



**SLOVENSKI STANDARD
SIST EN 3854:2004**

01-maj-2004

Aerospace series - Pipe couplings, 60°, spherical in titanium alloy TI-P64001 - Ferrules, welded

Aerospace series - Pipe couplings, 60°, spherical in titanium alloy TI-P64001 - Ferrules, welded

Luft- und Raumfahrt - Rohrverschraubungen mit Kugelbuchsen, 60°, aus Titanlegierung TI-P 64001 - Sutzen zum Anschweißen

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[SIST EN 3854:2004](https://standards.iteh.ai/catalog/standards/sist/5c75290-cbec-4407-8be8-7c128cc72d61/sist-en-3854-2004)

Ta slovenski standard je istoveten z: **EN 3854:2002**

ICS:

49.080

Številni sistemi za prenos tekočin in plinov v letalstvu
Člani in delci

Aerospace fluid systems and components

SIST EN 3854:2004

en

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EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

EN 3854

November 2002

ICS 49.080

English version

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

Série aérospatiale - Raccords sphériques, 60°, en alliage
de titane TI-P64001 - Olives à souder

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 3854:2002) 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.

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1 Scope

This standard specifies the characteristics of welded ferrules for pipe couplings, 60°, spherical, in TI-P64001, for aerospace applications.

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NOTE Assembly in accordance with TR 4052 <https://standards.iteh.ai/catalog/standards/sist/5c75290-cbec-4407-8be8-7c128ec72d61/sist-en-3854-2004>

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).

EN 2000	<i>Aerospace series - Quality assurance - EN aerospace products - Approval of the quality system of manufacturers.</i>
EN 2424	<i>Aerospace series - Marking of aerospace products.</i>
EN 2530	<i>Aerospace series - Titanium alloy TI-P63 - Annealed - $900 \text{ MPa} \leq R_m \leq 1160 \text{ MPa}$ - Bars $D_e \leq 150 \text{ mm}$ ¹⁾.</i>
EN 2656	<i>Aerospace series – Pipe coupling – Coupling end, welded – Geometric configuration.</i>
TR 4052	<i>Aerospace series - Pipe couplings, 60°, spherical, in titanium alloy - Assembly recommendations ²⁾.</i>

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 3854:2002 (E)

3 Required characteristics

3.1 Configuration – Dimensions – Tolerances – Masses

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

3.2 Material

EN 2530

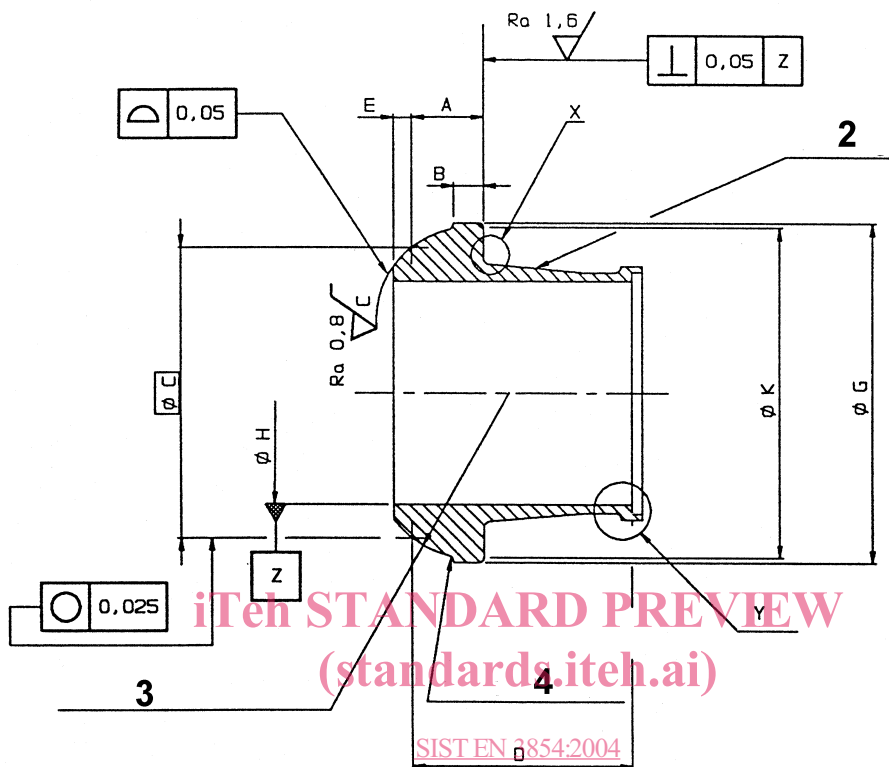
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Ra 3,2 / (Ra 1,6 / Ra 0,8 / c)

1



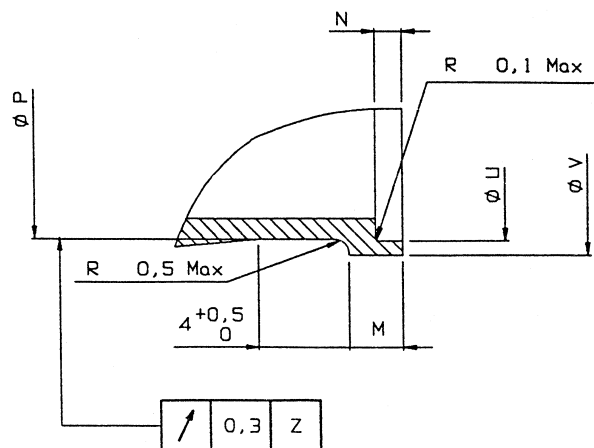
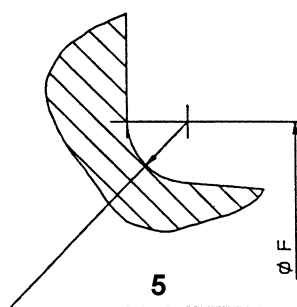
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X

Y



Key

- 1 Remove sharp edges 0,1 to 0,4
- 2 Marking
- 3 Spherical radius : S
- 4 R 0,9 to 1,3
- 5 R 0,3 to 0,5

Figure 1

Table 1

Dimensional code	Tube		A	B	C	D	E	F	G		H	K ^a	M	N	P	S	U	V	Mass ^b
	Nominal diameter	Thickness	+0,2 0	+0,1 0		+0,3 0	0 -0,2	h13	nom.	Tol.			+0,1 0	+0,1 0	+0,1 0		+0,1 0	+0,1 0	
040060	4	0,6	3,6	1	6,2	16	1,1	6	8,1	0	2,8	7,2			4	3,6	4,1	4,9	1,4
040080		0,8									5,1								
040100		1																	
060060	6	0,6 ^c	4,6	1,6	9	17		8	12,2	0	4,8	11,3			6	5,25	6,1	6,9	2,8
060080		0,8									7,1								
060100		1																	
080060	8	0,6 ^c	4,6	1,6	11			10	14,2	0	6,8	13,3	1,4	0,7	8	6,5	8,1	8,9	3,8
080080		0,8 ^c									9,1								
080100		1																	
100060	10	0,6	4,6	1,6	13			12,5	16,2	0	8,8	15,3			10	7,5	10,1	10,9	4,9
100080		0,8 ^c									11,1								
100100		1 ^c																	
120060	12	0,6 ^c	6	2,5	15	18,5	1,5		14,5	18,2	10,8	17,3	1,6	0,8	12	8,5	12,1	12,9	6,6
120080		0,8									13,1								
120100		1																	
140060	14	0,6	6	2,5	17	18,5	1,5		16,5	20,2	12,8	19,3	1,6	0,8	14	9,75	14,1	14,9	7,7
140080		0,8 ^c									15,1								
140100		1 ^c																	
160060	16	0,6 ^c	6	2,5	19	18,5	1,5		18,5	22,2	14,8	21,3	1,6	0,8	16	11	16,1	16,9	8,8
160080		0,8									17,1								
160100		1 ^c																	
180060	18	0,6	6	2,5	21,6	18,5	1,5		20,5	25,2	16,8	24,2	1,8	0,9	18	12,5	18,1	18,9	10,7
180080		0,8									19,1								
180100		1 ^c																	
200060	20	0,6 ^c	6	2,5	24,2	18,5	1,5		22,5	28,2	18,8	27,2	1,8	0,9	20	14	20,1	20,9	12,9
200080		0,8									21,1								
200100		1																	
250080	25	0,8 ^c	7,6	2,5	29,8	20	1,5		27,5	34,2	23,4	33,2	2	1	25	17	25,1	26,1	19,7
250100		1																	

^a Minimum bearing diameter

^b Mass ≈ quoted in kg/ 1000 parts

^c Welding preparation in accordance with EN 2656