



**SLOVENSKI STANDARD**  
**SIST EN 3064:2001**  
**01-januar-2001**

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**Aerospace series - Shank nuts, self-locking, serrated - Installation procedure**

Aerospace series - Shank nuts, self-locking, serrated - Installation procedure

Luft- und Raumfahrt - Einnietmuttern, selbstsichernd, verzahnt - Einbauverfahren

Série aérospatiale - Ecrous à sertir, dentelés, à freinage interne - Procédure de montage

**Ta slovenski standard je istoveten z: EN 3064:1996**

[SIST EN 3064:2001](https://standards.iteh.ai/catalog/standards/sist/08d4840a-641a-4789-b9b8-7e7dd2808609/sist-en-3064-2001)

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**ICS:**

49.030.30      Matice                                      Nuts

**SIST EN 3064:2001**                                      **en**

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EUROPEAN STANDARD

EN 3064

NORME EUROPÉENNE

EUROPÄISCHE NORM

July 1996

ICS 49.040.207

Descriptors: aircraft industry, fastener, nut : fastener, self-locking nut, crimping : mechanics, assembling, inspection

English version

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This European Standard was approved by CEN on 1994-12-28. 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.

The European Standards exist 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, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

## CEN

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

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

**Foreword**

**iTeh STANDARD PREVIEW**

This European Standard has been prepared by the European Association of Aerospace Manufacturers (AECMA).

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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 January 1997, and conflicting national standards shall be withdrawn at the latest by January 1997.

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 the United Kingdom.



## 1 Scope

This standard specifies the conditions of installation (tools, swaging and control) of self-locking serrated shank nuts defined by EN standards. It shall be applicable whenever referenced.

## 2 Tools

Configuration see figure 1 and table 1. Dimensions and tolerances are in millimetres.

## 3 Swaging of the nuts

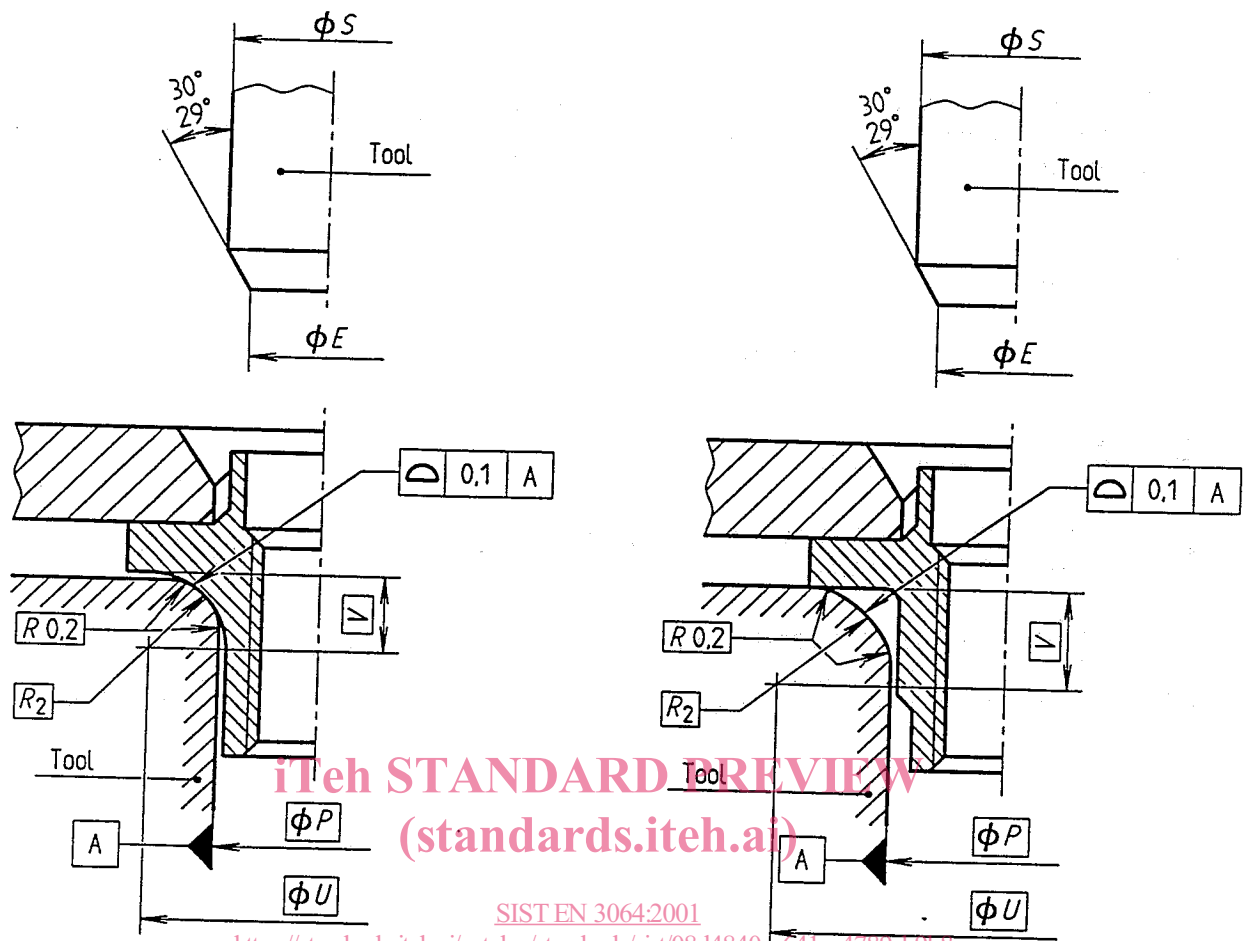
It shall be obtained by flaring the end of the serrated shank of the nut with tools (conical tapered punch and support).

The load for the swaging operation is approx. 15 000 N. The punch shall be aligned with the axis of the nut in order to prevent creating overstresses or cracks on the flared shank. During this operation the punch shall not rotate.

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Figure 1

Table 1

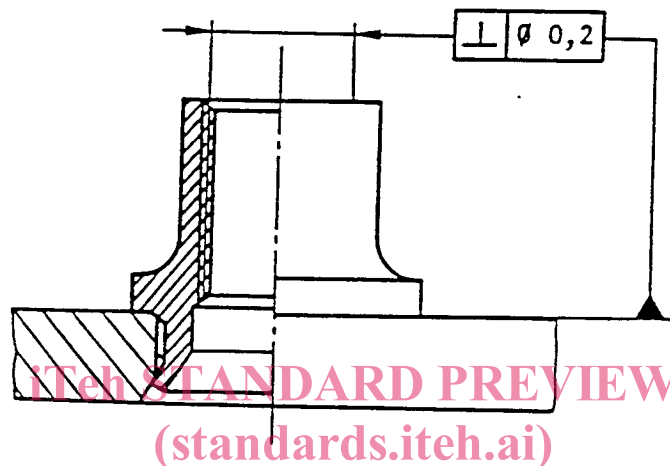
Thread code of the nut	$E$ max.	$P$ $\pm 0,1$	$R_2$	$S$ min.	$U$	$V$
050	3,8	8	2	9,8	10,5	1,25
060		9			11,5	
070	7,1	10	2,2	11,1	12,7	1,35
080		11,2			13,6	1,2

#### 4 Control of the swaging

The swaged area shall show no cracks or corrugations.

The bearing surface of the nut shall bear completely on the base.

The perpendicularity of the assembled nut shall be in accordance with figure 2.



**Figure 2**

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In the case of silver plated nuts, the flaking of the coating in the swaging area is acceptable. Meanwhile any loose flakes are to be removed.