



**SLOVENSKI STANDARD**  
**SIST EN 3852:2004**

01-maj-2004

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**Aerospace series - Pipe couplings, 60°, spherical, in titanium alloy TI-P64001 - Straight unions, welded, threaded**

Aerospace series - Pipe couplings, 60°, spherical, in titanium alloy TI-P64001 - Straight unions, welded, threaded

Luft- und Raumfahrt - Rohrverschraubungen mit Kugelbuchsen, 60 °, aus Titanlegierung TI-P64001 - Gerade Verschraubungen zum Anschweißen

IPCS STANDARD PREVIEW  
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SIST EN 3852:2004

Ta slovenski standard je istoveten z: **EN 3852:2002**

<https://standards.iteh.ai/catalog/standards/sist/9f5d9004-a31b-4154-9209-c9c2c623b6aa/sist-en-3852-2004>

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**ICS:**

49.080 Štečajev sistemov za letalstvo in zračne sile  
Člani sistema za letalstvo in zračne sile Aerospace fluid systems and components

**SIST EN 3852:2004**

**en**

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EUROPEAN STANDARD  
NORME EUROPÉENNE  
EUROPÄISCHE NORM

**EN 3852**

November 2002

ICS 49.080

English version

**Aerospace series - Pipe couplings, 60°, spherical, in titanium alloy TI-P64001 - Straight unions, welded, threaded**

Série aérospatiale - Raccords sphériques, 60°, en alliage de titane TI-P64001 - Raccords droits, soudés, filetés

This European Standard was approved by CEN on 30 August 2002.

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 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 Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Malta, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

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

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## Foreword

This document (EN 3852:2002) has been prepared by the European Association of Aerospace Manufacturers – Standardization (AECMA-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 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 May 2003, and conflicting national standards shall be withdrawn at the latest by May 2003.

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

## 1 Scope

### iTeh STANDARD PREVIEW

This standard specifies the characteristics of threaded welded straight unions for pipe couplings, 60°, spherical, in TI-P64001, for aerospace applications. ([standards.iteh.ai](https://standards.iteh.ai))

NOTE Assembly in accordance with TR 4052. [SIST EN 3852:2004](https://standards.iteh.ai/catalog/standards/sist/9f5d9004-a31b-4154-9209-e9c2c823b6aa/sist-en-3852-2004)

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## 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 (including amendments).

- ISO 286-2 *ISO system of limits and fits - Part 2: Tables of standard tolerance grades and limit deviations for holes and shafts.*
- ISO 5855-3 *Aerospace - MJ Threads - Part 3 –Limit dimensions for fittings for fluid systems.*
- EN 2000 *Aerospace series - Quality assurance - EN aerospace products - Approval of the quality system of manufacturers.*
- EN 2424 *Aerospace series - Marking of aerospace products.*
- EN 2530 *Aerospace series - Titanium alloy TI-P63 - Annealed -  $900\text{ MPa} \leq R_m \leq 1160\text{ MPa}$  - Bars  $D_e \leq 150\text{ mm}$ <sup>1)</sup>.*
- EN 2656 *Aerospace series - Pipe coupling – Coupling end, welded – Geometric configuration.*
- TR 4052 *Aerospace series - Pipe couplings, 60°, spherical, in titanium alloy - Assembly recommendations*<sup>2)</sup>.

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

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

EN 3852:2002 (E)

### 3 Required characteristics

#### 3.1 Configuration - Dimensions – Tolerances

See Figure 1 and Table 1. Dimensions and tolerances are in millimetres.

#### 3.2 Material

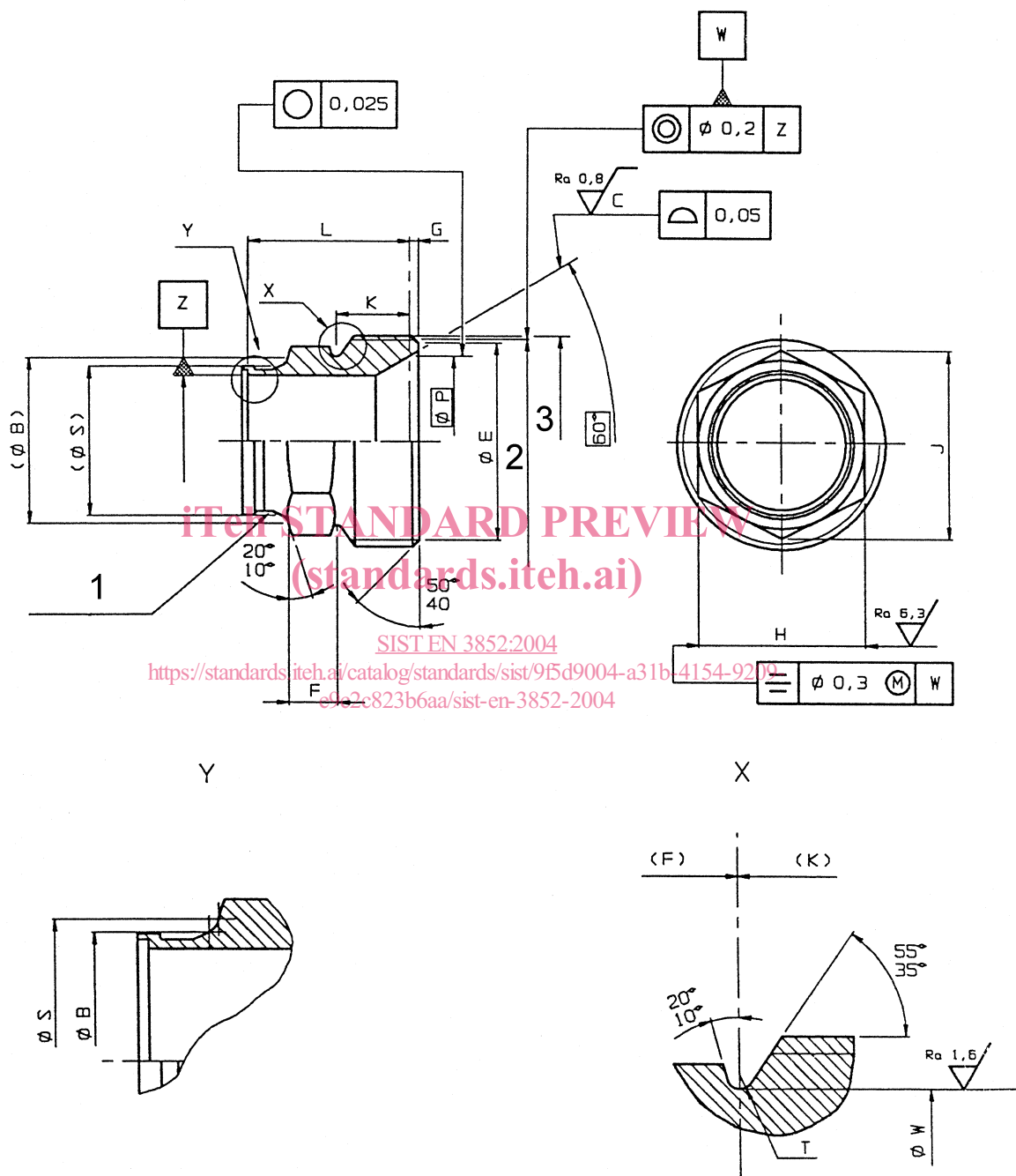
EN 2530

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$Ra\ 3,2 / \left( Ra\ 6,3 / Ra\ 1,6 / Ra\ 0,8 \right)$  4  
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**Key**

- 1 Marking
- 2 Pitch diameter
- 3 Thread
- 4 Thread's surface will be achieved by normal methods of manufacture.
- 5 Remove sharp edges 0,1 to 0,4

Figure 1

Table 1

Dimensional code	Tube		Thread <sup>a</sup>	B h14 <sup>b</sup>	C +0,1 0	D +0,1 0	E +0,3 0	F +0,3 0	G +0,2 0	H h 13 <sup>b</sup>	J min.	K +0,3 0	L +0,2 0	M +0,1 0	N +0,1 0	P	S ± 0,3	T ± 0,2	U +0,1 0	V +0,1 0	W h 14 <sup>b</sup>	
	Nominal diameter	Thickness																				
040060	4	0,6	MJ10X1-4g6g	5	2,8	4	8,6	4	0,9	7	7,7	5,5	16	1,4	0,7	6,2	6,7	1	4,1	4,9	6	
040080		0,8			2,4																	5,1
040100		1			2																	6
060060	6	0,6 <sup>c</sup>	MJ14X1,5-4g6g	7	4,8	6	12	4,5	10	11	8,7	20	1,4	0,7	9	9,7	1	6,1	6,9	9		
060080		0,8			4,4																7,1	
060100		1			4																8	
080060	8	0,6 <sup>c</sup>	MJ16X1,5-4g6g	9	6,8	8	14	5	12	13,2	8,5	20	1,4	0,7	11	11,7	1	8,1	8,9	11		
080080		0,8 <sup>c</sup>			6,4																9,1	
080100		1			6																8	
100060	10	0,6	MJ18X1,5-4g6g	11,5	8,8	10	16	6	13	14,3	9,1	21	1,4	0,7	13	12,7	1	10,1	10,9	12		
100080		0,8 <sup>c</sup>			8,4																11,1	
100100		1 <sup>c</sup>			8																10	
120060	12	0,6 <sup>c</sup>	MJ20X1,5-4g6g	13,5	10,8	12	18	6,5	15	16,5	9,5	22	1,6	0,8	15	14,7	1,2	12,1	12,9	13,8		
120080		0,8			10,4																13,1	
120100		1			10																12	
140060	14	0,6	MJ22X1,5-4g6g	15,5	12,8	14	20	6,5	17	18,9	9,7	22	1,6	0,8	17	16,7	1,4	14,1	14,9	15,6		
140080		0,8 <sup>c</sup>			12,4																15,1	
140100		1 <sup>c</sup>			12																14	
160060	16	0,6 <sup>c</sup>	MJ24X1,5-4g6g	17,5	14,8	16	22	7	19	21,1	10,5	23	1,8	0,9	19	18,7	1,6	16,1	16,9	17,6		
160080		0,8			14,4																17,1	
160100		1 <sup>c</sup>			14																16	
180060	18	0,6	MJ27X1,5-4g6g	19,5	16,8	18	25	7	22	24,5	9,8	23	1,8	0,9	21,6	21,7	1,6	18,1	18,9	20,4		
180080		0,8			16,4																19,1	
180100		1 <sup>c</sup>			16																18	
200060	20	0,6 <sup>c</sup>	MJ30X1,5-4g6g	21,5	18,8	20	28	7,5	24	26,8	10,5	24	2	1	24,2	23,7	1,8	20,1	20,9	22,4		
200080		0,8			18,4																21,1	
200100		1			18																20	
250080	25	0,8 <sup>c</sup>	MJ36X1,5-4g6g	26,5	23,4	25	34	7,5	27	30,1	10,7	24	2	1	29,8	27,7	1,8	25,1	26,1	27,4		
250100		1			23																25	

<sup>a</sup> In accordance with ISO 5855-3

<sup>b</sup> Tolerance in accordance with ISO 286-2

<sup>c</sup> Welding preparation in accordance with EN 2656