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**Aeronavtika - Stožčaste mazalke, aksialne, iz korozijsko odpornega jekla, pasivirane**

Aerospace series - Nipples, lubricating, axial type, in corrosion resisting steel, passivated

Luft- und Raumfahrt - Kegel-Schmiernippel, aus korrosionsbeständigem Stahl, passiviert

Série aéronautique - Graisseurs à accrochage axial, en acier résistant à la corrosion, passivés

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**ICS:**

49.035

Sestavni deli za letalsko in  
vesoljsko gradnjo

Components for aerospace  
construction

**SIST EN 3908:2017**

**en,fr,de**

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EUROPEAN STANDARD  
NORME EUROPÉENNE  
EUROPÄISCHE NORM

EN 3908

January 2017

ICS 49.035

English Version

Aerospace series - Nipples, lubricating, axial type, in  
corrosion resisting steel, passivated

Série aérospatiale - Graisseurs à accrochage axial, en  
acier résistant à la corrosion, passivés

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korrosionsbeständigem Stahl, passiviert

This European Standard was approved by CEN on 11 March 2016.

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

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

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## European foreword

This document (EN 3908:2017) 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 European 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of an identical text or by endorsement, at the latest by July 2017, and conflicting national standards shall be withdrawn at the latest by July 2017.

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, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

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## 1 Scope

This European Standard specifies the required characteristics and the tests for lubricating nipples of the axial type, in corrosion resisting steel, passivated. Annex A (normative) states the clearance space requirements for the coupling and uncoupling of the lubricating gun and the maximum permissible diameter of the lubricating gun barrel, together with installation thread requirements.

Lubricating nipples according to this European Standard are intended for use in aerospace assemblies, where regular lubrication of moving parts is required.

## 2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. 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 2516, *Aerospace series — Passivation of corrosion resisting steels and decontamination of nickel base alloys*

EN 9100, *Quality Management Systems — Requirements for Aviation, Space and Defense Organizations*

ISO 68 (all parts), *ISO general purpose screw threads — Basic profile*

ISO 413, *Aircraft — Heads of lubricating nipples*

ISO 965-2, *ISO general purpose metric screw threads — Tolerances — Part 2: Limits of sizes for general purpose external and internal screw threads — Medium quality*

ISO 2859-1, *Sampling procedures for inspection by attributes — Part 1: Sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection*

ISO 6507-1, *Metallic materials — Vickers hardness test — Part 1: Test method*

STANAG 1135:2008, *Interchangeability of fuels, lubricants and associated products used by the armed forces of the North Atlantic Treaty Nations* <sup>1)</sup>

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<sup>1)</sup> Published by: North Atlantic Treaty Organization (NATO), Military Agency for Standardization (MAS), 1110 Brussels, Belgium.

### 3 Required characteristics

#### 3.1 Configuration – Dimensions – Masses

The envelope dimensions for the nipple head are shown in Figure 1, detail "Z" and are in accordance with ISO 413. The tip design of the nipple (face with the sealing ball) is left at the manufacturer's option provided the profile remains within the envelope dimensions shown in figure 1 and the requirements of Clause 7 are met.

The dimensions apply after surface treatment.

A check valve (composed of a spring and ball) shall be located at the surface of the nipple to prevent the ingress of foreign matter into the nipple tip. Other internal design shall be at the manufacturer's discretion provided the nipples meet the requirements specified in Clause 7.

#### 3.2 Surface roughness

$R_a = 6,3 \mu\text{m}$  unless otherwise specified. The values apply prior to surface treatment.

The surface roughness of the thread will be as achieved by normal methods of manufacture.

#### 3.3 Materials

Austenitic chromium-nickel steel; ultimate strength min. 550 MPa. See also 7.6.2.

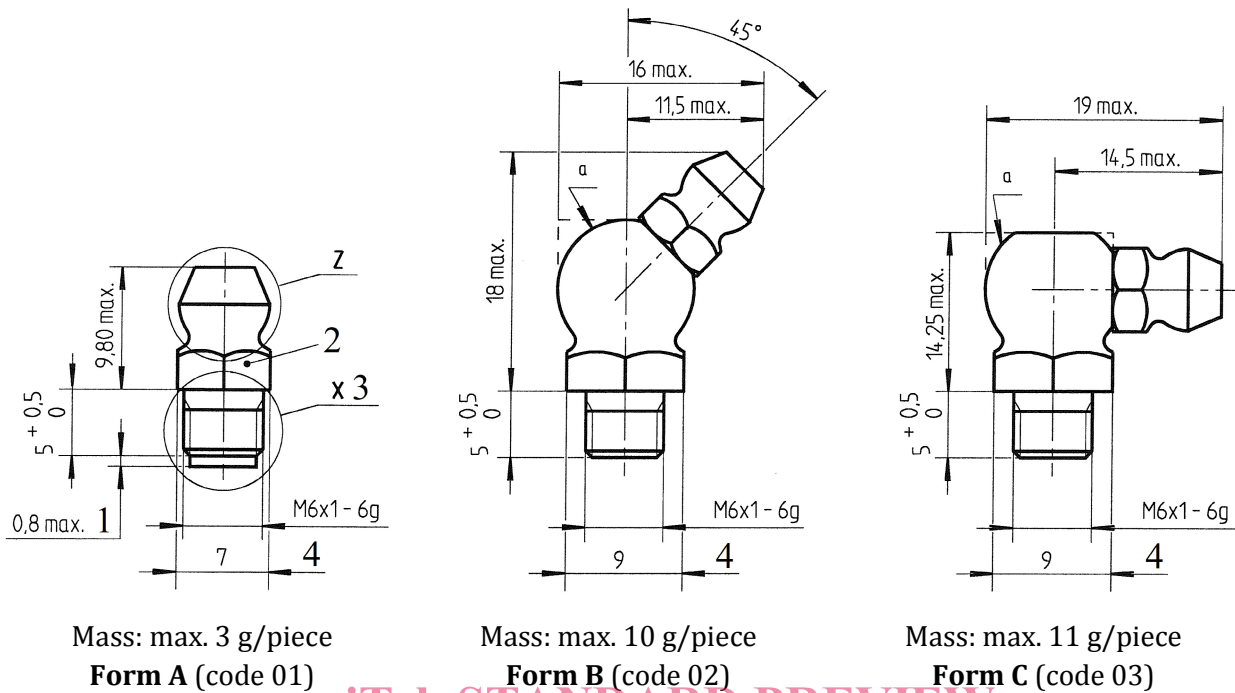
The nipple head surface shall be case hardened to a depth of 0,08 mm to 0,13 mm to give a minimum hardness value of HV 533 (52 HRC). The nipple body shall withstand a tightening torque of 9 Nm without strain.

Material and surface treatment for the internal parts of the nipple shall be at the manufacturer's option.

#### 3.4 Surface treatment

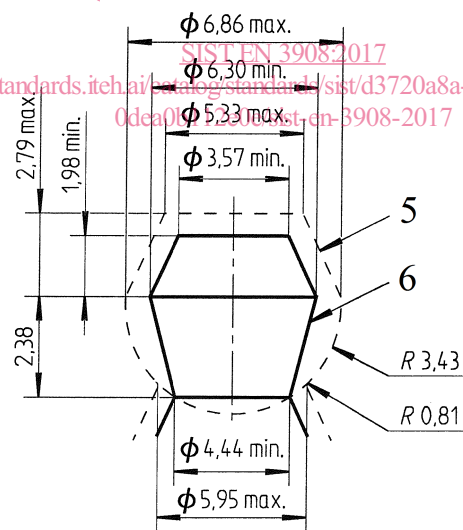
EN 2516, process appropriate to the material

Dimensions in millimetres



**Form A (code 01)**  
**Form B (code 02)**  
**Form C (code 03)**

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## Key

- 1 At manufacturer's option
- 2 Marking area (for forms A, B and C)
- 3 Detail X: see Figure 2.
- 4 Across flats
- 5 Maximum contour (broken line)
- 6 Minimum contour (continuous line)
- a Shape optional

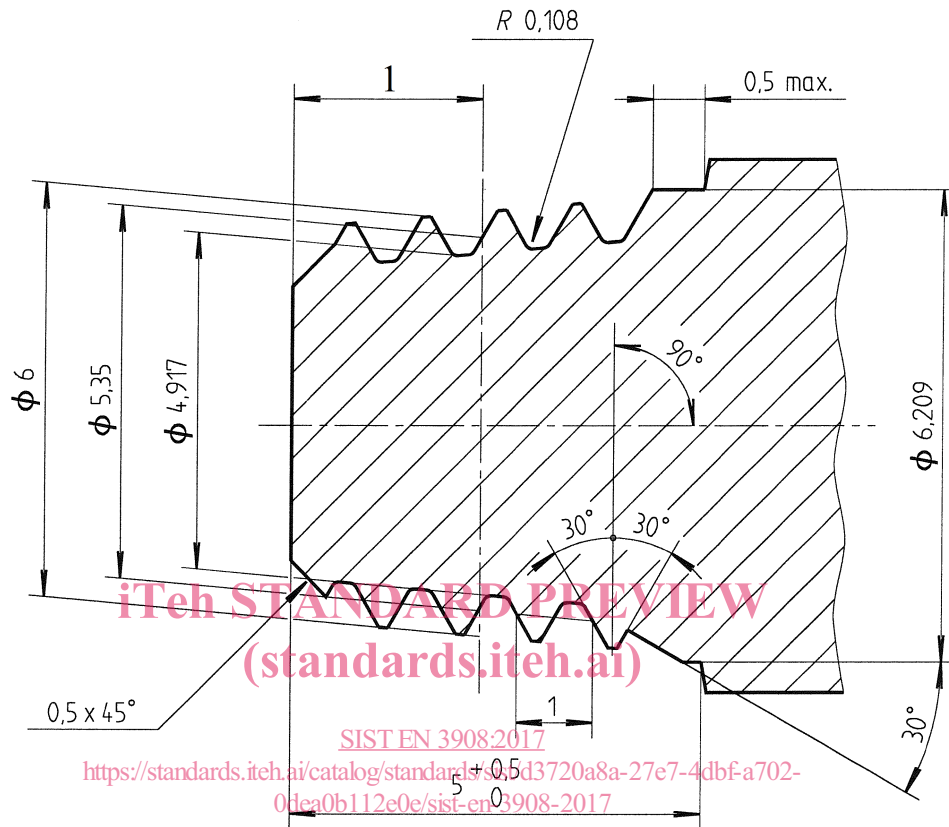
**Figure 1**



### 3.5 Thread

The thread shall be tapered as shown in Figure 2 and conform with ISO 68 and ISO 965-2.

Dimensions in millimetres



### Key

1 1 to 2

Figure 2 — Detail X of Figure 1

## 4 Designation

EXAMPLE

Description block	Identity block
NIPPLE	EN3908-01
Number of this standard	
Form code of nipple (see Figure 1)	

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