
Aerospace series - Nuts, bihexagonal, self-locking, in heat resisting nickel base alloy NI-P101HT (Waspaloy), silver plated thread - Classification: 1 210 MPa (at ambient temperature) / 730 °C

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Luft- und Raumfahrt - Zwölfkantmuttern, selbstsichernd, aus hochwarmfester Nickelbasislegierung NI-P101HT (Waspaloy), Gewinde versilbert - Klasse: 1 210 MPa (bei Raumtemperatur) / 730 °C

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Série aérospatiale - Ecrous bihexagonaux, à freinage interne, en alliage résistant a chaud a base de nickel NI-P101HT (Waspaloy), a filetage argenté - Classification: 1 210 MPa (a température ambiante) / 730 °C

Ta slovenski standard je istoveten z: EN 3239:1995

ICS:

49.030.30 Matice Nuts

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EUROPEAN STANDARD

EN 3239

NORME EUROPÉENNE

EUROPÄISCHE NORM

September 1995

ICS 49.040.20

Descriptors: aircraft industry, fastener nut: fastener, double hexagonal nut, self locking nut, nickel alloy, heat resistant material, silver, classification, screw thread, dimension, surface treatment, designation

English version

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European Committee for Standardization
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Ref. No. EN 3239:1995 E

1 Scope

This standard specifies the characteristics of self-locking bihexagonal nuts in NI-P101HT, silver plated thread, for aerospace applications.

Classification : 1 210 MPa ¹⁾ / 730 °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 4095	Fasteners for aerospace construction - Bi-hexagonal wrenching configuration
ISO 5855-2	Aerospace - MJ threads - Part 2 : Limit dimensions for bolts and nuts
EN 2424	Aerospace series - Marking of aerospace products
EN 2786	Aerospace series - Electrolytic silver plating of fasteners ³⁾
EN 2959	Aerospace series - Heat resisting nickel base alloy (NI-P101HT) - Solution treated and cold worked - Bars for hot upset forging for fasteners - $3 \leq D \leq 30$ mm ³⁾
EN 3005	Aerospace series - Nuts, self-locking, in heat resisting nickel base alloy NI-P101HT (Waspaloy) - Classification : 1 210 MPa / 730 °C Technical specification ³⁾
EN 3220	Aerospace series - Heat resisting nickel base alloy (NI-P101HT) - 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 table 1. Dimensions and tolerances are in millimetres. They apply after silver plating.

3.2 Materials

EN 2959 or EN 3220

3.3 Surface treatment

EN 2786 on thread and chamfers

Thickness :

- thread \geq MJ6 : 5 μ m min. on thread flanks ;
- thread MJ5 : shall show complete coverage, without thickness requirement ;
- chamfers : shall show complete coverage, without thickness requirement.

1) Corresponds to the minimum tensile stress which the nut is able to withstand at ambient temperature without breaking or cracking when tested with a bolt of a higher strength class.

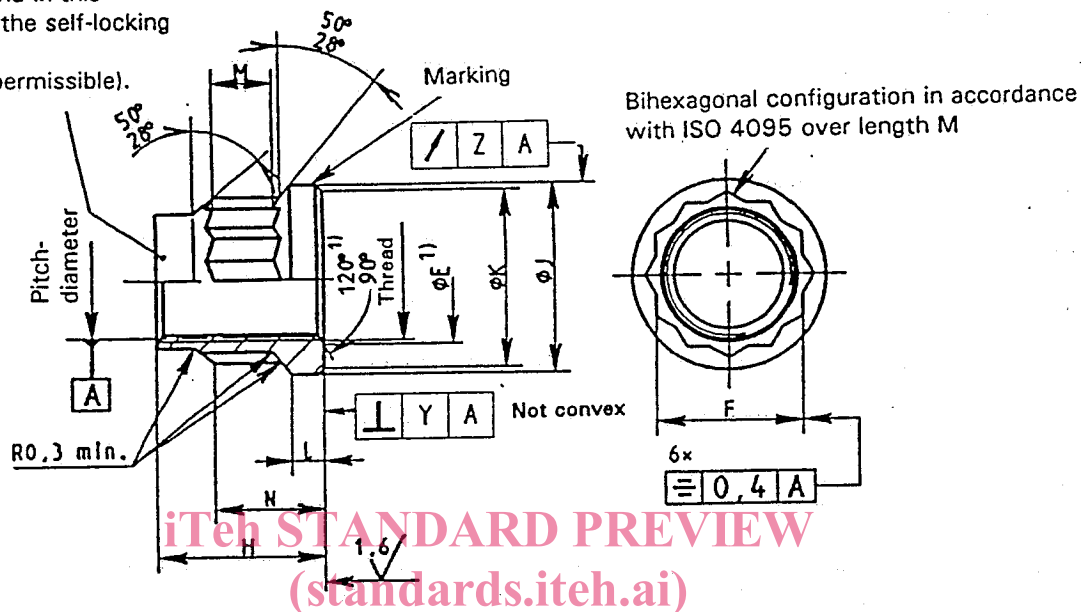
2) Maximum test temperature of the parts

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

6,3 / (1,6) Values apply before silver plating.
Thread surface will be achieved by normal methods of manufacture.

Remove sharp edges 0,1 to 0,4

Form out-of-round in this area to achieve the self-locking requirement (tooling marks permissible).



1) All forms of entry (radius or chamfer) are permissible within these limiting dimensions.

Details of form not stated are left to the manufacturer's discretion.

Figure 1

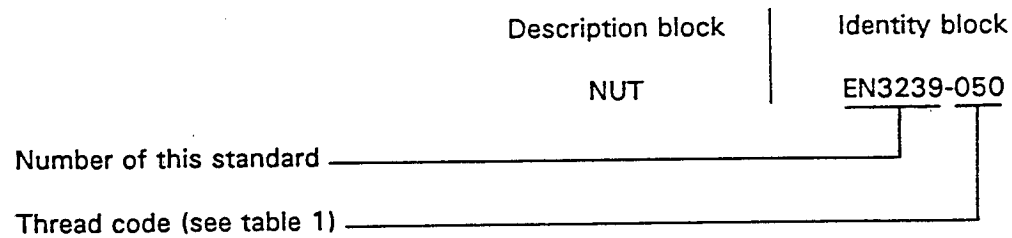
Table 1

Code	Thread 1)	E		F	H	J	K	L	M	N	Y	Z	Mass kg/1 000 parts ≈
		max.	min.										
050	MJ5x0,8-4H6H	5,8	5,2	8	8,3	10,2	9	1,5	2	5,6	0,1	0,2	3
060	MJ6x1-4H5H	7,1	6,3	9	9,4	11,6	10,2	1,6	2,3	5,8			4
070	MJ7x1-4H5H	8,1	7,3	10	10,4	12,6	11,5	1,7	2,6	6,5			5
080	MJ8x1-4H5H	9,1	8,3	12	11,5	15	13,6	2	2,8	7,3	0,13	0,3	8
100	MJ10x1,25-4H5H	11,1	10,3	14	13,2	18	16,1	2,3	3,1	8,1			12
120	MJ12x1,25-4H5H	13,1	12,3	17	16	21,5	19,7	2,8	3,5	10	0,15	0,3	20
140	MJ14x1,5-4H5H	15,2	14,4	19	17,5	24	22	3	4	11,2			28
160	MJ16x1,5-4H5H	17,2	16,4	22	20	28	25,6	3,5	4,7	12,1	0,18	0,3	42

1) In accordance with ISO 5855-2. In the self-locking zone, the tolerances apply before forming out-of-round.

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 A, as indicated on figure 1.

6 Technical specification

EN 3005

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