

SLOVENSKI STANDARD

SIST EN 3626:2009

01-maj-2009

5 YfcbUj H_U!`A UhWzYgfcVYzgUa cnUd]fUbYz`Y`YbYzdfYj`Y`YbY`g`_UXa]`Ya ž
bUa UhUbYn`AcG&!`?`Ug]Z_UW`U`%\$`ADUfblf]`hYa dYfUh f]`c_c`JW`z`&`)`š`

Aerospace series - Nuts, hexagon, self-locking in steel, cadmium plated, MoS2 lubricated - Classification: 1 100 MPa (at ambient temperature)/235 °C

Luft- und Raumfahrt - Sechskantmuttern, selbstsichernd, aus Stahl, verkadmet, MoS2-
geschmiert - Klasse: 1 100 MPa (bei Raumtemperatur)/235 °C

item STANDARD PREVIEW

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Série aérospatiale - Ecrous hexagonaux, à freinage interne, en acier, cadmiés, lubrifiés
MoS2 - Classification: 1 100 MPa (à température ambiante)/235 °C

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Ta slovenski standard je istoveten z: EN 3626:2006

ICS:

49.030.30 Matrice Nuts

SIST EN 3626:2009 **en,de**

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EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

EN 3626

July 2006

ICS 49.030.30

English Version

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cadmium plated, MoS₂ lubricated - Classification: 1 100 MPa (at
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aus Stahl, verkadmet, MoS₂-geschmiert - Klasse: 1 100
MPa (bei Raumtemperatur)/235 °C

This European Standard was approved by CEN on 9 March 2006.

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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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 Central Secretariat has the same status as the official versions.
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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
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Foreword

This European Standard (EN 3626:2006) 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 January 2007, and conflicting national standards shall be withdrawn at the latest by January 2007.

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, 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.

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1 Scope

This standard specifies characteristics of self-locking hexagonal nuts, with flange, in steel, cadmium plated, MoS₂ lubricated.

Classification: 1 100 MPa¹⁾ / 235 °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 2133, Aerospace series — Cadmium plating of steels, with specified tensile strength $\leq 1\ 450\ MPa$, copper, copper alloys and nickel alloys

EN 2424, Aerospace series — Marking of aerospace products

EN 2491, Aerospace series — Molybdenum disulphide dry lubricants — Coating methods

EN 9100, Aerospace series - Quality management systems - Requirements (based on ISO 9001:2000) and Quality systems - Model for quality assurance in design, development, production, installation and servicing (based on ISO 9001:1994)

EN 9133, Aerospace series — Quality management systems — Qualification procedure for aerospace standard parts

ISO 5855-2, Aerospace — MJ threads — Part 2: Limit dimensions for bolts and nuts
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ISO 5858, Aerospace — Self-locking nuts with maximum operating temperature less than or equal to 425 °C — Procurement specification

ISO 7995, Aerospace — Nuts, hexagonal, self-locking, with MJ threads, classifications: 1 100 MPa (at ambient temperature)/315 °C and 1 100 MPa (at ambient temperature/425 °C — Dimensions

ISO 8788 Aerospace — Fasteners — Tolerances of form and position

TR 3791, Aerospace series — Materials for all metal self-locking nuts and thin wall insert of temperature classes $\leq 425\ ^\circ C$ ³⁾

- 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 temperature that the nut is able to withstand, without permanent alteration to its original characteristics, after ambient temperature has been restored. The maximum temperature is conditioned by the cadmium plating.
- 3) Published ASD 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: in conformity with ISO 7995, expressed in millimetres and apply after cadmium plating but before MoS₂ lubricating.

Details of form not stated are at the manufacturer's option.

3.2 Tolerances of form and position

See ISO 8788.

3.3 Materials

See TR 3791.

3.4 Surface treatments

EN 2133, 5 µm min. on threads and all surfaces which can be contacted by a 20 mm diameter ball. On all other surfaces, a continuous deposit shall be present.

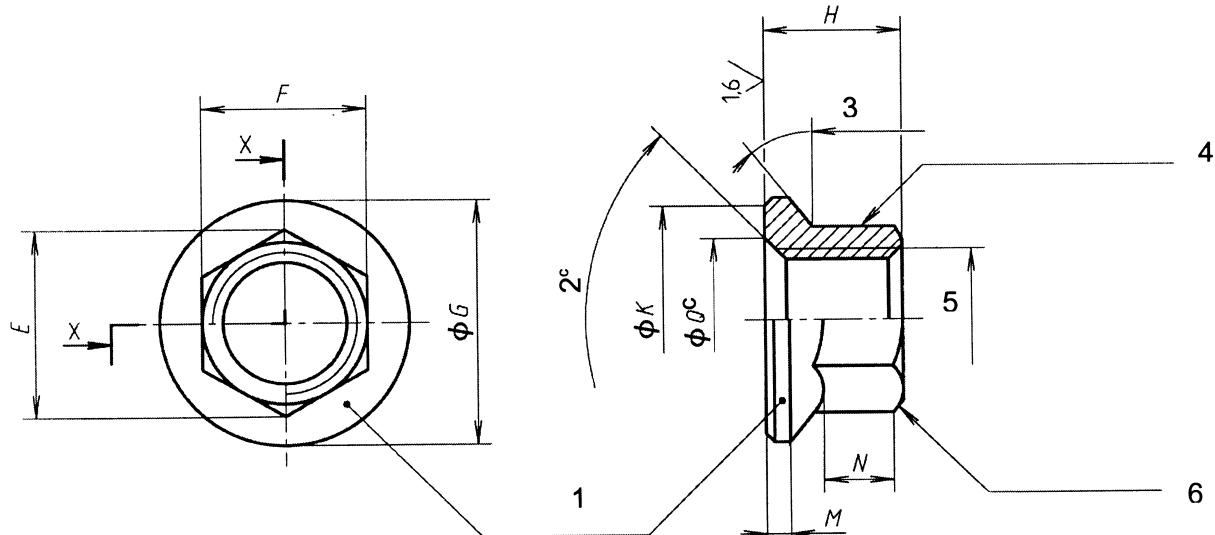
EN 2491, thickness not specified. (standards.iteh.ai)

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$$6,3 \checkmark \quad [\quad 1,6 \checkmark \quad] \text{ a}$$

Remove sharp edges 0,1 to 0,4



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Key

1 Marking 2 90° to 120° 3 0° to 50°
4 Form out-of-round in this area to achieve the self-locking torque requirement^b
5 Thread 6 Chamfer, radius or broken edge

^a These values in micrometres apply before surface treatment. They do not apply to threads and sheared edges the surface texture of which will be as achieved by usual manufacturing methods.
^b Tooling marks are permitted in this area.
^c All forms of entry (chamfer or radius) are permissible within these limiting dimensions.

Figure 1

Table 1

Diameter code	Thread ^a	E ^b min.	F ^b	G max.	H max.	K min.	M min.	N ^c min.	Q		Mass ^d	
									max.	min.		
030	MJ3x0,5-4H6H	4,2	4	h12	6	3	5,3	0,4	1,2	3,8	3,2	0,35
040	MJ4x0,7-4H6H	5,3	5		7,4	4	6,7	0,5	1,5	4,8	4,2	0,7
050	MJ5x0,8-4H6H	6,5	6		9,1	5	8,3	0,6	2	5,8	5,2	1,05
060	MJ6x1-4H5H	7,6	7		10,6	5,4	9,8	0,7	2,3	7,1	6,3	1,5
070	MJ7x1-4H5H	8,7	8		12,1	6,3	11,3	0,8	2,7	8,1	7,3	2,45
080	MJ8x1-4H5H	10,9	10	h13	13,6	7,2	12,8	0,9	3,2	9,1	8,3	3,6
100	MJ10x1,25-4H5H	13,2	12		16,8	9	15,8	1,1	3,8	11,1	10,3	6,25
120	MJ12x1,25-4H5H	15,5	14		19,9	10,8	18,8	1,4	4,5	13,5	12,3	10,35
140	MJ14x1,5-4H5H	17,9	16		23	12,6	21,9	1,7	5	15,1	14,3	13,2

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

b) These dimensions apply before forming out-of-round, but finished nuts shall fit a standard socket wrench in accordance with ISO 3855-2. In the self-locking zone the tolerances apply before forming out-of-round.

c Wrench pad engagement

^d Approximate values (kg/1 000 pieces), given for information purposes only.