SLOVENSKI STANDARD
SIST EN 3644:2001

01-januar-2001

Aerospace series - Rivets, solid, universal head, in titanium TI-PO2, anodized, inch based series

Aerospace series - Rivets, solid, universal head, in titanium TI-PO2, anodized, inch based series

Luft- und Raumfahrt - Vollniete, mit Universalkopf, aus Titan TI-PO2, anodisiert, Zoll-Reihe

Série aérospatiale - Rivets ordinaires, a tete ronde aplatie, en titane TI-PO2, anodisés, série base inches

Ta slovenski standard je istoveten z: **EN 3644:1996**

ICS:

49.030.60 Kovice Rivets

SIST EN 3644:2001 **en**

EUROPEAN STANDARD **EN 3644**

NORME EUROPÉENNE

EUROPÄISCHE NORM September 1996

ICS 49.040.20

Descriptors: aircraft industry, rivet, round head rivet, titanium, characteristic, dimension, dimensional tolerance, designation

English version

Aerospace series - Rivets, solid, universal head, in titanium TI-PO2, anodized, inch based series

Série aérospatiale - Rivets ordinaires, à tête ronde aplatie, en titane TI-PO2, anodisés, série base inches

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This European Standard was approved by CEN on 1996-06-29. 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

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 March 1997, and conflicting national standards shall be withdrawn at the latest by March 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 characteristics of solid rivets, universal head, in titanium TI-P02, anodized, inch based series, for maximum operating temperature 315 °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 8080	Aerospace - Anodic treatment of titanium and titanium alloys - Sulfuric acid process
ISO 10299	Aerospace - Identification marking of solid rivets [1]
EN 2424	Aerospace series - Marking of aerospace products
EN 3378	Aerospace series - Titanium TI-P02 - Annealed - $330 \leq R_c \leq 410$ MPa - Wire for rivet - $1,6 \leq d \leq 10$ mm [2]
EN 3627	Aerospace series - Titanium solid rivets - Technical specification [1]

3 Required characteristics

3.1 Configuration - Dimensions - Masses

See figure 1 and tables 1 and 2. Dimensions and tolerances are expressed in millimetres and apply after surface treatment.

3.2 Material

EN 3378

3.3 Surface treatment

ISO 8080

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

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

Non-radiused tail
(code "N")

Radiused tail
(code "R")

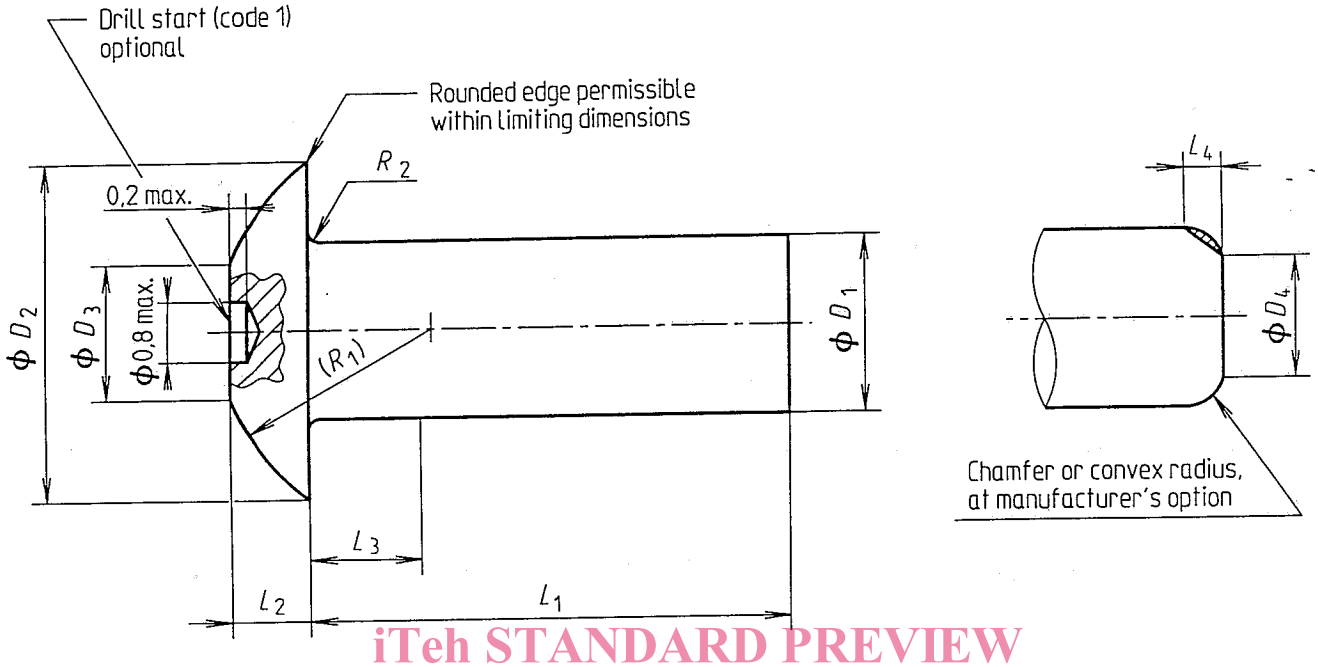


Figure 1

Table 1

Diameter code	D_1 [1]		D_2		D_3		D_4		L_2 + 0,2 0	L_3	L_4		R_1	R_2
	max.	min.	max.	min.	max.	min.	max.	min.			max.	min.		± 0,08
024	2,45	2,35	5	4,5	2,4	1,8	1,9	1,6	1	1,4	0,8	0,5	2,9	0,15
032	3,25	3,15	6,7	6	3,2	2,4	2,6	2,3	1,4		1	0,7	3,9	
036	3,65	3,55	7,5	6,8	3,6	2,7	2,9	2,5	1,6	1,6	1,1		4,4	0,25
040	4,05	3,94	8,3	7,5	4	3	3,2	2,8	1,7		1,2	0,8	4,9	
048	4,85	4,73	10	9	4,8	3,6	3,8	3,3	2	2	1,5	1	5,9	

1) D_1 max. may increase by 0,03, over length L_3.

Table 2

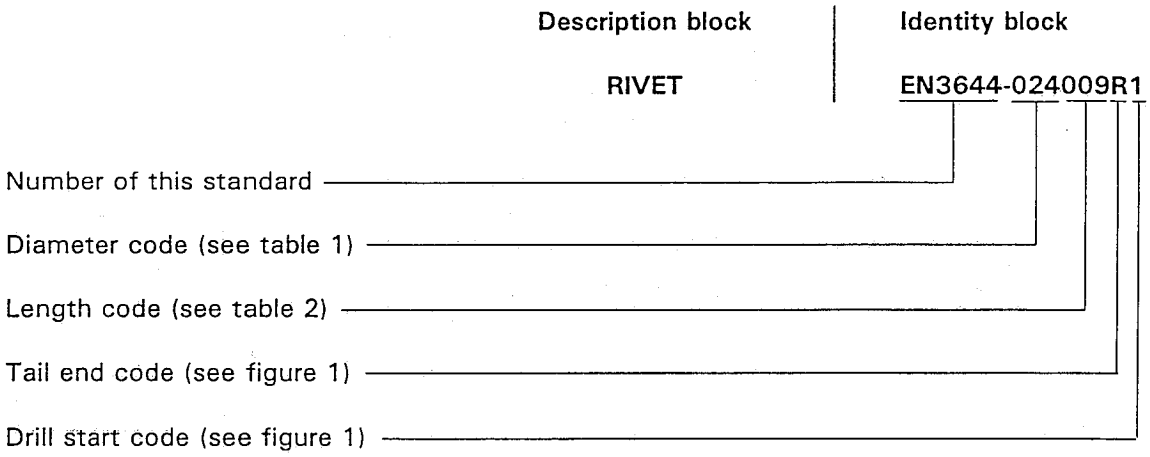
Diameter code		024			032			036			040			048		
Length		1)		Mass 2)	1)		Mass 2)	1)		Mass 2)	1)		Mass 2)	1)		Mass 2)
code	L_1 $^{+0,5}_{0}$	N	R		N	R		N	R		N	R		N	R	
004	4	X	X	0,140	X	X	0,284	X	X	0,370			—			—
005	5	X	X	0,160	X	X	0,320	X	X	0,414			—			—
006	6	X	X	0,180	X	X	0,356	X	X	0,456	X	X	0,611			—
007	7	X	X	0,201	X	X	0,392	X	X	0,498	X	X	0,668			—
008	8	X	X	0,221	X	X	0,428	X	X	0,541	X	X	0,724	X	X	1,121
009	9	X	X	0,242	X	X	0,464	x	x	0,583	X	X	0,781	X	X	1,202
010	10	X	X	0,262	X	X	0,501	X	X	0,626	X	X	0,837	X	X	1,283
011	11	X	X	0,283	X	X	0,537	X	X	0,668	X	X	0,893	X	X	1,365
012	12	X	X	0,303	X	X	0,573	X	X	0,710	X	X	0,950	X	X	1,446
013	13	X	X	0,323	X	X	0,610	X	X	0,753	X	X	1,006	X	X	1,528
014	14	X	X	0,343	X	X	0,646	X	X	0,795	X	X	1,063	X	X	1,609
015	15	X	X	0,364	X	X	0,682	X	X	0,839	X	X	1,119	X	X	1,690
016	16	X	X	0,384	X	X	0,718	X	X	0,882	X	X	1,176	X	X	1,772
017	17	X		0,405	X	X	0,755	X	X	0,924	X	X	1,232	X	X	1,853
018	18	X		0,425	X	X	0,791	X	X	0,966	X	X	1,289	X	X	1,935
019	19	X		0,446	X		0,827	X	X	1,009	X	X	1,345	X	X	2,016
020	20	X		0,466	X		0,863	X	X	1,051	X	X	1,402	X	X	2,098
022	22			—	X		0,935	X		1,136	X	X	1,515	X	X	2,261
024	24			—	X		1,007	X		1,221	X	X	1,628	X	X	2,424
026	26			—			—	X		1,307	X		1,741	X	X	2,587
028	28			—			—	X		1,392	X		1,854	X	X	2,750
030	30			—			—			—	X		1,967	X		2,913
032	32			—			—			—	X		2,080	X		3,076
035	35			—			—			—			—	X		3,239
040	40			—			—			—			—	X		3,402

1) Tail end code (see figure 1)

2) Approximate values (kg/1 000 pieces), calculated on the basis of 4,45 kg/dm^3, given for information purposes only

4 Designation

EXAMPLE :



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

5 Marking

5.1 Rivet

EN 2424, style G

5.2 Material

ISO 10299

6 Technical specification

EN 3627