

SLOVENSKI STANDARD

SIST EN 2907:2001

01-januar-2001

Aerospace series - Nuts, bihexagonal, self-locking, in heat resisting steel FE-PA92HT (A 286), silver plated - Classification: 1100 MPa (at ambient temperature) / 650 °C

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Luft- und Raumfahrt - Zwölfkantmuttern, selbstsichernd, aus hochwarmfestem Stahl FE-PA92HT (A286), versilbert - Klasse: 1 100 MPa (bei Raumtemperatur) / 650 °C

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Série aérospatiale - Ecrous bihexagonaux, à freinage interne, en acier résistant à chaud FE-PA92HT (A286), argentés - Classification: 1 100 MPa (à température ambiante) / 650 °C

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Ta slovenski standard je istoveten z: EN 2907:1995

ICS:

49.030.30 Matice Nuts

SIST EN 2907:2001 en

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EUROPEAN STANDARD

EN 2907

NORME EUROPÉENNE

EUROPÄISCHE NORM

September 1995

ICS 49.040.20

Descriptors: aircraft industry, fastener, nut:fastener, self locking nut, steel, heat resistant steel, classification, characteristic, dimension, surface treatment, screw thread, designation

English version

**Aerospace series - Nuts, bihexagonal, self-locking,
in heat resisting steel FE-PA92HT (A286), silver
plated - Classification: 1 100 MPa (at ambient
temperature) / 650 °C**

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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.

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CEN

European Committee for Standardization
Comité Européen de Normalisation
Europäisches Komitee für Normung

Central Secretariat: rue de Stassart, 36 B-1050 Brussels

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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 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of an identical text or by endorsement, at the latest by March 1996, and conflicting national standards shall be withdrawn at the latest by March 1996.

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 self-locking bihexagonal nuts in FE-PA92HT, silver plated, for aerospace applications.

Classification : 1 100 MPa¹⁾ / 650 °C²⁾

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 4095 Fasteners for aerospace construction - Bi-hexagonal wrenching configuration
- ISO 5855-2 Aerospace - MJ threads - Part 2 : Limit dimensions for bolts and nuts
- EN 2399 Heat resisting steel FE-PA92-HT - $R_m \geq 900$ MPa - Bars for forged bolts - $D \leq 25$ mm - Aerospace series³⁾
- EN 2424 Aerospace series - Marking of aerospace products
- EN 2786 Aerospace series - Electrolytic silver plating of fasteners⁴⁾
- EN 3004 Aerospace series - Nuts, self-locking, in heat resisting steel FE-PA92HT (A286) - Classification : 1 100 MPa / 650 °C - Technical specification⁴⁾
- EN 3639 Aerospace series - Heat resisting alloy FE-PA2601 - Softened and cold worked - Wire for forged fasteners - $D \leq 15$ mm - $900 \text{ MPa} \leq R_m \leq 1100 \text{ MPa}$ ⁴⁾
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3 Required characteristics

3.1 Configuration - Dimensions - Tolerances - Masses

See figure 1 and table 1. Dimensions and tolerances are in millimetres. They apply after silver plating.

3.2 Materials

EN 2399 or EN 3639

3.3 Surface treatment

EN 2786

Thickness :

- external surfaces : 5 µm to 15 µm ;
- thread \geq MJ6 : 5 µm min. on thread flanks ;
- thread MJ5 : shall show complete coverage, without thickness requirement.

1) Corresponds to the minimum tensile stress which the nut is able to withstand at ambient temperature without breaking or cracking when tested with a bolt of a higher strength class.

2) Maximum test temperature of the parts

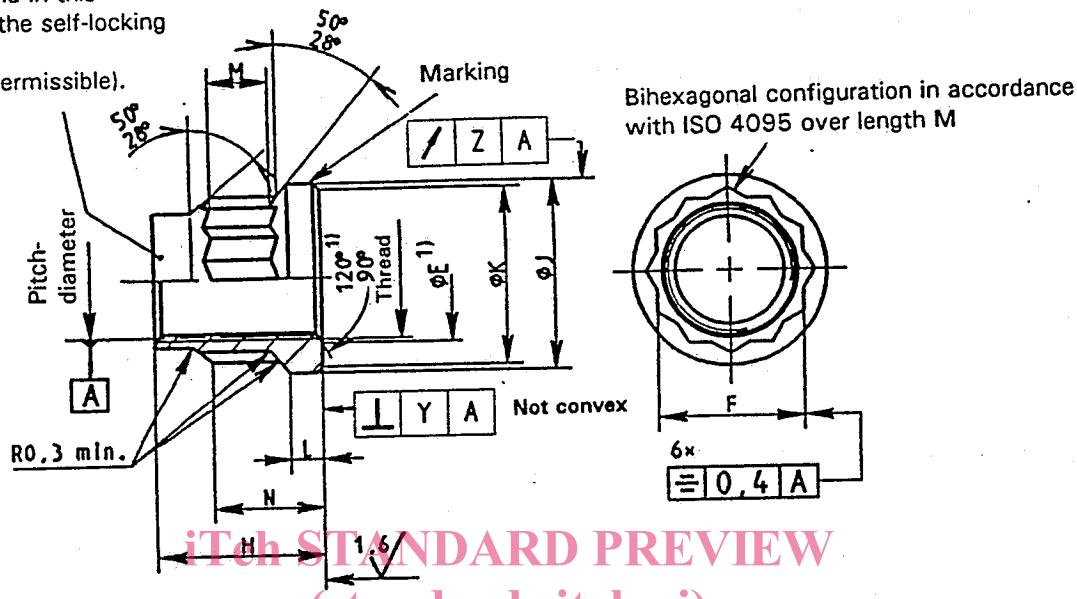
3) Published as AECMA Standard at the date of publication of this standard

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

6,3 (1,6) Values apply before silver plating.
Thread surface will be as achieved by normal methods of manufacture.

Remove sharp edges 0,1 to 0,4

Form out-of-round in this area to achieve the self-locking requirement (tooling marks permissible).



1) All forms of entry (radius or chamfer) are permissible within these limiting dimensions.

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Details of form not stated are left to the manufacturer's discretion.

Figure 1

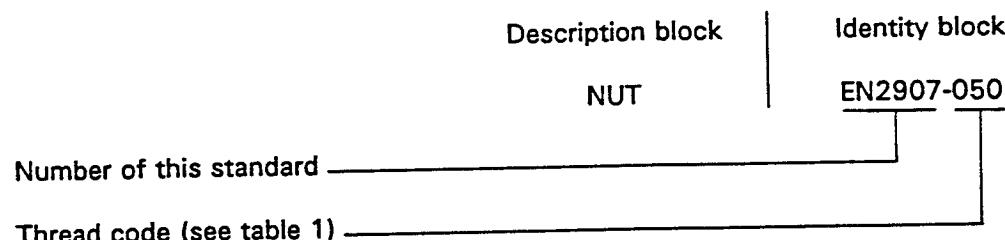
Table 1

Thread ¹⁾		<i>E</i>		<i>F</i>	<i>H</i>	<i>J</i>	<i>K</i>	<i>L</i>	<i>M</i>	<i>N</i>	<i>Y</i>	<i>Z</i>	Mass kg/1 000 parts ≈
Code	Designation	max.	min.		max.	max.	min.	min.	min.	max.			
050	MJ5x0,8-4H6H	5,8	5,2	7	7	9,1	8,3	1,2	2	4,9	0,1	0,2	1,63
060	MJ6x1-4H5H	7,1	6,3	8	8,1	10,6	9,8		2,3	5,5			2,33
070	MJ7x1-4H5H	8,1	7,3	9	9,1	12,1	11,3		2,6	6,1			3,19
080	MJ8x1-4H5H	9,1	8,3	10	10,4	13,6	12,8		2,8	6,9			4,34
100	MJ10x1,25-4H5H	11,1	10,3	12	13	16,8	15,8		3,1	8,8	0,13	0,3	7,69
120	MJ12x1,25-4H5H	13,1	12,3	14	15	19,9	18,8		1,4	3,5	10,1		14,58
140	MJ14x1,5-4H5H	15,2	14,4	17	17,5	23	21,9		1,7	4	12,6	0,15	19,79

1) In accordance with ISO 5855-2. In the self-locking zone, the tolerances apply before forming out-of-round.

4 Designation

EXAMPLE :



NOTE : If necessary, the code 19005 shall be placed between the description block and the identity block.

5 Marking

EN 2424, style A, as indicated on figure 1.

6 Technical specification

EN 3004

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