



SLOVENSKI STANDARD

SIST EN 3236:2001

01-januar-2001

Aerospace series - Inserts, thin wall, self-locking, short, in heat resisting nickel base alloy NI-P100HT (Inconel 718), silver plated internal thread

Aerospace series - Inserts, thin wall, self-locking, short, in heat resisting nickel base alloy NI-P100HT (Inconel 718), silver plated internal thread

Luft- und Raumfahrt - Gewindeeinsätze, dünnwandig, selbstsichernd, kurz, aus hochwarmfester Nickelbasislegierung NI-P100HT (Inconel 718), Innengewinde versilbert

Série aérospatiale - Douilles filetéés, a paroi mince, a freinage interne, courtes, en alliage résistant a chaud a base de nickel NI-P100HT (Inconel 718), filetage intérieur argenté

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Ta slovenski standard je istoveten z: EN 3236:1998

ICS:

49.030.99 Drugi vezni elementi Other fasteners

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EUROPEAN STANDARD
 NORME EUROPÉENNE
 EUROPÄISCHE NORM

EN 3236

January 1998

ICS 49.030.99

Descriptors: aircraft industry, joining adaptor, nickel alloy, heat resistant material, characteristic, surface treatment, dimension, dimensional tolerance, designation, marking

English version

Aerospace series - Inserts, thin wall, self-locking, short, in heat
 resisting nickel base alloy NI-P100HT (Inconel 718), silver plated
 internal thread

Série aérospatiale - Douilles filetées, à paroi mince, à
 freinage interne, courtes, en alliage résistant à chaud à
 base de nickel NI-P100HT (Inconel 718), filetage intérieur
 argenté

Luft- und Raumfahrt - Gewindeeinsätze, dünnwandig,
 selbstsichernd, kurz, aus hochwarmfester
 Nickelbasislegierung NI-P100HT (Inconel 718),
 Innengewinde versilbert

This European Standard was approved by CEN on 18 September 1997.

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.

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 July 1998, and conflicting national standards shall be withdrawn at the latest by July 1998.

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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0 Introduction

For design and installation procedures see EN 3676 and EN 3298.

1 Scope

This standard specifies the characteristics of self-locking, short, thin wall inserts, in NI-P100HT, with silver plated internal thread, for aerospace applications.

Maximum test temperature: 550 °C

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 965-1	ISO general purpose metric screw threads - Tolerances - Part 1: Principles and basic data
ISO 5855-2	Aerospace - MJ threads - Part 2: Limit dimensions for bolts and nuts
EN 2404	Heat resisting nickel base alloy NI-P100-HT - Solution treated and precipitation treated - Bars - Aerospace series ¹⁾
EN 2424	Aerospace series - Marking of aerospace products
EN 2786	Aerospace series - Electrolytic silver plating of fasteners ²⁾
EN 3297	Aerospace series - Inserts, thin wall, self-locking, MJ threads, in heat resisting nickel base alloy NI-P100HT (Inconel 718) - Technical specification ²⁾
EN 3298	Aerospace series - Inserts, thin wall, self-locking - Installation and removal procedure ²⁾
EN 3676	Aerospace series - Inserts, thin wall, self-locking - Design standard ²⁾
TR 3198	Aerospace series - Manufacturers' identification monograms and marks for EN aerospace products ³⁾

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

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

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

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 Material

EN 2404

3.3 Surface treatment

EN 2786, internal thread and counterbore diameter *C*


Thickness:

- internal threads \geq MJ6: 5 μm min. on thread flanks;
- internal threads MJ5: shall show complete coverage, without thickness requirement;
- counterbore diameter *C*: without thickness requirement.

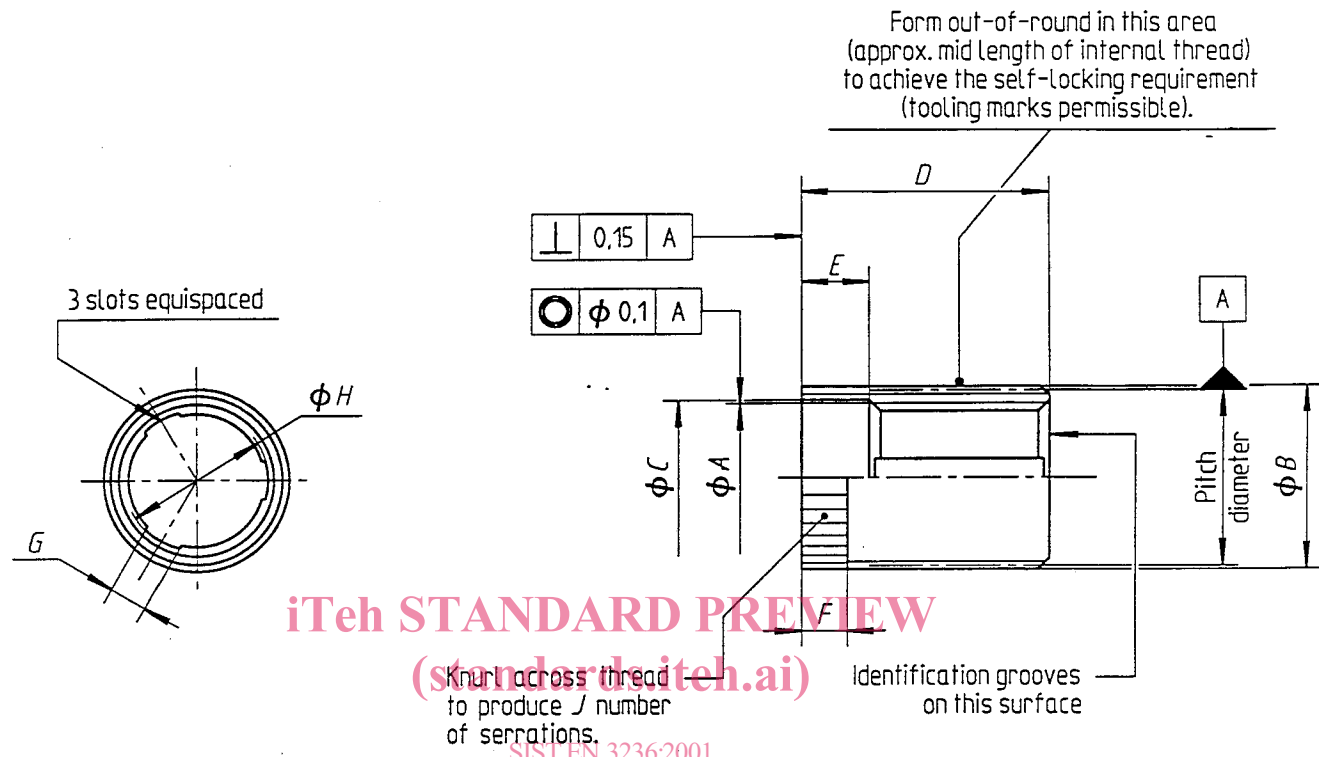
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Ra 3,2/  Values apply before silver plating.

Remove sharp edges 0,1 to 0,4.



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Details of form not stated are at the manufacturer's option.

Figure 1

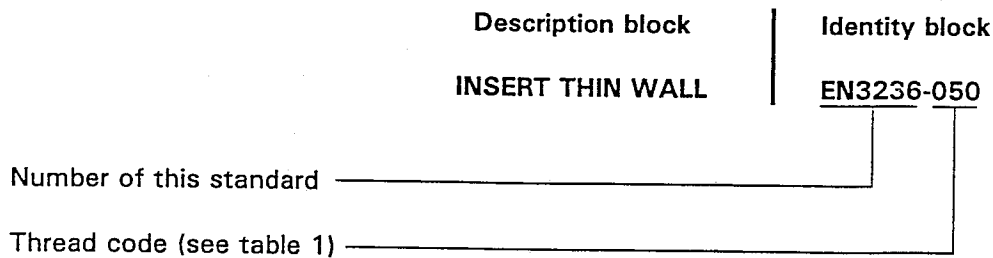
Table 1

Code	A Internal thread ¹⁾		B External thread ²⁾		C	D	E	F	G	H	J	Mass kg/1 000 parts ≈
	Designation	Designation	max. minor diameter		+0,15 0	± 0,3	+0,4 0	+0,6 0	min.	min.		
050	MJ5x0,8-4H6H	M7x1-4g	5,973		5,2	7,6	2,75	2	1,25	4,56	18	0,920
060	MJ6x1-4H5H	M8x1-4g	7,016		6,2	8,9	2,95	2,1	1,5	5,44	24	1,355
070	MJ7x1-4H5H	M9x1-4g	8,056		7,2	10,9	3,35	2,4	1,75	6,44	27	1,960
080	MJ8x1-4H5H	M10x1-4g	9,056		8,2	12,8	3,75	2,6	2	7,28	28	2,756
100	MJ10x1,25-4H5H	M12x1-4g	11,11		10,25	16,2	4,45	3	2,5	9,14	33	4,595

1) In accordance with ISO 5855-2. In the self-locking zone, the tolerances apply before forming out-of-round.
2) In accordance with ISO 965-1, except maximum minor diameter which shall be as stated.

4 Designation

EXAMPLE:



NOTE: If necessary, the code I9005 shall be placed between the description block and the identity block.

5 Marking

EN 2424, style G

Manufacturers' identification grooves shall be V-section 0,1 mm to 0,2 mm deep as indicated in figure 1, spacing see TR 3198 list 3.

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6 Technical specification

EN 3297

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