
Aerospace series - Bolts, T-head, relieved shank, long thread, in heat resisting nickel base alloy NI-P100HT (Inconel 718) - Classification: 1 275 MPa (at ambient temperature)/650 °C

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Luft- und Raumfahrt - T-Kopfschrauben, Dünnschaft, langes Gewinde, aus hochwarmfester Nickelbasislegierung NI-P100HT (Inconel 718) - Klasse: 1 275 MPa (bei Raumtemperatur)/650°C

Série aérospatiale - Vis à tete en T, fut dégagé, filetage long, en alliage résistant a chaud a base de nickel NI-P100HT (Inconel 718) - Classification: 1275 MPa (a température ambiante)/650°C

Ta slovenski standard je istoveten z: EN 2933:1996

ICS:

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

SIST EN 2933:2001

en

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EUROPEAN STANDARD

EN 2933

NORME EUROPÉENNE

EUROPÄISCHE NORM

March 1996

ICS 49.040.20

Descriptors: aircraft industry, screw, nickel alloy, heat resistant material, classification, dimension, designation

English version

**Aerospace series - Bolts, T-head, relieved shank,
long thread, in heat resisting nickel base alloy
NI-P100HT (Inconel 718) - Classification : 1 275
MPa (at ambient temperature) / 650 °C**

Série aérospatiale - Vis à tête en T, fût
dégagé, filetage long, en alliage résistant à
chaud à base de nickel NI-P100HT (Inconel 718)
- Classification : 1 275 MPa (à température
ambiante) / 650 °C

Luft- und Raumfahrt - T-Kopfschrauben,
Dünnschaft, langes Gewinde, aus hochwarmfester
Nickelbasislegierung NI-P100HT (Inconel 718) -
Klasse : 1 275 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of an identical text or by endorsement, at the latest by September 1996, and conflicting national standards shall be withdrawn at the latest by September 1996.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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.....T318
PRESENTED TO CEN/TC 101



1 Scope

This standard specifies the characteristics of T-headed bolts with relieved shank, long thread, in NI-P100HT, for aerospace applications.

Classification : 1 275 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 2424 Aerospace series - Marking of aerospace products
- EN 2583 Aerospace series - Bolts in heat resisting nickel base alloy NI-P100HT (Inco 718) - Classification : 1 275 MPa / 650 °C - Technical specification ³⁾
- EN 2952 Aerospace series - Heat resisting alloy NI-PH2601 - Solution treated and cold worked - Bar for forged fasteners - $D \leq 50$ mm - $1\ 270$ MPa $\leq R_m \leq 1\ 550$ MPa ³⁾
- EN 3219 Aerospace series - Heat resisting nickel base alloy (NI-P100HT) - Cold worked and softened - Bar and wire for continuous forging or extrusion for fasteners - $3 \leq D \leq 30$ mm ³⁾

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3 Required characteristics

3.1 Configuration - Dimensions - Tolerances - Masses

See figure 1 and tables 1 and 2. Dimensions and tolerances are in millimetres.

3.2 Materials

EN 2952 or EN 3219

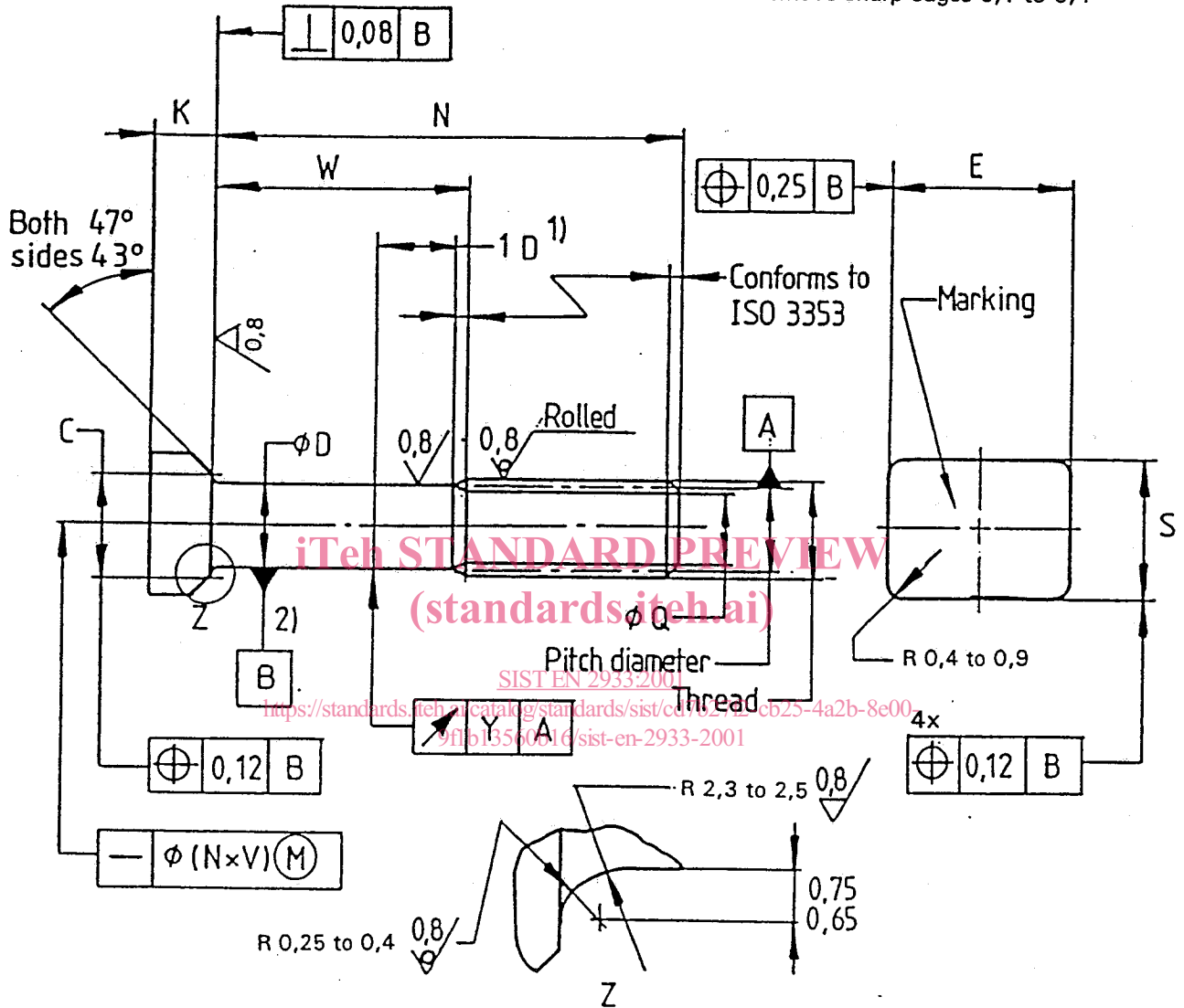
1) Minimum tensile strength of the material at ambient temperature

2) Maximum test temperature of the parts

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

3,2 / (0,8 / 0,8 / 0,8 / 0,8 / 0,8 / Rolled)

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)	C	D	E	K	Q	S	V	Y
	Designation	$\pm 0,1$	$\pm 0,13$	$+ 0,5$ 0	$+ 0,5$ 0	$\pm 0,5$	$+ 0,3$ 0		
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		
080	MJ8x1-4h6h	9,3	7,35	14	4,5	6,2	11,2	0,0025	0,15
100	MJ10x1,25-4h6h	11,1	9,19	16,5	5,3	7,9	13		

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) max.	Mass 1) min.	W max.	W min.	Mass 1) max.	Mass 1) min.	W max.	W min.	Mass 1) max.	Mass 1) min.	W max.	W min.	Mass 1) max.	Mass 1) min.	W max.	W min.	Mass 1) max.	Mass 1) min.		
014	14																						
016	16			4,42																			
018	18			4,68		6,61																	
020	20	4	2,5	4,94		6,98																	
022	22			5,20		7,35																	
024	24	6	4,5	5,46		7,72																	
026	26	8	6,5	5,72		8,09																	
028	28	10	8,5	5,98		8,46																	
030	30	12	10,5	6,23		8,83																	
032	32	14	12,5	6,49		9,20																	
034	34	16	14,5	6,75		9,57																	
036	36	18	16,5	7,01		9,94																	
038	38	20	18,5	7,27		10,31																	
040	40	22	20,5	7,53		10,68																	
042	42	24	22,5	7,79		11,05																	
044	44	26	24,5	8,05		11,42																	
046	46	28	26,5	8,31		11,79																	
048	48	30	28,5	8,57		12,16																	
050	50	32	30,5	8,83		12,53																	
052	52	34	32,5	9,09		12,90																	
054	54	36	34,5	9,34		13,26																	
056	56	38	36,5	9,60		13,63																	
058	58	40	38,5	9,86		14,00																	
060	60	42	40,5	10,12		14,37																	
062	62	44	42,5	10,38		14,74																	
064	64	46	44,5	10,64		15,11																	
066	66	48	46,5	10,90		15,48																	
068	68	50	48,5	11,16		15,85																	
		52	50,5	11,42		16,22																	
		54	52,5	11,68		16,59																	
		56	54,5	11,94		16,96																	
		58	56,5	12,20		17,33																	
		60	58,5	12,46		17,70																	
		62	60,5	12,72		18,07																	
		64	62,5	12,98		18,44																	
		66	64,5	13,24		18,81																	
		68	66,5	13,50		19,18																	

(continued)

Table 2 (concluded)

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)
070	70	54	52,5	11,68	52	50,5	16,59	48,5	23,08	48	46,5	31,03	44	42,5	48,55	
072	72				54	52,5	16,96	52	50,5	23,60	50	48,5	31,73	46	44,4	49,64
074	74				56	54,5	17,33	54	52,5	24,12	52	50,5	32,43	48	46,5	50,73
076	76				58	56,5	17,70	56	54,5	24,64	54	52,5	33,13	50	48,5	51,82
078	78				60	58,5	18,07	58	56,5	25,17	56	54,5	33,82	52	50,5	52,90
080	80				62	60,5	18,44	60	58,5	25,69	58	56,5	34,52	54	52,5	53,99
082	82				64	62,5	18,81	62	60,5	26,21	60	58,5	35,22	56	54,5	55,08
084	84				66	64,5	19,18	64	62,5	26,73	62	60,5	35,92	58	56,5	56,17
086	86							66	64,5	27,25	64	62,5	36,62	60	58,5	57,26
088	88							68	66,5	27,77	66	64,5	37,31	62	60,5	58,35
090	90							70	68,5	28,29	68	66,5	38,01	64	62,5	59,43
092	92							72	70,5	28,81	70	68,5	38,71	66	64,5	60,52
094	94							74	72,5	29,33	72	70,5	39,41	68	66,5	61,61
096	96							76	74,5	29,85	74	72,5	40,10	70	68,5	62,70
098	98							78	76,5	30,37	76	74,5	40,80	72	70,5	63,79
100	100										78	76,5	41,50	74	72,5	64,88
104	104										82	80,5	42,89	78	76,5	67,05
108	108										86	84,5	44,29	82	80,5	69,23
112	112										90	88,5	45,68	86	84,5	71,41
116	116													90	88,5	73,58
120	120													94	92,5	75,76
124	124													98	96,5	77,93
128	128													102	110,5	80,11
132	132													106	104,5	82,29
136	136													110	108,5	84,46
140	140													114	112,5	86,64
144	144													118	116,2	88,82

1) Mass ≈ quoted in kg/1 000 parts