



**SLOVENSKI STANDARD  
SIST EN 3247:2004**

**01-maj-2004**

**Aerospace series - Pipe coupling 8°30' in titanium alloy - Unions, bulkhead, welded end**

Aerospace series - Pipe coupling 8°30' in titanium alloy - Unions, bulkhead, welded end

Luft- und Raumfahrt - Rohrverschraubung 8°30' aus Titanlegierung - Gerade Schottverschraubungen mit Anschweißende

**iTeh STANDARD PREVIEW**

Série aérospatiale - Systeme de raccordement 8°30' en alliage de titane - Raccords droits pour traversée de cloison, a souder

[SIST EN 3247:2004](https://standards.iteh.ai/catalog/standards/sist/e22a9c1c-fl89-481f-a2ec-57706af7cfe2/sist-en-3247-2004)

**Ta slovenski standard je istoveten z: EN 3247:2001**

**ICS:**

49.080 Štepanje [b]ã Aerospace fluid systems and components

**SIST EN 3247:2004 en**

**iTeh STANDARD PREVIEW**  
**(standards.iteh.ai)**

[SIST EN 3247:2004](#)

<https://standards.iteh.ai/catalog/standards/sist/e22a9c1c-fl89-481f-a2ec-37708af7cfe2/sist-en-3247-2004>

EUROPEAN STANDARD  
NORME EUROPÉENNE  
EUROPÄISCHE NORM

**EN 3247**

October 2001

ICS 49.080

English version

## Aerospace series - Pipe coupling 8°30' in titanium alloy - Unions, bulkhead welded end

Série aérospatiale - Système de raccordement 8°30' en  
alliage de titane - Raccords droits à souder pour traversée  
de cloison

Luft- und Raumfahrt - Rohrverschraubung 8°30' aus  
Titanlegierung - Gerade Schottverschraubungen mit  
Anschweißende

This European Standard was approved by CEN on 6 January 2001.

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 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 Management Centre has the same status as the official versions.

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

SIST EN 3247:2004

<https://standards.iteh.ai/catalog/standards/sist/e22a9c1c-fl89-481f-a2ec-37708af7cfe2/sist-en-3247-2004>



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

Management Centre: 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 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 April 2002, and conflicting national standards shall be withdrawn at the latest by April 2002.

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

<https://standards.iteh.ai/catalog/standards/sist/e22a9c1c-fl89-481f-a2ec-37708af7cfe2/sist-en-3247-2004>

## 1 Scope

This standard specifies the characteristics of unions, bulkhead, welded end, for pipe couplings 8°30', in titanium alloy, for aerospace applications.

Nominal pressure: 28 000 kPa

Temperature range: – 55 °C to 135 °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 (including amendments).

ISO 5855-3	Aerospace – MJ threads – Part 3: Limit dimensions for fittings for fluid systems
EN 2424	Aerospace series – Marking of aerospace products
EN 2491	Aerospace series – Molybdenum desulphide dry lubricants – Coating methods
EN 2656	Aerospace series – Pipe coupling – Coupling ends, welded – Geometric configuration
EN 3267	Aerospace series – Washers, bulkhead, in titanium alloy
EN 3274	Aerospace series – Pipe coupling 8°30' – Thread ends – Geometric configuration
EN 3275	Aerospace series – Pipe coupling 8°30' up to 28 000 kPa – Dynamic beam seal – Metric series – Technical specification
EN 3311	Aerospace series – Titanium alloy, TI-P64001 – Annealed – Bar for machining – $D \leq 150 \text{ mm}^1$
EN 3314	Aerospace series – Titanium alloy TI-P64001 – Solution treated and aged – Bar for machining – $D \leq 75 \text{ mm}^1$

## 3 Required characteristics

### 3.1 Configuration – Dimensions – Mass

According to figure 1 and figure 2 and table 1. The values apply before lubricating.

Dimensions not specified are at the manufacturer's option provided that the qualification and acceptance requirements of EN 3275, type II are met.

<sup>1)</sup> Published as AECMA Prestandard at the date of publication of this standard

EN 3247:2001 (E)

### 3.2 Surface roughness

According to figure 1 and figure 2, unless otherwise specified in the design documentation

### 3.3 Materials

According to EN 3311 or EN 3314

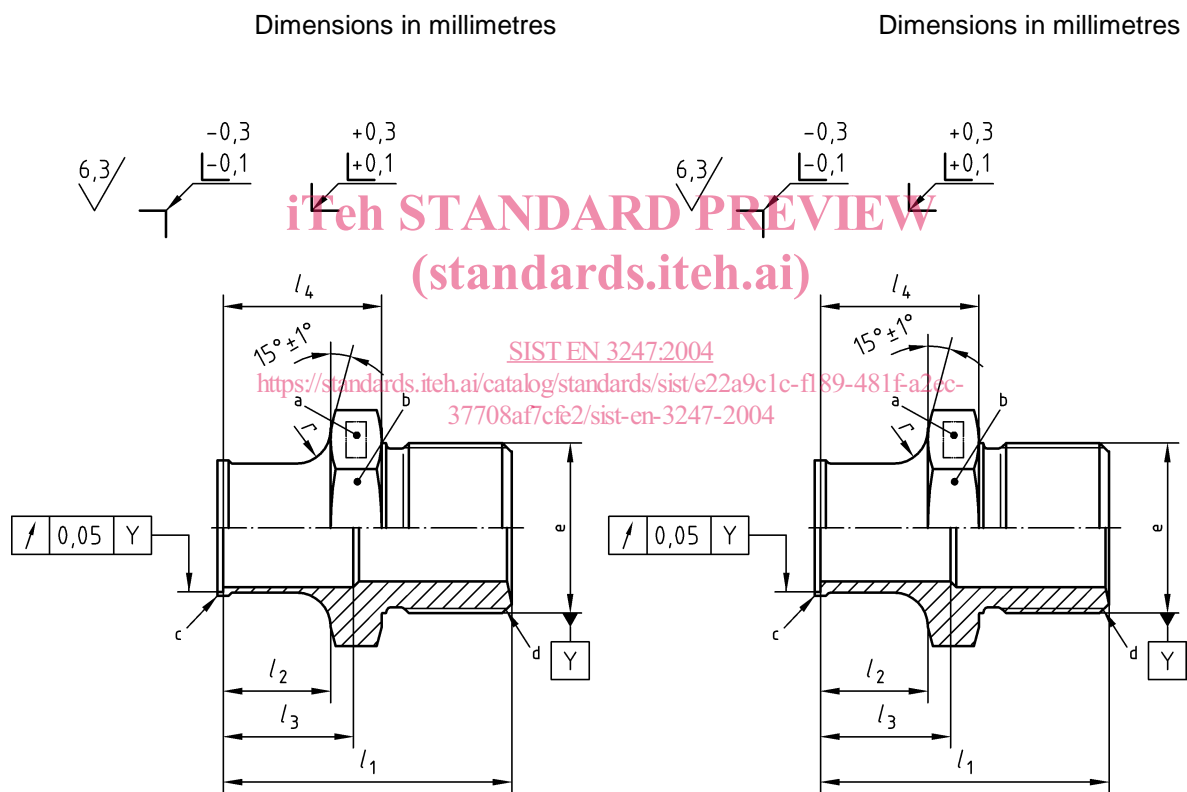
### 3.4 Surface treatment

Welded end without surface treatment, min. 10 mm (outside and bore diameters)

Lubrication: according to EN 2491, on thread and sealing face.

Prior to application of the lubricant, the surface shall be abrasive blasted using non-metallic grit.

Film thickness 0,005 mm to 0,013 mm



- a Area for marking
- b Across flats  $s$
- c According to EN 2656
- d According to EN 3274, form E
- e Thread

NOTE Pipe internal diameter  $d_1$  in accordance with EN 2656 > diameter  $d_1$  in accordance with EN 3274

**Figure 1**

- a Area for marking
- b Across flats  $s$
- c According to EN 2656
- d According to EN 3274, form E
- e Thread

NOTE Pipe internal diameter  $d_1$  in accordance with EN 2656 < diameter  $d_1$  in accordance with EN 3274

**Figure 2**

Table 1

Dimensions in millimetres

Code <sup>a b</sup>	Thread <sup>c</sup>	$l_1^d$	$l_2$	$l_3$	$l_4$	$r$	$s$	Mass g/piece
	4g6g		$\pm 0,2$	$\pm 0,5$	$\pm 0,2$	$\begin{matrix} +0,2 \\ 0 \end{matrix}$	h13	max.
<b>0504</b> <b>0505</b>	MJ10×1	38	13	19	22,5	5	14	10,69 10,80
<b>0605</b>	MJ12×1,25	40	13	18	22	5	17	16,08
<b>0805</b> <b>0806</b>	MJ14×1,5	42	13	17	21	5	19	19,67 19,83
<b>1005</b> <b>1008</b>	MJ16×1,5	43	13	17	21	5	22	25,16 26,00
<b>1205</b> <b>1206</b> <b>1209</b>	MJ18×1,5	45	13	17	22	5	24	31,66 31,94 32,74
<b>1405</b> <b>1408</b> <b>1410</b>	MJ20×1,5	46	14	18	23	5	27	40,00 41,04 41,66
<b>1605</b> <b>1606</b> <b>1610</b> <b>1612</b>	MJ22×1,5	48	16	20	25	5	30	51,09 51,53 53,23 54,03
<b>1805</b> <b>1807</b> <b>1810</b> <b>1813</b>	MJ24×1,5	50	18	22	27	6	32	53,10 54,21 55,78 57,29
<b>2006</b> <b>2007</b> <b>2012</b> <b>2015</b>	MJ27×1,5	51	19	23	28	7	34	60,72 61,37 64,38 66,11
<b>2208</b> <b>2212</b> <b>2216</b>	MJ30×1,5	51	19	23	28	7	36	68,84 71,55 74,11
<b>2508</b> <b>2509</b> <b>2514</b> <b>2518</b>	MJ33×1,5	52	20	24	29	7	41	88,99 89,79 93,70 96,73
<b>2808</b> <b>2810</b> <b>2816</b> <b>2820</b>	MJ36×1,5	53,5	20	24	29	8	46	106,86 108,65 113,92 117,32
<b>3210</b> <b>3212</b>	MJ39×1,5	55,5	22	26	31	8	50	123,11 134,47

<sup>a</sup> Corresponds to the pipe nominal outside diameter and wall thickness

<sup>b</sup> Relationship between code and pressure classification according to EN 2656

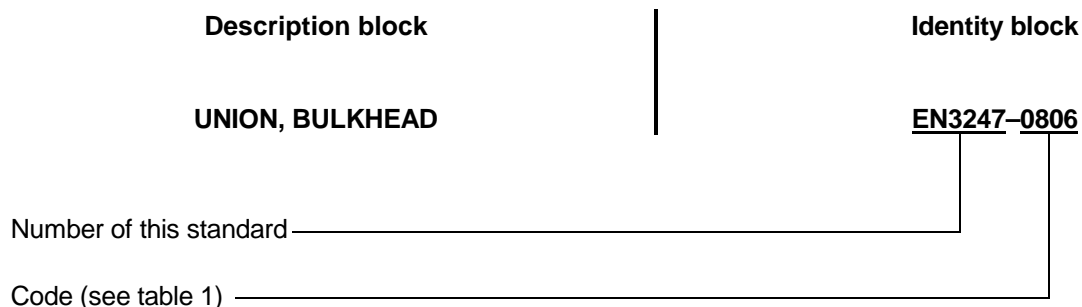
<sup>c</sup> According to ISO 5855-3

<sup>d</sup> According to  $l_4$  and EN 3274, form E

EN 3247:2001 (E)

#### 4 Designation

EXAMPLE:



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

#### 5 Marking

According to EN 2424, style A and figures 1 and 2.

**iTeh STANDARD PREVIEW**  
(standards.iteh.ai)

#### 6 Technical specification

According to EN 3275, type II

[SIST EN 3247:2004](https://standards.iteh.ai/catalog/standards/sist/e22a9c1c-fl89-481f-a2ec-37708af7cfe2/sist-en-3247-2004)  
<https://standards.iteh.ai/catalog/standards/sist/e22a9c1c-fl89-481f-a2ec-37708af7cfe2/sist-en-3247-2004>

#### 7 Installation details

See figure 3

Dimensions in millimetres

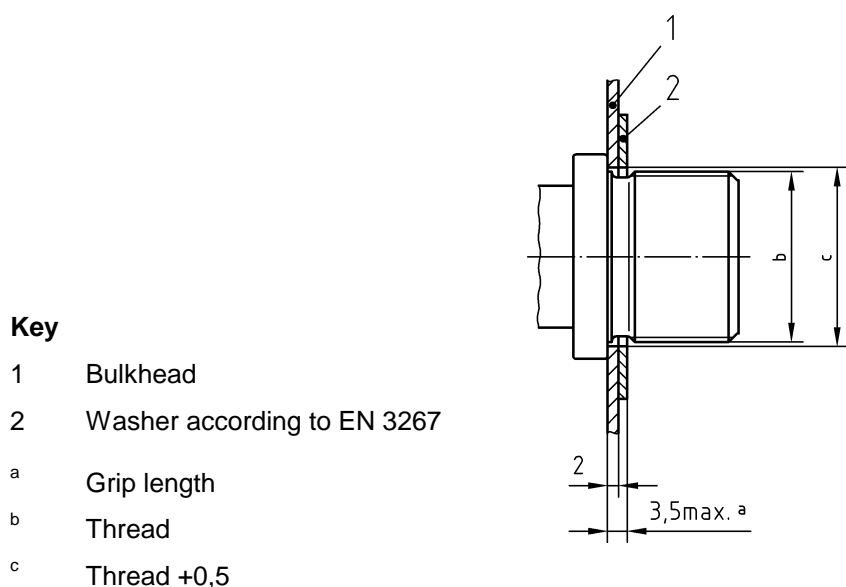


Figure 3