

SLOVENSKI STANDARD

SIST EN 3306:2001

01-januar-2001

Aerospace series - Screws, 100- countersunk normal head, offset cruciform recess, threaded to head, in titanium alloy, anodized, MoS2 lubricated - Classification: 1 100 MPa (at ambient temperature)/315°C

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Luft- und Raumfahrt - 100° Senkschrauben mit Flügelkreuzschlitz, Gewinde annähernd bis Kopf, aus Titanlegierung, anodisiert, MoS2-geschmiert - Klasse: 1 100 MPa (bei Raumtemperatur)/315 °C

Série aérospatiale - Vis a tete fraisée, 100° normale, a empreinte cruciforme déportée, filetées jusqu'a proximité de la tete, en alliage de titane, anodisées, lubrifiées MoS2 - Classification: 1 100 MPa (a température ambiante)/315 °C

Ta slovenski standard je istoveten z: EN 3306:1996

ICS:

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

SIST EN 3306:2001

en

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EUROPEAN STANDARD

EN 3306

NORME EUROPÉENNE

EUROPÄISCHE NORM

August 1996

ICS 49.040.20

Descriptors: aircraft industry, screw, countersunk head screw, cross recessed screw, titanium alloy, specification, dimension, dimensional tolerance, surface treatment, designation, marking

English version

Aerospace series - Screws, 100° countersunk normal head, offset cruciform recess, threaded to head, in titanium alloy, anodized, MoS₂ lubricated
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Série aérospatiale - Vis à tête fraisée 100° normale, à empreinte cruciforme déportée, filetées jusqu'à proximité de la tête, en alliage de titane, anodisées, lubrifiées MoS₂
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This European Standard was approved by CEN on 1995-12-27. 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.

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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

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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.

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 February 1997, and conflicting national standards shall be withdrawn at the latest by February 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

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cylindrom ni cilindrihote os 8H bnu
ANALJOUJ

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EVTKAGSAAI HOVEDI ON THEVERA



1 Scope

This standard specifies the characteristics of screws, 100° countersunk normal head, offset cruciform recess, threaded to head, in titanium alloy, anodized, MoS₂ lubricated.

Classification : 1 100 MPa ¹⁾ / 315 °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
- ISO 7913 Aerospace - Bolts and screws, metric - Tolerances of form and position
- ISO 7994 Aerospace - Internal drive, offset cruciform recess - (Torq-Set [®]) for rotary fastening devices - Metric series
- ISO 9152 Aerospace - Titanium alloy bolts, strength class 1 100 MPa, MJ threads - Procurement specification ³⁾
- EN 2000 Aerospace series - Quality assurance - EN aerospace products - Approval of the quality system of manufacturers
- EN 2424 Aerospace series - Marking of aerospace products
- EN 2491 Aerospace series - Molybdenum disulphide dry lubricants - Coating methods ⁴⁾
- TR 3775 Aerospace series - Bolts and pins - National materials ⁵⁾
- TR 4070 Aerospace series - Molybdenum disulphide dry lubricants - List of commercial products ³⁾

1) Minimum tensile strength of the material at ambient temperature

2) Maximum temperature that the screw can withstand without continuous change in its original characteristics, after return to ambient temperature. The maximum temperature is determined by the surface treatment.

3) In preparation at the date of publication of this standard

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

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

3 Required characteristics

3.1 Configuration - Dimensions - Masses

See figure 1 and table 1.

Dimensions and tolerances are expressed in millimetres and apply after anodizing but before lubricating.

3.2 Tolerances of form and position

ISO 7913

3.3 Materials

TR 3775 (titanium alloy, strength class 1 100 MPa)

3.4 Surface treatment

Lubrication :

- lubricant : see TR 4070 ;
- application : EN 2491, 5 μm to 10 μm .

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3,2 $\sqrt{\quad}$ [0,8 $\sqrt{\quad}$]

Values in micrometres apply prior to surface treatment.

Break sharp edges 0,1 to 0,4

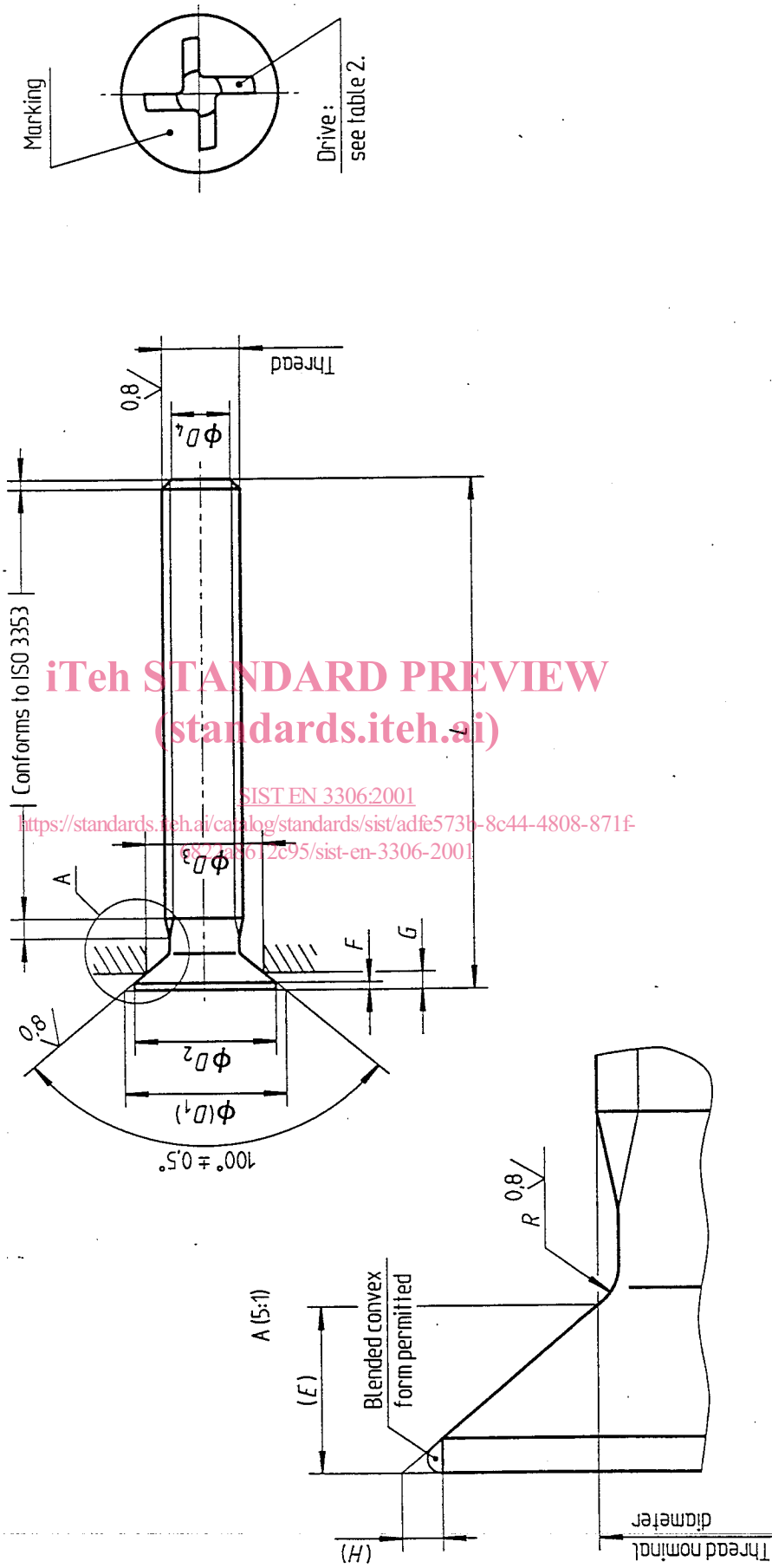


Figure 1

Table 1

Diameter code	Thread ¹⁾	D ₁		D ₂		D ₃		D ₄		E	F	G	H	L + 0,3 ^{2) 3)}		R		Mass ⁴⁾	
		max.	min.	min.	max.	nom.	Tol.	Code	nom.					nom.	Tol.	nom.	Tol.	5)	6)
030	MJ3x0,5 - 4h6h	6	5,4	4,5	2,3	0	1,27	0,06	0,63	0,3	0,06 to 0,42	6 to 42	0,4	0,22	0,11				
040	MJ4x0,7 - 4h6h	8	7,2	5,78	3	- 0,5	1,69	0,08	0,93	0,4	0,08 to 0,56	8 to 56	0,4	0,53	0,20				
050	MJ5x0,8 - 4h6h	10	9	7,71	3,4		2,12		0,96	0,5	0,10 to 0,70	10 to 70	0,5	1,02	0,33				
060	MJ6x1 - 4h6h	12	10,8	9	4,2		2,54		1,26		0,12 to 0,84	12 to 84	0,5	1,78	0,44				
070	MJ7x1 - 4h6h	14	12,8	10,28	5,2		2,96		1,57		0,12 to 0,98	12 to 98	0,7	2,54	0,60				
080	MJ8x1 - 4h6h	16	14,8	12,21	6,2	+ 0,5	3,39	0,1	1,6	0,6	0,14 to 1,12	14 to 112	0,8	3,86	0,78				
100	MJ10x1,25 - 4h6h	20	18,8	15,43	7,9		4,23		1,93		0,18 to 1,40	18 to 140	0,8	7,78	1,22				
120	MJ12x1,25 - 4h6h	24	22,8	18	9,8		5,08		2,53		0,20 to 1,68	20 to 168	0,9	12,72	1,76				

1) In accordance with ISO 5855-2

2) Increments :

2 for L ≤ 100

4 for L > 100

3) If greater lengths are required, they shall be chosen using the above increments. The length code corresponds to the length L, completed by one or two zeros to the left, where necessary, to obtain a three digit code.

4) Approximate values (kg/1 000 pieces), calculated on the basis of 4,45 kg/dm³, given for information purposes only

5) Value for first L

6) Increase for each additional 2 mm of L.