



SLOVENSKI STANDARD

SIST EN 3270:2004

01-maj-2004

Aerospace series - Pipe coupling 8°30' in titanium alloy - Blanking plugs with lockring

Aerospace series - Pipe coupling 8°30' in titanium alloy - Blanking plugs with lockring

Luft- und Raumfahrt - Rohrverschraubung 8°30' aus Titanlegierung - Verschlusschrauben mit Sicherungsring

Série aérospatiale - Systeme de raccordement 8°30' en alliage de titane - Obturateurs filetés avec bague de freinage

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Ta slovenski standard je istoveten z: **EN 3270:2001**

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ICS:

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

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en

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EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

EN 3270

October 2001

ICS 49.030.20

English version

Aerospace series - Pipe coupling 8°30' in titanium alloy - Blanking plugs with lockring

Série aérospatiale - Système de raccordement 8°30' en
alliage de titane - Obturateurs filetés avec bague de
freinage

Luft- und Raumfahrt - Rohrverschraubung 8°30' aus
Titanlegierung - Verschlusschrauben mit Sicherungsring

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.

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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.

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1 Scope

This standard specifies the characteristics for blanking plugs with lockring for pipe couplings 8°30', in titanium alloy, for aerospace applications.

Nominal pressure: up to 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 disulphide dry lubricants – Coating methods |
| EN 2602 | Aerospace series – Ports for installation of straight metric-size unions with locking ring – Dimensions ¹⁾ |
| EN 2603 | Aerospace series – Straight metric-size unions with locking ring – Port end – Dimensions ¹⁾ |
| EN 2645 | Aerospace series – Straight metric-size unions with locking ring – Locking ring – Dimensions ¹⁾ |
| EN 3079 | Aerospace series – Pipe coupling 8°30' up to 28 000 kPa – Adaptors – Metric series – Technical specification |
| EN 3311 | Aerospace series – Titanium alloy TI-P64001 – Annealed – Bar for machining – $D \leq 150$ mm ¹⁾ |
| EN 3314 | Aerospace series – Titanium alloy TI-P64001 – Solution treated and aged – Bar for machining – $D \leq 75$ mm ¹⁾ |
| AMS 2488D | Anodic Treatment - Titanium and Titanium Alloys – Solution pH13 or Higher ²⁾ |

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

2) Published by: Society of Automotive Engineers, Inc. (SAE), 400 Commonwealth Drive, Warrendale, PA 15096-0001

EN 3270:2001 (E)

3 Required characteristics

3.1 Configuration – Dimensions – Mass

According to figure 1 and table 1. Dimensions apply before lubricating or anodizing.

3.2 Surface roughness

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

3.3 Materials (for blanking plug)

According to EN 3311 or EN 3314

3.4 Surface treatments (for blanking plug)

Lubrication: according to EN 2491, on all surfaces

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

Film thickness : 0,005 mm to 0,013 mm

Alternative: Anodizing according to AMS 2488D, type 2

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Dimensions in millimetres

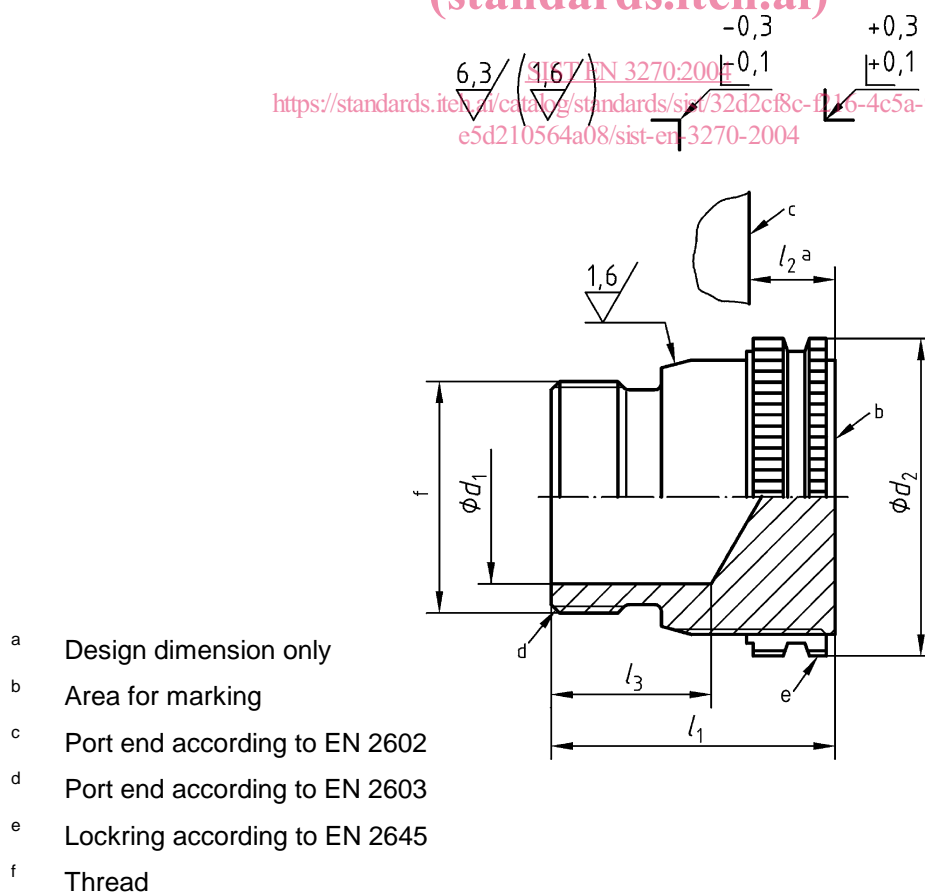


Figure 1

Table 1

Dimensions in millimetres

| Code ^a | Thread ^b | Code ^c | d_1 ^d | d_2 ^e | l_1 | l_3 | l_2 | Mass g/piece | Lockring code ^e |
|-------------------|---------------------|-------------------|--------------------|--------------------|-------|-------|-------|-----------------|-------------------------------|
| | | | Ref | Ref | ± 0,2 | ± 0,4 | Ref | max. | |
| 06 | MJ6×1 | 05 | – | 12,9 | 21,0 | – | 7,5 | 5,01 | 077 |
| 08 | MJ8×1 | 06 | – | 14,7 | 23,5 | – | 9,0 | 8,67 | 098 |
| 10 | MJ10×1 | 08 | – | 17,8 | 26,0 | – | 10,0 | 14,36 | 125 |
| 12 | MJ12×1,25 | 10 | – | 19,5 | 26,5 | – | 10,0 | 18,67 | 136 |
| 14 | MJ14×1,5 | 12 | – | 21,0 | 27,0 | – | 10,0 | 24,30 | 153 |
| 16 | MJ16×1,5 | 14 | 10,7 | 22,6 | 27,5 | 18 | 10,0 | 22,51 | 170 |
| 18 | MJ18×1,5 | 16 | 12,5 | 26,4 | 28,0 | 18 | 10,0 | 29,58 | 192 |
| 20 | MJ20×1,5 | 18 | 14,2 | 28,0 | 30,5 | 19 | 10,0 | 37,73 | 214 |
| 22 | MJ22×1,5 | 20 | 15,9 | 30,2 | 31,0 | 19 | 10,0 | 43,61 | 231 |
| 24 | MJ24×1,5 | 22 | 17,6 | 33,7 | 31,5 | 19 | 10,0 | 54,22 | 253 |
| 27 | MJ27×1,5 | 25 | 20,2 | 37,0 | 33,0 | 19 | 10,0 | 70,70 | 295 |
| 30 | MJ30×1,5 | 28 | 22,8 | 40,7 | 33,5 | 19 | 10,0 | 84,51 | 320 |
| 33 | MJ33×1,5 | 32 | 25,4 | 43,0 | 35,0 | 20 | 10,0 | 100,79 | 350 |

^a Corresponds to the thread diameter^b According to ISO 5855-3^c Corresponds to the pipe nominal outside diameter^d According to EN 2603^e According to EN 2645

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4 Designation

EXAMPLE:

Description block

Identity block

BLANKING PLUG

EN3270 06

Number of this standard _____

Code (see table 1) _____

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 figure 1

6 Technical specification

According to EN 3079, type II