September 2008.

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, Bulgaria, 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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1 Scope

This standard specifies the performance and test requirements for corrosion and heat resisting solid steel rivets intended for aerospace applications. It applies whenever it is specified in the document defining the rivet.

Its use, after agreement between the customer and the supplier, for solid rivets made from other materials, requires determination, case by case, of the minimum tensile and double shear loads.

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 2859-1, *Sampling procedures for inspection by attributes — Part 1: Sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection.*

EN 2002-001, *Aerospace series — Metallic materials — Test methods — Part 001: Tensile testing at ambient temperature.*

EN 2002-7, *Aerospace series — Metallic materials — Test methods — Part 7: Hardness test.* ¹⁾

EN 2119, *Aerospace series — Heat resisting alloy FE-PA2601 (X6NiCrTiMoV26-15) — Solution treated and precipitation treated — Wires for rivets — $2\text{ mm} \leq D \leq 10\text{ mm}$ — $R_m \geq 960\text{ MPa}$.* ¹⁾

EN 2470, *Steel FE-PA11 — Softened and cold drawn — Wires for rivets $1\text{ mm} \leq D \leq 10\text{ mm}$ — Aerospace series.* ²⁾

EN 3238, *Aerospace series — Metallic materials — Test method — Shear test for wires and rivets.* ³⁾

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

3.1 batch
for all tests, inspections and supplies, a batch of rivets is defined as follows: finished rivets of the same form, diameter and length, manufactured by the same process, made from one material, batch from the same heat treatment furnace with the same surface treatment, and deriving from the same wire coil and the same place of manufacture

The maximum mass of each batch is limited to 25 kg.

1) Published as ASD Prestandard at the date of publication of this standard.

2) Published as ASD Standard at the date of publication of this standard

3) In preparation at the date of publication of this standard.

3.2**rivet wire samples**

for test, each rivet batch shall be accompanied by rivet wire samples taken from each end of the coil used to manufacture the batch. The samples shall be submitted to the same heat treatment as the rivets of that batch

3.3**rivet samples**

rivet samples intended for tests shall be chosen at random from each batch

4 Required characteristics

The rivets shall conform with the requirements of the document defining the rivet and those prescribed in Table 1. Inspections and tests are to be carried out by the rivet manufacturer.

Table 1 — Technical requirements and test methods

Subclause	Characteristics	Technical requirements	Inspection and test methods	Number of samples
4.1	Materials	Shall conform with the requirements of the material standard quoted in the document defining the rivet.	See material specification.	—
4.2	Dimensions	Shall conform with the requirements of the document defining the rivet. https://standards.iteh.ai/catalog/standards/sist/f0c3b10e-1c65-4b77-8814-5867f280fac8/sist-en-2898-2008	Methods are at manufacturer's option. In case of dispute, the projection method at $\times 25$ magnification for diameter of up to 8 mm and $\times 10$ for diameter above shall be used as a reference method. The inspection shall be carried out at three equidistant points around the rivet.	Table 2
4.3	Heat treatment	Shall conform with the condition of use defined in the material standard.	See 4.5.	—
4.4	Surface treatment	Shall be in conformity with the defining document.	Methods are at manufacturer's option.	—
4.5	Mechanical properties	Shall be checked either by a double shear test or by a tensile test combined with a hardness test.	—	—
4.5.1	Double shear	Non-assembled rivets (i.e. without post-formed head) shall conform with the values specified in Table 4.	See EN 3238. If the rivets are not long enough for the double shear test, it shall be carried out on the wire samples.	Table 3
4.5.2	Tension	Rivet wire samples shall conform with the values specified given in Table 5.	See EN 2002-001.	Table 3

continued

Table 1 — Technical requirements and test methods (continued)

Subclause	Characteristics	Technical requirements	Inspection and test methods	Number of samples
4.5.3	Hardness	Hardness values for rivet wire samples shall conform with the requirements of the corresponding material standard. Hardness values for rivets shall correspond with the rivet hardness values within a tolerance of $\pm 5\%$.	See EN 2002-7.	Table 3
4.5.4	Upset test	After upset the head of the rivet shall be free from cracks or folds when viewed at a magnification of $\times 10$.	Rivets shall be placed in a test fixture substantially conforming to Figure 1 a). The free end of the rivet shall be upset using a flat tool to obtain a head conforming to the requirements of Figure 1b).	Table 3 This test to be performed only at the request of the purchaser
4.6	Surface condition, appearance	Rivets shall be free from seams, burrs, laps, crevices, incrustations, clefts, tooling marks, scores, cracks and other defect prejudicial to the use of the rivet.	Rivets shall be examined visually with or without magnification. Magnification is limited to $\times 6$.	Table 2
4.7	Identification and marking	Each rivet shall be marked in conformity with the defining document, except for particular indications requested by the customer. No sharp edges or other defect detrimental to the correct setting of the rivet shall be present.	Visual examination.	—
4.8	Packaging	Rivets shall be delivered in strong and durable packages, capable of protecting them from physical and corrosive deterioration. Any particular or additional packaging requirements shall be specified in the order. If the rivets delivered come from different batches, each batch shall be packed and identified separately. Unless particularly specified in the order, the number of rivets in the same package is left to the manufacturer's discretion. However, maximum mass is 25 kg. A copy of the manufacturer's delivery note relating to the rivet batch shall be included in the package but may, on the other hand, be sent separately on request.	—	—

continued

Table 1 — Technical requirements and test methods (concluded)

Subclause	Characteristics	Technical requirements	Inspection and test methods	Number of samples
4.9	Labelling	<p>Durable external labels on the package shall contain the following information:</p> <ul style="list-style-type: none"> – Identity block of standard rivet; – Quantity (mass or number of rivets); – Customer's order number; – Manufacturer's identification, name and address; – Number of manufacturer's delivery note; – Manufacturer's batch number; – Manufacturer's Inspection stamp. <p>Labels attached to a secondary package shall include the following information as a minimum:</p> <ul style="list-style-type: none"> – Identity block of the rivet; – Quantity; – Batch number; – Inspection stamp. 	—	—

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 Table 2 — Sampling plan and acceptance level ⁴⁾
 non-destructive tests

Number of rivets in batch	Number of rivets to be sampled from batch	Maximum number of defective rivets in sample allowing acceptance of batch ^a
151 to 280	32	3
281 to 500	50	5
501 to 1 200	80	7
1 201 to 3 200	125	10
3 201 to 10 000	200	14
10 001 to 35 000	315	21
35 001 to 150 000	500	21

^a Defective rivets shall not be returned to the batch.

4) Sampling plan for normal inspection to ISO 2859-1 (AQL = 4 %).