

SLOVENSKI STANDARD

SIST EN 3052:2001

01-januar-2001

Aerospace series - Bolts, normal hexagonal head, close tolerance normal shank, short thread, in heat and corrosion resisting steel, passivated - Classification: 1 100 MPa (at ambient temperature / 425° C (includes amendment A1:1993)

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Luft- und Raumfahrt - Sechskant-Paßschrauben, kurzes Gewinde, aus korrosionsbeständigem und hochwärmfestem Stahl, passiviert - Klasse : 1 100 MPa (bei Raumtemperatur) / 425 °C (enthält Änderung A1:1993)

[SIST EN 3052:2001](https://standards.iteh.ai/catalog/standards/sist/cd513ed2-bed0-4640-81ee-2a0011e20000/sist-en-3052-2001)

Série aérospatiale - Vis a tete hexagonale normale, tige normale a tolérance serrée, filetage court, en acier résistant a chaud et a la corrosion, passivées - Classification : 1 100 MPa (a température ambiante) / 425 °C (inclut l'amendement A1:1993)

Ta slovenski standard je istoveten z: EN 3052:1993

ICS:

49.030.20 Sorniki, vijaki, stebelni vijaki Bolts, screws, studs

SIST EN 3052:2001

en

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EUROPEAN STANDARD

EN 3052

NORME EUROPÉENNE

+ A1

EUROPÄISCHE NORM

December 1993

UDC 621.882.211-034.14.018.8.018.44:629.7

Descriptors: Aircraft industry, fasteners, machine screws, hexagonal head screws, corrosion resistant steels, classifications, specifications

English version

Aerospace series - Bolts, normal hexagonal head, close tolerance normal shank, short thread, in heat and corrosion resisting steel, passivated - Classification : 1 100 MPa (at ambient temperature / 425 °C (includes amendment A1:1993)

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Série aéronautique - Vis à tête hexagonale normale, tige normale à tolérance serrée, filetage court, en acier résistant à chaud et à la corrosion, passivées - Classification : 1 100 MPa (à température ambiante) / 425 °C (inclut l'amendement A1:1993)

Luft- und Raumfahrt - Sechskant-Paßschrauben, kurzes Gewinde, aus korrosionsbeständigem und hochwärmfestem Stahl, passiviert - Klasse : 1 100 MPa (bei Raumtemperatur) / 425 °C (enthält Änderung A1:1993)

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This European Standard was approved by CEN on 1993-12-06. 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 standard was submitted for Formal Vote, and the result was positive.

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 June 1994, and conflicting national standards shall be withdrawn at the latest by June 1994.

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, United Kingdom.

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1 Scope

This standard specifies the characteristics of bolts, normal hexagonal head, close tolerance normal shank, short thread, in heat and corrosion resisting steel, passivated.

Classification : 1 100 MPa ¹⁾ / 425 °C ²⁾

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.

- ISO 3193 Aerospace - Bolts, normal hexagonal head, normal shank, short or medium length MJ threads, metallic material, coated or uncoated, strength classes less than or equal to 1 100 MPa - Dimensions
- ISO 3353 Aerospace construction - Rolled threads - Runout and lead threads
- ISO 5855-2 Aerospace - MJ threads - Part 2 : Limit dimensions for bolts and nuts
- ISO 7913 Aerospace - Fasteners - Tolerances of form and position for bolts and screws
- ISO 8168 Aerospace - Corrosion- and heat-resisting steel bolts with strength classification 1 100 MPa and MJ threads - Procurement specification
- EN 2000 Aerospace series - Quality assurance - EN aerospace products - Approval of the quality system of manufacturers
- EN 2424 Aerospace series - Identification marking of standard fasteners ³⁾
- EN 2516 Aerospace series - Passivation of corrosion resistant steels and decontamination of nickel base alloys ⁴⁾
- EN 3042 Aerospace series - Quality assurance - EN aerospace products - Qualification procedure
- EN 4016 Aerospace series - Oversized bolts ⁴⁾
- TR 3775 Aerospace series - Bolts and pins - National materials ⁵⁾

1) Minimum tensile strength of the material at ambient temperature

2) Maximum temperature that the bolt can withstand without continuous change in its original characteristics, after return to ambient temperature. The maximum temperature is determined by the material.

3) Published as AECMA Standard at the date of publication of this standard

4) In preparation at the date of publication of this standard

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

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EN 3052:1993 + A1:1993

3 Required characteristics

3.1 Configuration - Dimensions - Masses

See figure 1 and table 1.

Dimensions and tolerances are : in conformity with ISO 3193, expressed in millimetres and apply after surface treatment.

3.2 Tolerances of form and position

ISO 7913 and table 1

3.3 Materials

TR 3775 (heat and corrosion resisting steel, classification 1 100 MPa / 425 °C)


3.4 Surface treatment

EN 2516C1

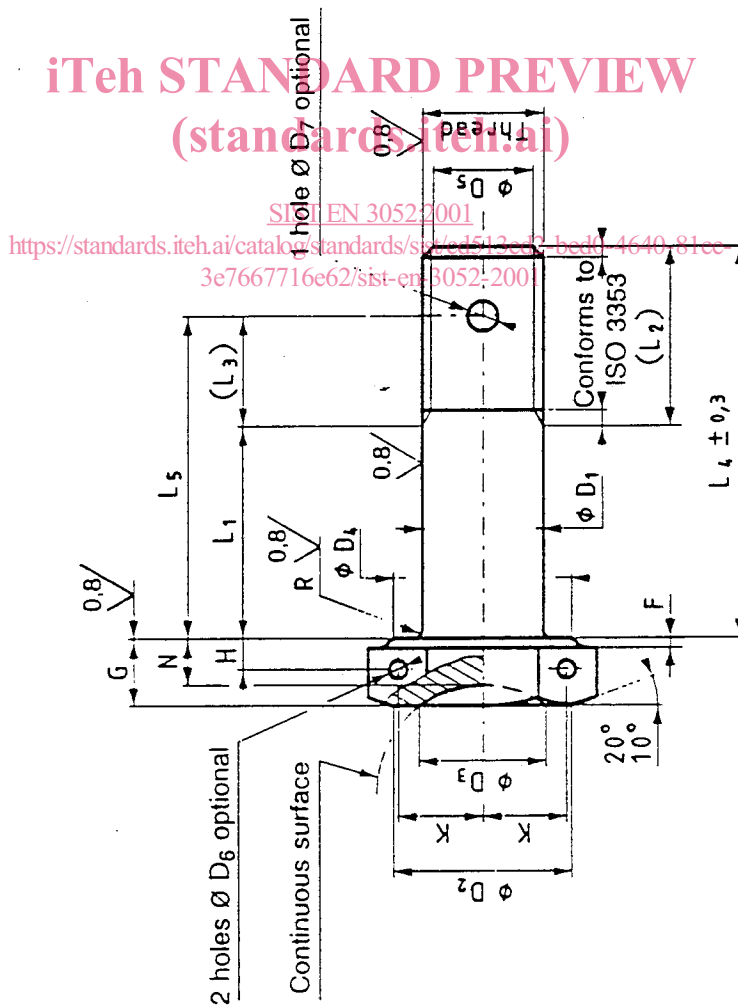
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Values in micrometres apply prior to surface treatment.



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Break sharp edges 0,1 to 0,4
Details of form not stated are left to the manufacturer's discretion.

Figure 1

Table 1

Diameter code	Thread ¹⁾	D ₁ f7	D ₂ min.	D ₃ 0 -0,5	D ₄ ²⁾ min.	D ₆ nom.	D ₆ Tol.	D ₆ H13	D ₇ H13	E min.	F		G 0 -0,3	H	J	
											max.	min.			nom.	Tol.
030	MJ3x0,5 - 4h6h	3	5,5	—	5,4	2,3	0	—	—	6,5	0,4	2	—	6	—	—
040	MJ4x0,7 - 4h6h	4	6,4	—	6,4	3	-0,5	—	1,1	7,6	—	2,5	—	7	—	—
050	MJ5x0,8 - 4h6h	5	7,4	5,25	7,4	3,4	—	1	1,5	8,7	—	3	—	8	—	—
060	MJ6x1 - 4h6h	6	9,4	6,25	9,3	4,2	—	1,4	1,9	10,9	0,5	3,5	1,35	10	—	—
070	MJ7x1 - 4h6h	7	10,3	7,25	10,2	5,2	—	1,4	1,9	12	—	4	1,85	11	—	—
080	MJ8x1 - 4h6h	8	12,3	8,25	12,2	6,2	—	1,4	1,9	14,3	—	4,5	2,1	13	—	—
100	MJ10x1,25 - 4h6h	10	16,3	10,25	16	7,9	± 0,5	—	2,4	18,9	—	5	2,35	17	—	—
120	MJ12x1,25 - 4h6h	12	18,3	12,25	18	9,8	—	—	—	21,1	—	6	2,85	19	—	—
140	MJ14x1,5 - 4h6h	14	21,3	14,25	21	11,5	—	—	—	24,5	—	7	3,35	22	—	—
160	MJ16x1,5 - 4h6h	16	23,3	16,25	23	13,5	—	1,6	3	26,8	0,6	8	3,85	24	—	—
180	MJ18x1,5 - 4h6h	18	26,3	18,25	26	15,5	—	—	3,8	30,2	—	9	4,35	27	—	—
200	MJ20x1,5 - 4h6h	20	29,3	20,25	29	17,5	—	—	—	33,6	—	10	4,85	30	—	—

¹⁾ In accordance with ISO 5855-2, except the thread major diameter "d max." which shall be D₁ min. - 0,025.

²⁾ D₄ max. shall be less than J.

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Table 1 (concluded)

Diameter code	K	L ₁ ± 0,2 (3) 4) nom.		L ₂	L ₃	N	R		U ⁵⁾	V ⁵⁾	Y ⁵⁾	Masse ⁸⁾	
		Length code					max.	min.				9)	10)
030	—	002 to 030	2 to 30	6	—	—	0,4	0,2	0,10 6)	0,002 6)	0,15 6)	0,87	0,06
040	—	002 to 040	2 to 40	7,5	5	—	0,5	0,3				1,66	0,10
050	3,25	003 to 050	3 to 50	9	6	2	0,7	0,5				2,91	0,15
060	4,1	003 to 060	3 to 60	10	7	2,3	0,8	0,5				5,44	0,22
070	4,5	004 to 070	4 to 70	11	7,5	2,7	0,8	0,5				7,45	0,30
080	5,35	004 to 080	4 to 80	11,5	9	3	0,8	0,6				11,22	0,39
100	7,1	005 to 100	5 to 100	14,5	9	3,4	0,9	0,6	7)	7)	7)	21,78	0,62
120	7,9	006 to 120	6 to 120	16	10	4	0,9	0,8				34,82	0,89
140	9,2	007 to 140	7 to 140	19	12	4,7	1,1	0,8				53,61	1,21
160	10,05	008 to 160	8 to 160	20,5	13	5,4	1,3	0,8				78,40	1,58
180	11,3	009 to 180	9 to 180	22,5	14,5	6	1,3	1				110,48	2,00
200	12,6	010 to 200	10 to 200	24,5	15	6,7	1,3	1				151,14	2,47

3) Increments :

1 for L₁ ≤ 302 for 30 < L₁ ≤ 1004 for L₁ > 1004) If greater lengths are necessary, they shall be chosen using the above increments. The length code corresponds to length L₁, completed by one or two zeros to the left, where necessary, to obtain a 3 digit code.

5) Symbol in accordance with ISO 7913

6) Not included in ISO 7913 at the date of publication of this standard

7) See ISO 7913.

8) Approximate values (kg/1000 pieces), calculated on the basis of 7,85 kg/dm³, for information purposes only. They apply to bolts without hole.9) Value for head and first L₄10) Increase for each additional 1 mm of L₄