

**SLOVENSKI STANDARD
SIST EN 3008:2001****01-januar-2001**

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

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

Série aérospatiale - Vis à tête hexagonale, fut 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

Ta slovenski standard je istoveten z: EN 3008:1998

ICS:

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

SIST EN 3008:2001**en**

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SIST EN 3008:2001

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EUROPEAN STANDARD

EN 3008

NORME EUROPÉENNE

EUROPÄISCHE NORM

May 1998

ICS 49.030.20

Descriptors: aircraft industry, screw, hexagonal head screw, nickel alloy, heat resistant material, characteristic, screw thread, code, dimension, designation, marking

English version

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This European Standard was approved by CEN on 23 February 1998.

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 Central Secretariat 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 Central Secretariat 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.



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 received the approval of the National Associations and the Official Services of the member countries of AECMA, prior to its presentation to CEN.

IT IS A STANDARD PREVIEW

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 November 1998, and conflicting national standards shall be withdrawn at the latest by November 1998.

SIST EN 3008:2001

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 of hexagon headed bolts with relieved shank and 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
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 $\leq R_m \leq 1\ 470$ 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⁾

3 Required characteristics

3.1 Configuration - Dimensions - Tolerances - Masses

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

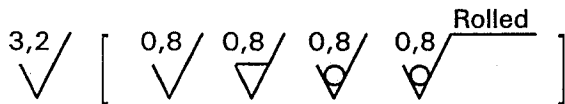
3.2 Materials

EN 2952 or EN 3219

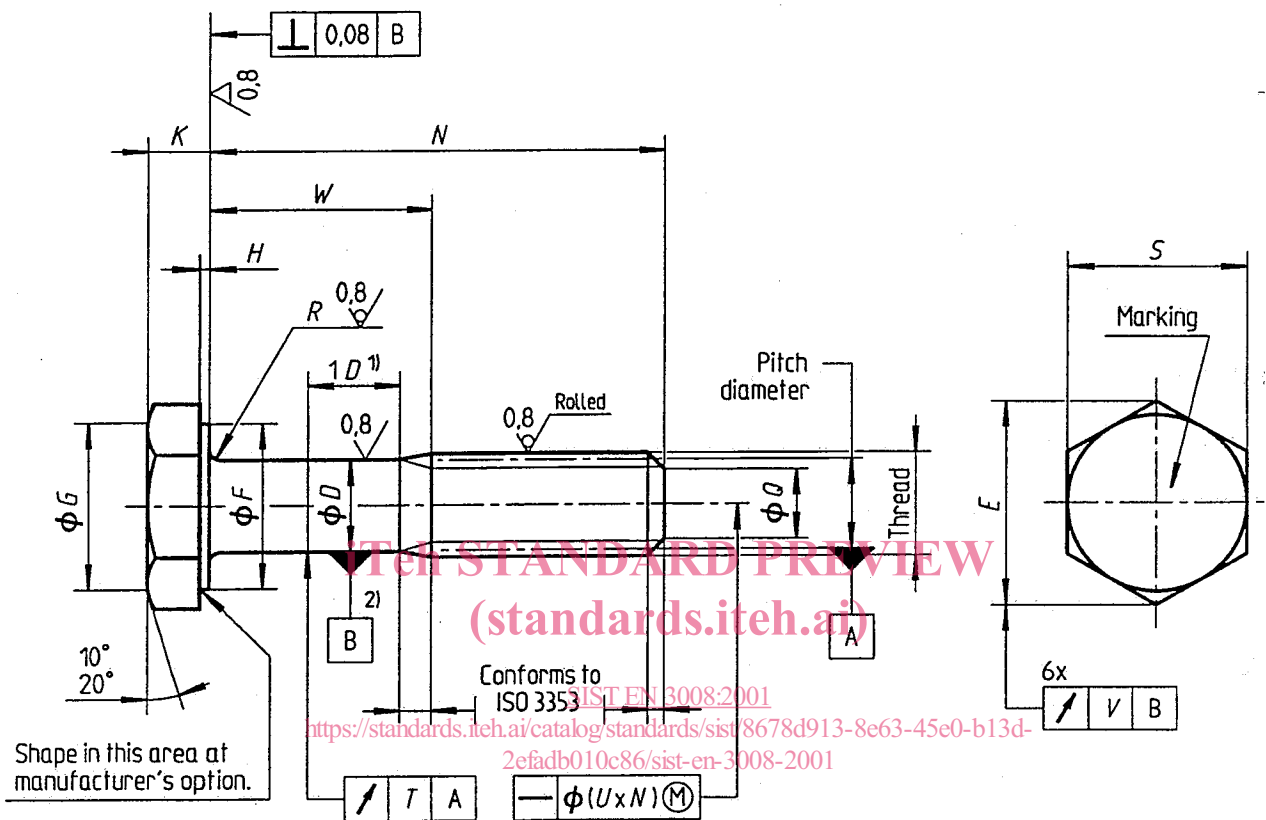
1) Minimum tensile strength of the material at ambient temperature

2) Maximum test temperature of the parts

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



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 runout 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	D $\pm 0,13$	E min.	F min.	G min.	H 0 - 0,3	K 0 - 0,3	Q $\pm 0,5$	R		S h13	T	U	V
										max.	min.				
050	MJ5x0,8-4h6h		4,48	9,8	8,3	8,4		3	3,4	0,5	0,3	9	0,12		0,25
060	MJ6x1-4h6h		5,35	12	10,2	10,3	0,5	3,5	4,2			11		0,003	0,3
070	MJ7x1-4h6h		6,35	13,2	11,2	11,3		4	5,2	0,7	0,5	12			0,35
080	MJ8x1-4h6h		7,35	15,5	13,2	13,3		4,5	6,2			14	0,15		0,4
100	MJ10x1,25-4h6h		9,19	18,9	16	16,3	0,6	5	7,9	0,8		17		0,0025	0,5
120	MJ12x1,25-4h6h		11,19	21,1	18	18,3		6	9,8	0,9	0,6	19	0,18		0,6

1) In accordance with ISO 5855-2

Table 2

Length code	N ± 0,3	Thread code																			
		050			060			070			080			100			120				
		W max.	W min.	Mass 1) min.	W max.	W min.	Mass 1) min.	W max.	W min.	Mass 1) min.	W max.	W min.	Mass 1) min.	W max.	W min.	Mass 1) min.	W max.	W min.	Mass 1) min.		
008	8																				
010	10			2,76																	
012	12			3,02		4,86															
014	14	2,1	1,7	3,28		5,23															
016	16			3,54	2,2	5,60															25,66
018	18			3,80	2,7	5,96	2,2	2,2													27,14
020	20			4,06		6,33															28,61
022	22	4	2,5	4,32		6,70															30,09
024	24	6	4,5	4,58	4	7,07															31,56
026	26	8	6,5	4,84	6	7,44	4	2,5	10,34												33,04
028	28	10	8,5	5,10	8	7,81	6	4,5	10,86	4	2,5	15,33									34,51
030	30	12	10,5	5,35	10	8,18	8	6,5	11,38	6	4,5	16,03									35,98
032	32	14	12,5	5,61	12	8,55	10	8,5	11,90	8	6,5	16,73									37,46
034	34	16	14,5	5,87	14	8,92	12	10,5	12,42	10	8,5	17,43									38,93
036	36	18	16,5	6,13	16	9,29	14	12,5	12,94	12	10,5	18,12									40,4
038	38	20	18,5	6,39	18	9,66	16	14,5	13,46	14	12,5	18,82									42,1
040	40	22	20,5	6,65	20	10,03	18	16,5	13,98	16	14,5	19,52									43,7
042	42	24	22,5	6,91	22	10,40	20	18,5	14,51	18	16,5	20,22									45,4
044	44	26	24,5	7,17	24	10,77	22	20,5	15,03	20	18,5	20,91									47,0
046	46	28	26,5	7,43	26	11,14	24	22,5	15,55	22	20,5	21,61									48,7
048	48	30	28,5	7,69	28	11,51	26	24,5	16,07	24	22,5	22,31									50,3
050	50	32	30,5	7,95	30	11,88	28	26,5	16,59	26	24,5	23,01									52,0
052	52	34	32,5	8,21	32	12,25	30	28,5	17,11	28	26,5	23,71									53,6
054	54	36	34,5	8,46	34	12,62	32	30,5	17,63	30	28,5	24,40									55,3
056	56	38	36,5	8,72	36	12,99	34	32,5	18,15	32	30,5	25,10									56,9
058	58	40	38,5	8,98	38	13,36	36	34,5	18,67	34	32,5	25,80									58,6
060	60	42	40,5	9,24	40	13,73	38	36,5	19,19	36	34,5	26,50									60,3
062	62	44	42,5	9,50	42	14,10	40	38,5	19,71	38	36,5	27,19									61,9
064	64	46	44,5	9,76	44	13,47	42	40,5	20,23	40	38,5	27,89									63,6
066	66	48	46,5	10,02	46	14,84	44	42,5	20,75	42	40,5	28,59									65,2
068	68	50	48,5	10,28	48	15,21	46	44,5	21,27	44	42,5	29,29									66,9
068	68	52	50,5	10,54	50	15,57	48	46,5	21,80	46	44,5	29,98									68,5

(continued)

Table 2 (concluded)

Length code	N ± 0,3	Thread code																	
		050			060			070			080			100			120		
		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⁾	W max.	W min.	Mass ¹⁾
070	70	54	52,5	10,80	52	50,5	15,94	48,5	22,32	30,68	48	46,5	30,68	44	42,5	48,35	40	38,5	70,2
072	72				54	52,5	16,31	50,5	22,84	31,38	50	48,5	31,38	46	44,5	49,44	42	40,5	71,8
074	74				56	54,5	16,68	52,5	23,26	32,08	52	50,5	32,08	48	46,5	50,53	44	42,5	73,5
076	76				58	56,5	17,05	54,5	23,88	32,77	54	52,5	32,77	50	48,5	51,62	46	44,5	75,2
078	78				60	58,5	17,42	56,5	24,40	33,47	56	54,5	33,47	52	50,5	52,71	48	46,5	76,8
080	80				62	60,5	17,79	58,5	24,92	34,17	58	56,5	34,17	54	52,5	53,79	50	48,5	78,5
082	82				64	62,5	18,16	60,5	25,44	34,87	60	58,5	34,87	56	54,5	54,88	52	50,5	80,1
084	84				66	64,5	18,53	62,5	25,96	35,56	62	60,5	35,56	58	56,5	55,97	54	52,5	81,8
086	86							66	26,48	36,26	64	62,5	36,26	60	58,5	57,06	56	54,5	83,4
088	88							68	27,00	36,96	66	64,5	36,96	62	60,5	58,15	58	56,5	85,1
090	90							70	27,52	37,66	68	66,5	37,66	64	62,5	59,23	60	58,5	86,7
092	92							72	28,04	38,36	70	68,5	38,36	66	64,5	60,32	62	60,5	88,4
094	94							74	28,56	39,05	72	70,5	39,05	68	66,5	61,41	64	62,5	90,0
096	96							76	29,09	39,75	74	72,5	39,75	70	68,5	62,50	66	64,5	91,7
098	98							78	29,61	40,45	76	74,5	40,45	72	70,5	63,59	68	66,5	93,4
100	100									41,15	78	76,5	41,15	74	72,5	64,68	70	68,5	95,0
104	104									42,54	82	80,5	42,54	78	76,5	66,85	74	72,5	98,3
108	108									43,94	86	84,5	43,94	82	80,5	69,03	78	76,5	101,6
112	112									45,33	90	88,5	45,33	86	84,5	71,21	82	80,5	104,9
116	116												90	88,5	73,38	86	84,5	108,3	
120	120												94	92,5	75,56	90	88,5	111,6	
124	124												98	96,5	77,74	94	92,5	114,9	
128	128												102	100,5	79,91	98	96,5	118,2	
132	132												106	104,5	82,09	102	100,5	121,4	
136	136												110	108,5	84,26	106	104,5	124,7	
140	140												114	112,5	86,44	110	108,5	128,1	
144	144															114	112,5	131,5	
148	148															118	116,5	134,7	
152	152															122	120,5	138,0	
156	156															126	124,5	141,4	
160	160															130	128,5	144,7	
164	164															134	132,5	148,0	
168	168															138	136,5	151,2	

1) Mass ≈ quoted in kg/1 000 parts