
Aerospace series - Bolts, T-head, relieved shank, long thread, in heat resisting steel FE-PA92HT (A286), silver plated - Classification: 900 MPa (at ambient temperature)/650 °C

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Luft- und Raumfahrt - T-Kopfschrauben, Dünnschaft, langes Gewinde, aus hochwarmfestem Stahl FE-PA92HT (A286), versilbert - Klasse: 900 MPa (bei Raumtemperatur)/650°C

Série aérospatiale - Vis à tête en T, fut dégagé, filetage long, en acier résistant à chaud FE-PA92HT (A286), argentées - Classification: 900 MPa (à température ambiante)/650°C

Ta slovenski standard je istoveten z: EN 2932:1996

ICS:

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

SIST EN 2932:2001

en

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EUROPEAN STANDARD

EN 2932

NORME EUROPÉENNE

EUROPÄISCHE NORM

March 1996

ICS 49.040.20

Descriptors: aircraft industry, screw, heat resistant steel, silver coating, classification, surface treatment, dimension, designation

English version

**Aerospace series - Bolts, T-head, relieved shank,
long thread, in heat resisting steel FE-PA92HT
(A286), silver plated - Classification : 900 MPa (at
ambient temperature) / 650 °C**

Série aéronautique - Vis à tête en T, fût
dégagé, filetage long, en acier résistant à
chaud FE-PA92HT (A286), argentées
Classification : 900 MPa (à température
ambiante) / 650 °C

Luft- und Raumfahrt - T-Kopfschrauben,
Dünnschaft, langes Gewinde, aus hochwarmfestem
Stahl FE-PA92HT (A286), versilbert - Klasse :
900 MPa (bei Raumtemperatur) / 650 °C

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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

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of an identical text or by endorsement, at the latest by September 1996, and conflicting national standards shall be withdrawn at the latest by September 1996.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of 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 and United Kingdom

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1 Scope

This standard specifies the characteristics of T-headed bolts with relieved shank, long thread, in FE-PA92HT, silver plated, for aerospace applications.

Classification : 900 MPa ¹⁾ / 650 °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 3353 Aerospace - Rolled threads for bolts - Lead and runout requirements
- 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 series ³⁾
- EN 2424 Aerospace series - Marking of aerospace products
- EN 2576 Aerospace series - Bolts in heat resisting steel FE-PA92HT (A286) - Classification : 900 MPa / 650 °C - Technical specification ⁴⁾
- EN 2786 Aerospace series - (Electrolytic silver plating of fasteners ⁴⁾)
- EN 3639 Aerospace series - Heat resisting alloy FE-PA2601 - Softened and cold worked - Wire for forged fasteners - $D \leq 15$ mm - 900 MPa $\leq R_m \leq 1\ 100$ MPa ⁴⁾
- <https://standards.iteh.ai/catalog/standards/sist/0ff3b21b-fd51-44ac-a5f9-2d0777104c9f/sist-en-2932-2001>

3 Required characteristics

3.1 Configuration - Dimensions - Tolerances - Masses

See figure 1 and tables 1 and 2. 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 :

- thread : 3 μ m to 6 μ m, shall be measured at the pitch diameter ;
- other areas may show complete coverage, without thickness requirement.

1) Minimum tensile strength of the material at ambient temperature

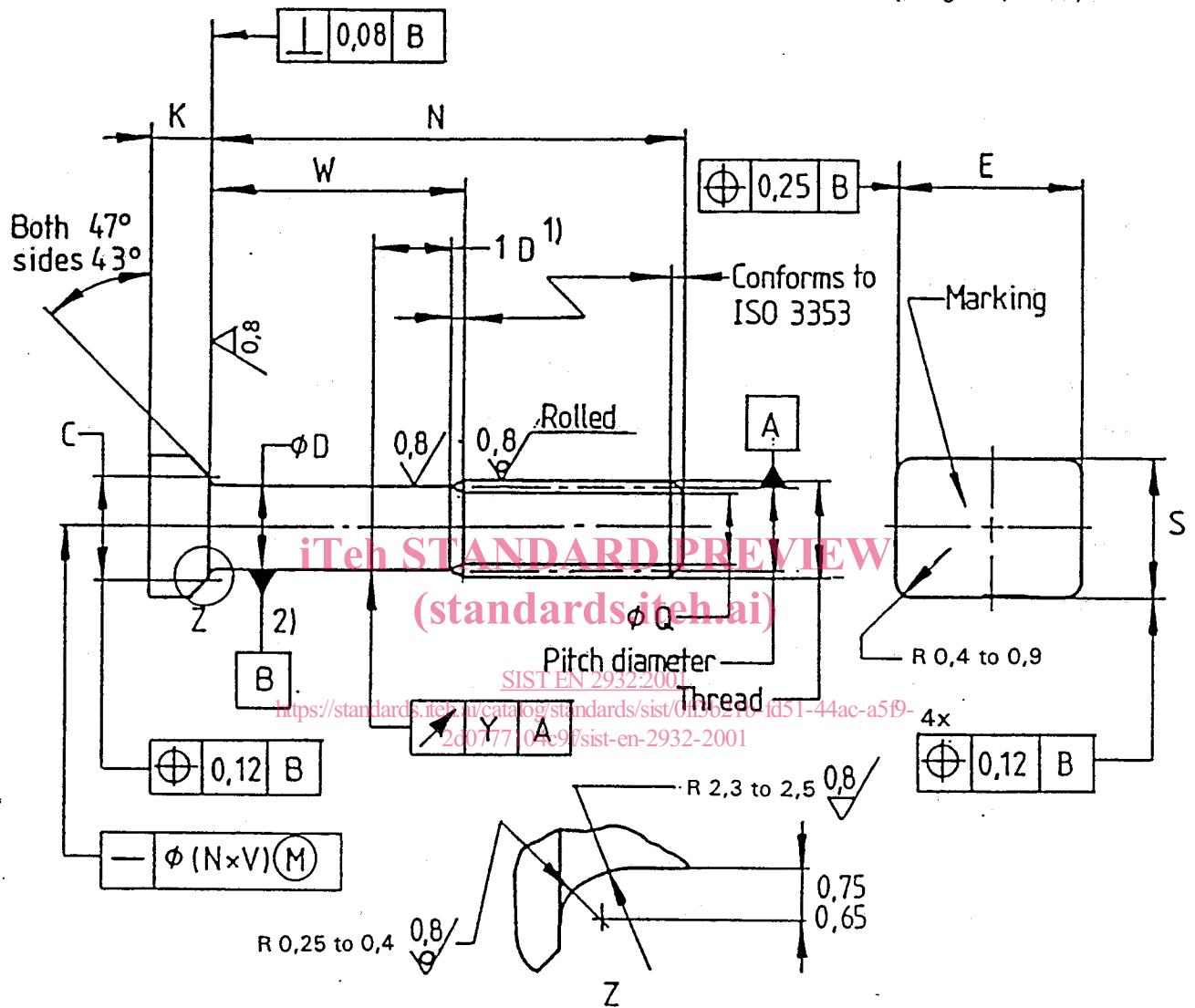
2) Maximum test temperature of the parts

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

$3,2 / \sqrt{\quad}$ ($0,8 / \sqrt{\quad}$ $0,8 / \sqrt{\quad}$ $0,8 / \sqrt{\quad}$ $0,8 / \sqrt{\quad}$ $0,8 / \sqrt{\quad}$ ^{Rolled}) Values apply before silver plating.

Remove sharp edges 0,1 to 0,4



- 1) When the length of the shank is less than one times the nominal value of the shank diameter D , the run-out is measured at a distance equal to half the actual shank length.
- 2) For bolts having a shank length less than one times the nominal value of the shank diameter D , and for those threaded to head, the pitch diameter axis shall be used as the datum.

Figure 1

Table 1

Code	Thread 1) Designation	C $\pm 0,1$	D $\pm 0,13$	E $+ 0,5$ 0	K $+ 0,5$ 0	Q $\pm 0,5$	S $+ 0,3$ 0	V	Y
050	MJ5x0,8-4h6h	6,2	4,48	11,1	2,9	3,4	8,1	0,003	0,12
060	MJ6x1-4h6h	7,2	5,35	12	3,4	4,2	9,2		
070	MJ7x1-4h6h	8,3	6,35	13,4	4	5,2	10,2		0,15
080	MJ8x1-4h6h	9,3	7,35	14	4,5	6,2	11,2		
100	MJ10x1,25-4h6h	11,1	9,19	16,5	5,3	7,9	13	0,0025	

1) In accordance with ISO 5855-2

Table 2

Length code	N ± 0,3	Thread code														
		050			060			070			080			100		
		W max.	W min.	Mass 1)	W max.	W min.	Mass 1)	W max.	W min.	Mass 1)	W max.	W min.	Mass 1)	W max.	W min.	Mass 1)
014	14			4,26												
016	16			4,51												
018	18			4,76												
020	20	4	2,5	5,01	4	2,5										
022	22	6	4,5	5,26												
024	24	8	6,5	5,51	6	4,5										
026	26	10	8,5	5,76	8	6,5	8,15	6	4,5	11,20						
028	28	12	10,5	6,01	10	8,5	8,51	8	6,5	11,70						23,74
030	30	14	12,5	6,26	12	10,5	8,86	10	8,5	12,21						24,78
032	32	16	14,5	6,51	14	12,5	9,22	12	10,5	12,71						25,82
034	34	18	16,5	6,76	16	14,5	9,58	14	12,5	13,21						26,86
036	36	20	18,5	7,01	18	16,5	9,93	16	14,5	13,71						27,91
038	38	22	20,5	7,26	20	18,5	10,29	18	16,5	14,21						28,95
040	40	24	22,5	7,51	22	20,5	10,64	20	18,5	14,71						30,00
042	42	26	24,5	7,75	24	22,5	11,00	22	20,5	15,22						31,05
044	44	28	26,5	8,00	26	24,5	11,36	24	22,5	15,72						32,10
046	46	30	28,5	8,25	28	26,5	11,71	26	24,5	16,22						33,15
048	48	32	30,5	8,50	30	28,5	12,07	28	26,5	16,72						34,20
050	50	34	32,5	8,75	32	30,5	12,42	30	28,5	17,22						35,25
052	52	36	34,5	9,00	34	32,5	12,78	32	30,5	17,72						36,29
054	54	38	36,5	9,25	36	34,5	13,14	34	32,5	18,23						37,34
056	56	40	38,5	9,50	38	36,5	13,49	36	34,5	18,73						38,39
058	58	42	40,5	9,75	40	38,5	13,85	38	36,5	19,23						39,44
060	60	44	42,5	10,00	42	40,5	14,21	40	38,5	19,73						40,49
062	62	46	44,5	10,25	44	42,5	14,56	42	40,5	20,23						41,54
064	64	48	46,5	10,50	46	44,5	14,92	44	42,5	20,73						42,59
066	66	50	48,5	10,75	48	46,5	15,27	46	44,5	21,24						43,63
068	68	52	50,5	11,00	50	48,5	15,63	48	46,5	21,74						44,68
																45,73

(continued)

Table 2 (concluded)

Length code	N ± 0,3	Thread code																			
		050				060				070				080				100			
		W		Mass ¹⁾		W		Mass ¹⁾		W		Mass ¹⁾		W		Mass ¹⁾		W		Mass ¹⁾	
max.	min.	max.	min.	max.	min.	max.	min.	max.	min.	max.	min.	max.	min.	max.	min.	max.	min.	max.	min.	max.	
070	70	54	52,5	11,25	15,99	50	48,5	22,24	22,24	48	46,5	29,90	29,90	44	42,5	46,78	46,78				
072	72				16,34	52	50,5	22,74	22,74	50	48,5	30,57	30,57	46	44,5	47,83	47,83				
074	74				16,70	54	52,5	23,24	23,24	52	50,5	31,25	31,25	48	46,5	48,88	48,88				
076	76				17,05	56	54,5	23,75	23,75	54	52,5	31,92	31,92	50	48,5	49,93	49,93				
078	78				17,41	58	56,5	24,25	24,25	56	54,5	32,59	32,59	52	50,5	50,97	50,97				
080	80				17,77	60	58,5	24,75	24,75	58	56,5	33,26	33,26	54	52,5	52,02	52,02				
082	82				18,12	62	60,5	25,25	25,25	60	58,5	33,93	33,93	56	54,5	53,07	53,07				
084	84				18,48	64	62,5	25,75	25,75	62	60,5	34,61	34,61	58	56,5	54,12	54,12				
086	86					66	64,5	26,25	26,25	64	62,5	35,28	35,28	60	58,5	55,17	55,17				
088	88					68	66,5	26,76	26,76	66	64,5	35,95	35,95	62	60,5	56,22	56,22				
090	90					70	68,5	27,26	27,26	68	66,5	36,62	36,62	64	62,5	57,27	57,27				
092	92					72	70,5	27,76	27,76	70	68,5	37,30	37,30	66	64,5	58,31	58,31				
094	94					74	72,5	28,26	28,26	72	70,5	37,97	37,97	68	66,5	59,36	59,36				
096	96					76	74,5	28,76	28,76	74	72,5	38,64	38,64	70	68,5	60,41	60,41				
098	98					78	76,5	29,26	29,26	76	74,5	39,31	39,31	72	70,5	61,46	61,46				
100	100									78	76,5	39,98	39,98	74	72,5	62,51	62,51				
104	104									82	80,5	41,33	41,33	78	76,5	64,60	64,60				
108	108									86	84,5	42,67	42,67	82	80,5	66,70	66,70				
112	112									90	88,5	44,02	44,02	86	84,5	68,80	68,80				
116	116													90	88,5	70,90	70,90				
120	120													94	92,5	72,99	72,99				
124	124													98	96,5	75,09	75,09				
128	128													102	100,5	77,19	77,19				
132	132													106	104,5	79,28	79,28				
136	136													110	108,5	81,38	81,38				
140	140													114	112,5	83,48	83,48				
144	144													118	116,5	85,58	85,58				

1) Mass ≈ quoted in kg/1 000 parts