
Aeronavtika - Vijaki, nizka valjasta glava, križna zarez, dolgi navoj do glave, iz toplotnoodpornega jekla FE-PA92HT (A286), posrebreni - Klasifikacija: 900 MPa/650 °C

Aerospace series - Screws, reduced pan head, offset cruciform recess, relieved shank, long thread, in heat resisting steel FE-PA92HT (A286), silver plated - Classification: 900 MPa/650 °C

Luft- und Raumfahrt - Flachkopfschrauben mit geripptem Flügelkreuzschlitz, Dünnschaft, langes Gewinde, aus hochwarmfestem Stahl FE-PA92HT (A286), versilbert - Klasse: 900 MPa/650 °C

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Série aérospatiale - Vis à tête cylindrique, réduite, à empreinte cruciforme déportée, à tige réduite, à filetage long, en acier résistant à chaud FE-PA92HT (A286), argentées - Classification: 900 MPa/650 °C

Ta slovenski standard je istoveten z: EN 3636:2008

ICS:

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

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ICS 49.030.20

English Version

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

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Contents

Page

Foreword.....	3
1 Scope	4
2 Normative references	4
3 Required characteristics.....	4
4 Designation	7
5 Marking	7
6 Technical specification	7

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Foreword

This document (EN 3636:2008) has been prepared by the Aerospace and Defence Industries Association of Europe - Standardization (ASD-STAN).

After enquiries 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 ASD, 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of an identical text or by endorsement, at the latest by October 2008, and conflicting national standards shall be withdrawn at the latest by October 2008.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN [and/or CENELEC] shall not be held responsible for identifying any or all such patent rights.

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1 Scope

This standard specifies the requirements for offset cruciform recess pan head screws with relieved shank and long thread in heat resisting steel FE-PA92HT, silver plated, tensile strength class 900 MPa at room temperature. The maximum test temperature of the material is 650 °C.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 3353-1, *Aerospace — Lead and runout threads — Part 1: Rolled external threads.*

ISO 5855-1, *Aerospace — MJ threads — Part 1: General requirements.*

ISO 5855-2, *Aerospace — MJ threads — Part 2: Limit dimensions for bolts and nuts.*

ISO 14275, *Aerospace — Drives, internal, offset cruciform, ribbed — Metric series.*

ISO 14277, *Aerospace — Drivers, ribbed, for internal offset cruciform ribbed or unribbed drives — Metric series.*

ISO 14278, *Aerospace — Gauges, for internal offset cruciform ribbed or unribbed drives — Metric series.*

EN 2398, *Aerospace series — Heat resisting steel FE-PA2601 (X6NiCrTiMoV26-15) — $R_m \geq 900$ MPa — Bars for machined bolts — $D \leq 25$ mm. ¹⁾*

EN 2399, *Heat resisting steel FE-PA92-HT — $R_m \geq 900$ MPa — Bars for forged bolts $D \leq 25$ mm — Aerospace series. ¹⁾*

EN 2424, *Aerospace series — Marking of aerospace products.*

EN 2786, *Aerospace series — Electrolytic silver plating of fasteners. ²⁾*

EN 3043, *Aerospace series — Fasteners, externally threaded, in heat resisting steel FE-PA92HT (A286) — Classification: 900 MPa/650 °C — Manufacturing method optional — Technical specification. ²⁾*

3 Required characteristics

3.1 Configuration – Dimensions – Tolerances

Configuration: see Figure 1.

Dimensions and tolerances: see Figure 1 and Tables 1 and 2, dimensions in millimetres.

3.2 Material

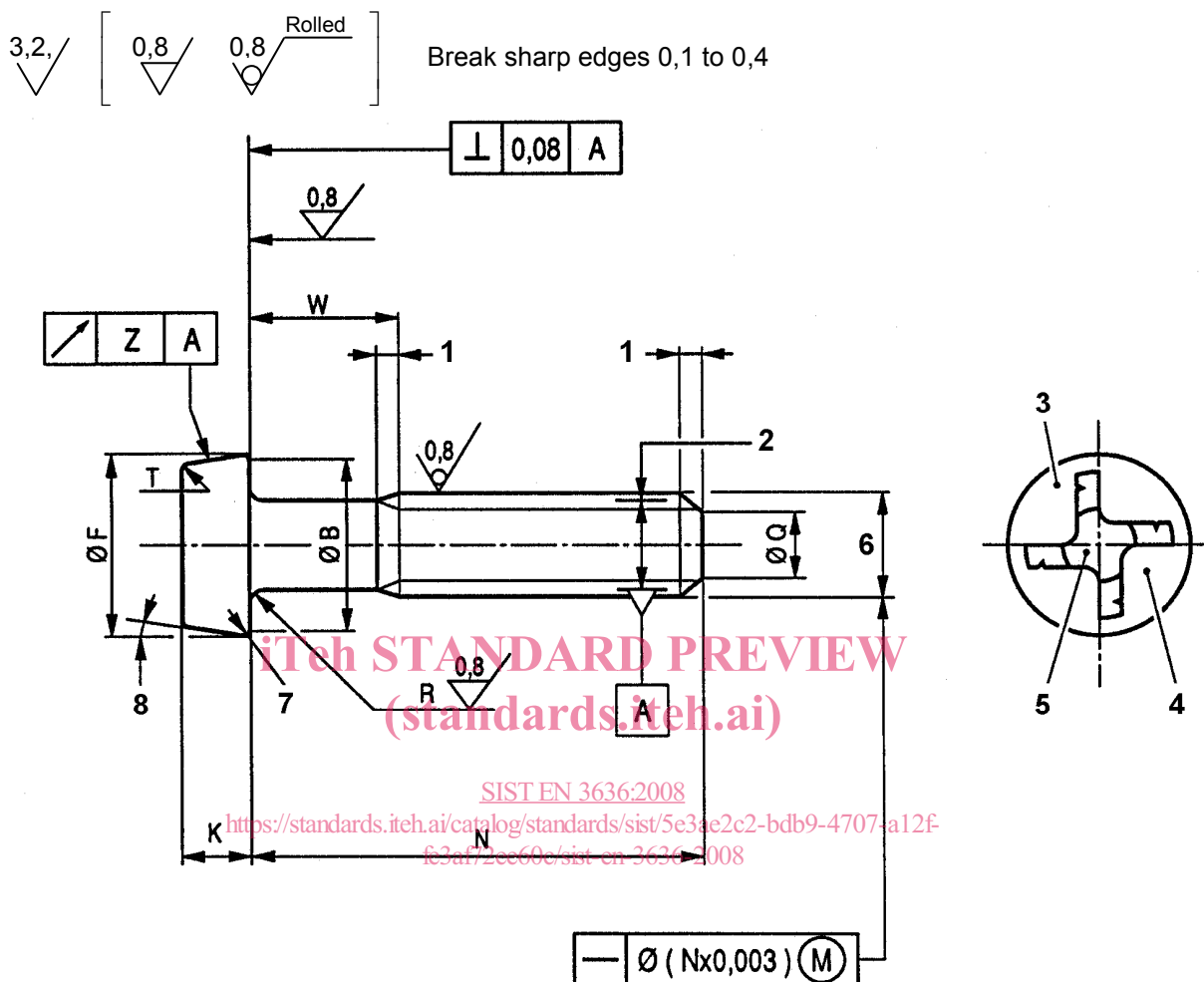
Heat resisting steel FE-PA92HT: see EN 2398 or EN 2399.

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

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

3.3 Surface coating

Silver coat all over: see EN 2786, coating thickness 3 µm to 6 µm on the thread flanks, measured at the pitch diameter.



Key

- | | |
|---------------------------------|---|
| 1 In conformity with ISO 3353-1 | 5 Recess in conformity with ISO 14275, ISO 14277, ISO 14278 |
| 2 \varnothing on flank | 6 Thread |
| 3 Marking | 7 0,2 to 0,5 |
| 4 Manufacturer monogram | 8 0° to 5° |

Figure 1 — Configuration

Table 1 — Dimensions

Diameter code	Thread ^a	B		F		K		Q		R		T		Z	Recess number to ISO 14275 ISO 14277 ISO 14278
		min.	max.	min.	max.	min.	max.	min.	max.	min.	max.	min.	max.		
030	MJ 3 × 0,5 - 4h6h	4,7	6	5,7	1,8	1,6	2,3	1,8	0,4	0,2	1,2	0,3	0,11	R3	
040	MJ 4 × 0,7 - 4h6h	5,7	7	6,7	2,1	1,9	3,1	2,6	0,4	0,2	1,4	0,4	0,14	R3,5	
050	MJ 5 × 0,8 - 4h6h	6,7	8	7,7	2,4	2,2	3	4	0,5	0,3	1,6	0,4	0,14	R4	

^a According to ISO 5855-1, Parts 1 and 2; rolled

Table 2 — Dimensional codes, lengths

Diameter code		030		040		050			
Length ^a code	$N \pm 0,3$	<i>W</i>		<i>W</i>		<i>W</i>			
		max.	min.	max.	min.	max.	min.		
004	4	1,40	1,15	—	—	—	—		
006	6	1,40	1,15	1,80	1,45				
008	8	1,40	1,15	1,80	1,45	2,10	1,70		
010	10	1,40	1,15	1,80	1,45	2,10	1,70		
012	12	1,40	1,15	1,80	1,45	2,10	1,70		
014	14	1,40	1,15	1,80	1,45	2,10	1,70		
016	16	4	2,50	1,80	1,45	2,10	1,70		
018	18	6	4,50	4	2,50	2,10	1,70		
020	20	8	6,50	6	4,50	4	2,50		
022	22	10	8,50	8	6,50	6	4,50		
024	24	12	10,50	10	8,50	8	6,50		
026	26	14	12,50	12	10,50	10	8,50		
028	28	16	14,50	14	12,50	12	10,50		
030	30	18	16,50	16	14,50	14	12,50		
032	32	20	18,50	18	16,50	16	14,50		
034	34	22	20,50	20	18,50	18	16,50		
036	36	24	22,50	22	20,50	20	18,50		
038	38	26	24,50	24	22,50	22	20,50		
040	40	28	26,50	26	24,50	24	22,50		
042	42	30	28,50	28	26,50	26	24,50		
044	44	—	—	30	28,50	28	26,50		
046	46			32	30,50	30	28,50		
048	48			34	32,50	32	30,50		
050	50			36	34,50	34	32,50		
052	52			38	36,50	36	34,50		
054	54			40	38,50	38	36,50		
056	56			42	40,50	40	38,50		
058	58			—	—	42	40,50	42	40,50
060	60					44	42,50	44	42,50
062	62					46	44,50	46	44,50
064	64	48	46,50			48	46,50		
066	66	50	48,50			50	48,50		
068	68	52	50,50			52	50,50		
070	70	54	52,50			54	52,50		

^a The preferred length range lies within the bold lines. If greater lengths are necessary they shall be chosen in steps of 2 mm for lengths *L* less than 100 mm and in multiples of 4 above 100 mm. The length code corresponds to the length *L* in millimetres completed by zeros to the left, where necessary to obtain a 3 digit code.