



SLOVENSKI STANDARD

SIST EN 3672:2008

01-november-2008

5 YfcbUj h U! NU_cj] YbY'a UjWžgUa cj Ufcj UbYž]n'hd`clbccXdcfbY'n`]hbY'bU
b]`^j]cgbcj]B=D°\$%<H'fK UgdUcmtždcgfYVfYbYžnU' \$šcXdfh]bY!'?`Ug]Z_ UW'U%
&%'A DUfd]gcVb]hYa dYfUi f]# ' \$'š7

Aerospace series - Shank nuts, self-locking, in heat resisting nickel base alloy NI-P101HT (Waspaloy), silver plated, for 30° swage - Classification: 1 210 MPa (at ambient temperature)/730 °C

STANDARD PREVIEW

(standards.iteh.ai)

Luft- und Raumfahrt - Einnietmuttern, selbstsichernd, aus hochwarmfester Nickelbasislegierung NI-P101HT (Waspaloy), versilbert, für 30° Aufweitung - Klasse: 1 210 MPa (bei Raumtemperatur)/730 °C

<https://standards.iteh.ai/standards/sist/6f269fa7-1986-4836-907a-e939e4f9ad11/sist-en-3672-2008>

Série aérospatiale - Ecrous à sertir, à freinage interne, en alliage résistant à chaud à base de nickel NI-P101HT (Waspaloy), argentés, pour sertissage 30° - Classification: 1 210 MPa (à température ambiante)/730 °C

Ta slovenski standard je istoveten z: EN 3672:2008

ICS:

49.030.30 Matice Nuts

SIST EN 3672:2008 en

iTeh STANDARD PREVIEW
(standards.iteh.ai)

SIST EN 3672:2008

<https://standards.iteh.ai/catalog/standards/sist/6f269fa7-1986-4836-907a-e939e4f9ad11/sist-en-3672-2008>

EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

EN 3672

August 2008

ICS 49.030.30

English Version

Aerospace series - Shank nuts, self-locking, in heat resisting nickel base alloy NI-P101HT (Waspaloy), silver plated, for 30° swage - Classification: 1 210 MPa (at ambient temperature)/730 °C

Série aéronautique - Ecrous à sertir, à freinage interne, en alliage résistant à chaud à base de nickel NI-P101HT (Waspaloy), argentés, pour sertissage 30° - Classification: 1 210 MPa (à température ambiante)/730 °C

Luft- und Raumfahrt - Einnietmuttern, selbstsichernd, aus hochwärmfester Nickelbasislegierung NI-P101HT (Waspaloy), versilbert, für 30° Aufweitung - Klasse: 1 210 MPa (bei Raumtemperatur)/730 °C

This European Standard was approved by CEN on 21 December 2007.

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 CEN Management Centre 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 CEN Management Centre has the same status as the official versions.

[SIST EN 3672:2008](https://standards.iteh.ai/catalog/standards/sist/626967-1986-4836-907a/sist-en-3672-2008)

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.



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

Management Centre: rue de Stassart, 36 B-1050 Brussels

Contents

Page

1	Scope	4
2	Normative references	4
3	Required characteristics	4
3.1	Configuration, dimensions, tolerances, masses	4
3.2	Material	4
3.3	Surface treatment	5
4	Designation	6
5	Marking	6
6	Technical specification	6

Figures

Figure 1 — Shank nuts	5
------------------------------------	----------

Tables

Table 1 — Dimensions and masses	6
--	----------

iTeh STANDARD PREVIEW
(standards.iteh.ai)

SIST EN 3672:2008

<https://standards.iteh.ai/catalog/standards/sist/6f269fa7-1986-4836-907a-e939e4f9ad11/sist-en-3672-2008>

Foreword

This document (EN 3672:2008) 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 February 2009, and conflicting national standards shall be withdrawn at the latest by February 2009.

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.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and the United Kingdom.

ITEH STANDARD PREVIEW
(standards.iteh.ai)

SIST EN 3672:2008

<https://standards.iteh.ai/catalog/standards/sist/6f269fa7-1986-4836-907a-e939e4f9ad11/sist-en-3672-2008>

EN 3672:2008 (E)**1 Scope**

This standard specifies the characteristics of self-locking shank nuts in NI-P101HT, silver plated, for use in 30° cone holes, for aerospace applications.

Classification: 1 210 MPa¹⁾/730 °C²⁾

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.

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

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

EN 2959, *Aerospace series — Heat resisting alloy NI-PH1302 (NiCr20Co13Mo4Ti3Al), solution treated and cold worked — Bar for forged fasteners $3 \text{ mm} \leq D \leq 30 \text{ mm}^3$*

EN 3005, *Aerospace series — Nuts, self-locking, MJ threads, in heat resisting nickel base alloy NI-PH1302 (Waspaloy), silver plated or uncoated — Classification: 1 210 MPa (at ambient temperature)/730 °C — Technical specification*

EN 3220, *Aerospace series — Heat resisting nickel base alloy (Ni-P101 HT) — Cold worked and softened — Bar and wire for continuous forging or extrusion for fasteners $3 \leq D \leq 30 \text{ mm}^3$*

ISO 5855-2, *Aerospace — MJ threads — Part 2: Limit dimensions for bolts and nuts*
<https://standards.iteh.ai/catalog/standards/sist/61269fa7-1986-4836-907a-e939e4f9ad11/sist-en-3672-2008>

3 Required characteristics**3.1 Configuration, dimensions, tolerances, masses**

See Figure 1 and Table 1. Dimensions and tolerances apply after silver plating.

3.2 Material

EN 2959 or EN 3220.

-
- 1) The strength class of the bolt concerned which can withstand the load at ambient temperature when tested at 100 % load without cracking or breaking of the nut.
 - 2) Maximum test temperature of the parts.
 - 3) Published as ASD prestandard at the date of publication of this standard.

3.3 Surface treatment

EN 2786 on thread, counterbore and chamfers.

Thickness:

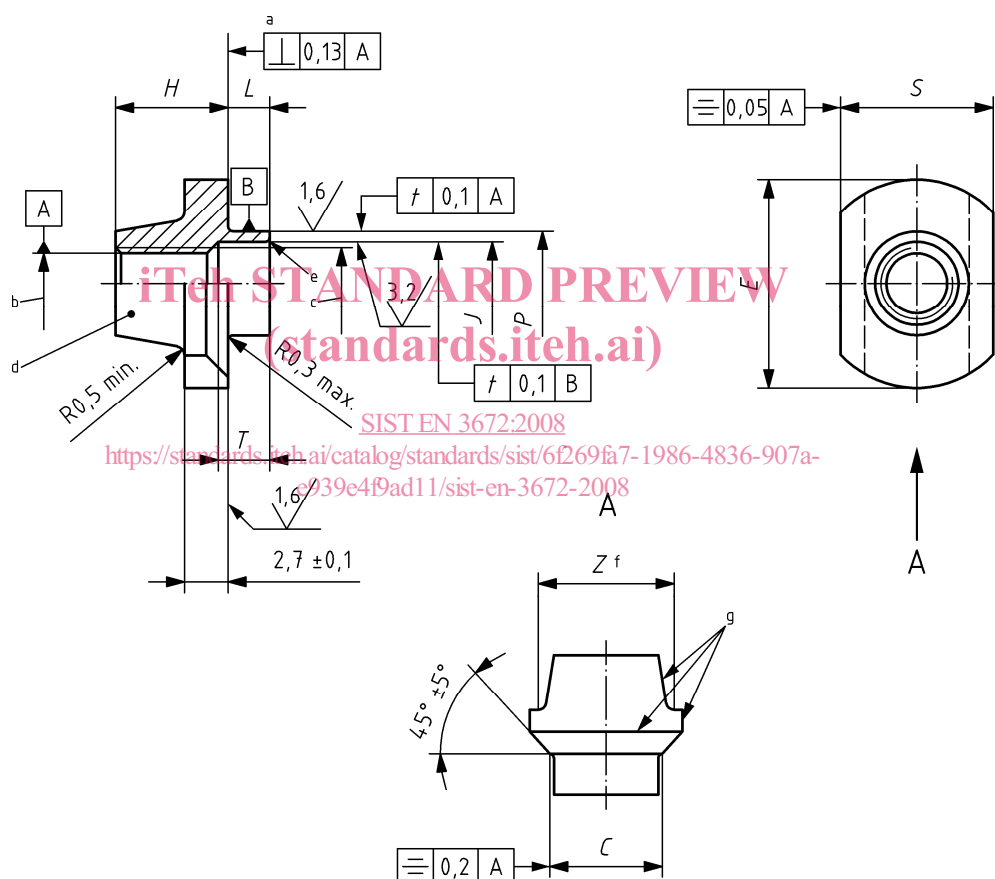
- External surfaces: 5 μm to 15 μm ;
- Thread \geq MJ6: 5 μm min. on thread flanks;
- Thread MJ5: shall show complete coverage, without thickness requirement.

Dimensions in millimetres

$6,3 / \left(\sqrt{1,6} / \sqrt{3,2} \right)$

Values apply before silver plating.

Thread surface will be as achieved by normal methods of manufacture.



Remove sharp edges 0,1 mm to 0,4 mm

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

- a Not convex
- b Pitch diameter
- c Thread
- d Form-out-round in this area to achieve the self-locking requirement (tooling marks permissible)
- e Chamfer or radius max. 0,08
- f Limit of the blend radius
- g Marking in these areas but not in locking area

Figure 1 — Shank nuts

Table 1 — Dimensions and masses

Code	Thread ^a Designation	C	E	H	J	L	P	S	T	Z	Mass 1 000 pieces kg
		mm ± 0,1	mm ± 0,25	mm h14	mm + 0,1 0	mm ± 0,1 0	mm 0 - 0,1	mm ± 0,1	mm ± 0,25	mm max.	kg ≈
050	MJ5 × 0,8-4H6H	7	∅ 13	7	∅ 5,2	2,6	∅ 6,5	9,5	3,2	∅ 8,5	2,77
060	MJ6 × 1-4H5H	8	∅ 14	8	∅ 6,2	2,9	∅ 7,5	10,5	3,5	∅ 9,5	3,47
070	MJ7 × 1-4H5H	9	∅ 16	9	∅ 7,2	3,1	∅ 8,5	11,5	3,7	∅ 10,5	4,2
080	MJ8 × 1-4H5H	10	∅ 17	10	∅ 8,2	3,3	∅ 9,5	12,5	4	∅ 11,5	5,41

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

4 Designation

EXAMPLE

Description block

Identity block

Nut

EN 3672 — 050

iTeh STANDARD PREVIEW
(standards.iteh.ai)

Number of EN standard

SIST EN 3672:2008

Thread code (see Table 1) <https://standards.iteh.ai/catalog/standards/sist/61269fa7-1986-4836-907a-e939e4f9ad11/sist-en-3672-2008>

If necessary the originator code I9005 shall be placed between the description block and the identity block.

5 Marking

EN 2424, Style A, as indicated in Figure 1.

6 Technical specification

According to EN 3005.