



SLOVENSKI STANDARD

SIST EN 3914:2008

01-september-2008

Aeronavtika - Vložki, tanka stena, samozapiralni, dolgi, iz toplotnoodporne zlitine na nikljevi osnovi NI-PH2601 (NI-P100HT, Inconel 718), posrebrnen notranji navoj, za popraviljanje sestavnih delov

Aerospace series - Insert, thin wall, self-locking, long, in heat resisting nickel base alloy NI-PH2601 (NI-P100HT, Inconel 718), silver plated on internal thread, for salvage of components

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Luft- und Raumfahrt - Gewindeeinsätze, dünnwandig, selbstsichernd, lang, aus hochwarmfester Nickelbasislegierung NI-PH2601 (NI-P100HT, Inconel 718), Innengewinde versilbert, zur Nacharbeit von Bauteilen

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Série aérospatiale - Douilles filetées, à paroi mince, à freinage interne, longues, en alliage résistant à chaud à base de nickel NI-PH2601 (NI-P100HT, Inconel 718), argentées sur filetage intérieur, pour récupération

Ta slovenski standard je istoveten z: EN 3914:2008

ICS:

49.030.30

Matice

Nuts

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ICS 49.030.30

English Version

**Aerospace series - Insert, thin wall, self-locking, long, in heat
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This European Standard was approved by CEN on 29 February 2008.

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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 Management Centre has the same status as the official versions.

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Foreword

This document (EN 3914:2008) 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of an identical text or by endorsement, at the latest by November 2008, and conflicting national standards shall be withdrawn at the latest by November 2008.

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.

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Introduction

For design, installation and removal procedures, see EN 3298 and EN 3916.

1 Scope

This standard specifies the characteristics of long self locking, thin wall salvage inserts, in NI-PH2601 (NI-P100HT), with silver plated internal thread, for aerospace applications.

Maximum test temperature 550 °C.

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 2404*, *Heat resisting nickel base alloy NI-P100HT — Solution treated and precipitation treated — Bars — Aerospace series* ¹⁾

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

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

TR 3198, *Aerospace series — Manufacturer's identification monograms for EN aerospace products* ²⁾

EN 3298, *Aerospace series — Inserts, thin wall, self-locking — Installation and removal procedure*

EN 3915, *Aerospace series — Inserts, thin wall, self-locking, MJ threads, in heat resisting nickel base alloy NI-PH2601 (NI-P100HT, Inconel 718), for salvage of components — Classification: 1 275 MPa (at ambient temperature) / 550 °C — Technical specification*

EN 3916, *Aerospace series — Insert, thin wall — Salvage procedure for components* ³⁾

EN 4376, *Aerospace series — Heat resisting alloy NI-PH2601 (NiCr19Fe19Nb5Mo3) — Solution treated and precipitation treated — Bar and section — $D_e \leq 200$ mm* ³⁾

EN 4377, *Aerospace series — Heat resisting alloy NI-PH2601 (NiCr19Fe19Nb5Mo3) — Non heat treated — Forging stock — a or $D \leq 300$ mm* ³⁾

ISO 965-1, *ISO general purpose metric screw threads — Tolerances — Part 1: Principles and basic data*

ISO 5855-2, *Aerospace — MJ threads — Part 2: Limit dimensions for bolts and nuts*

* Inactive for new design, see EN 4376 and EN 4377.

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

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

3) Published as ASD Prestandard at the date of publication of this standard.

3 Required characteristics

3.1 Configuration - Dimensions - Tolerances - Masses

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

3.2 Material

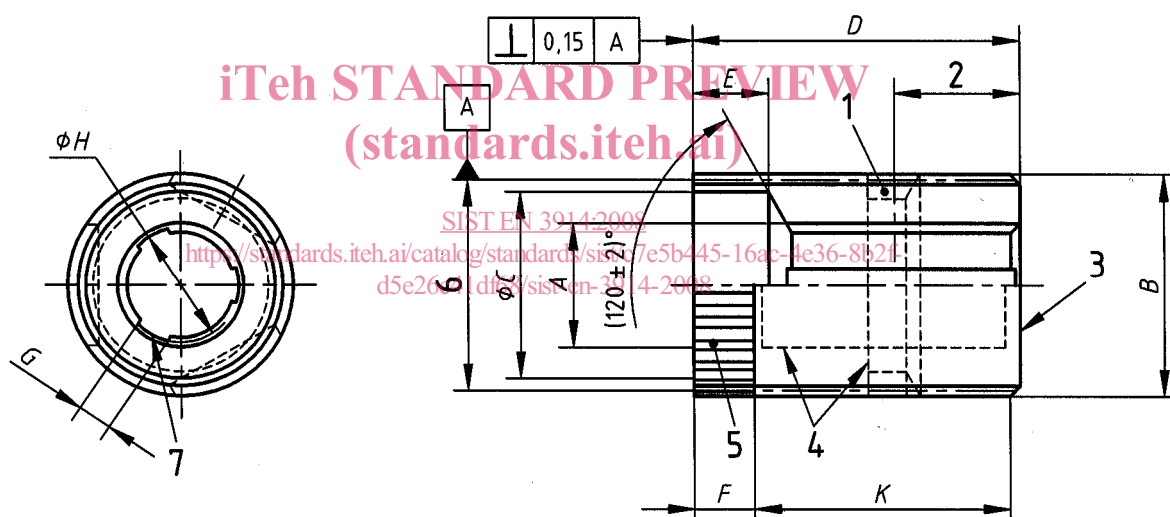
EN 2404

3.3 Surface treatment

EN 2786 on internal thread and counterbore diameter C .

Thickness:

- Internal threads \geq MJ6: 5 μm min. on thread flanks;
- Internal threads MJ5: shall show complete coverage, without thickness requirement;
- Counterbore diameter C : shall show complete coverage, without thickness requirement.



Key

- 1 Form may be produced out of round in this area (approx mid length of internal thread) to achieve self locking requirement tool marks permissible
- 2 Thread lock mid length (internal thread)
- 3 Manufacturer's identity mark here
- 4 Internal thread facilitated by either axial or radial groove or grooves, method optional
- 5 Knurl across threads to produce J serrations
- 6 Thread pitch diameter
- 7 3 slots equi spaced

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

Remove sharp edges 0,1 to 0,4.

R_a Values apply before silver plating.

Figure 1

Table 1

Code	A	B		Ø C	D	E	F	G	Ø H	J	Mass ≈ kg/1 000 pieces
	Internal thread ^a Designation	External thread ^b Designation	Max. minor diameter								
050	MJ5 × 0,8-4H6H	M9 × 1-4g	8,056	+ 0,12 0	± 0,3	+ 0,26 0	+ 0,26 0	min.	min.	27	4,398
060	MJ6 × 1-4H5H	M10 × 1-4g	9,056	8,36	15,95	2,42	1,90	1,50	5,44	28	6,213
070	MJ7 × 1-4H5H	M11 × 1-4g	10,110	9,40	18,35	2,42	1,90	1,75	6,44	32	8,256
080	MJ8 × 1-4H5H	M12 × 1-4g	11,110	10,39	20,75	2,42	1,90	2,00	7,28	33	10,931
100	MJ10 × 1,25-4H5H	M14 × 1-4g	13,116	12,40	25,45	3,05	2,42	2,50	9,14	40	17,780

^a Threads conform to ISO 5855-2. In the self-locking zone the tolerances apply before forming out of round.
^b Threads conform to ISO 965-1, except maximum minor diameter which shall be as stated.

Percentage thread loss values listed below in mm³ refer to the maximum amount of thread that can be removed to enable the facilitation of internal thread locking. These values are obtained from the volume of thread available which is defined as being the circumferential volume of thread over length K (see Figure 1 and Table 2).

Table 2

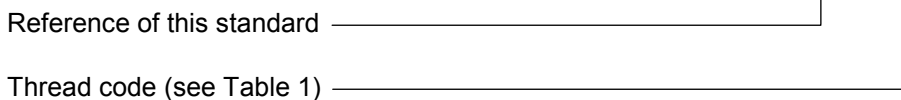
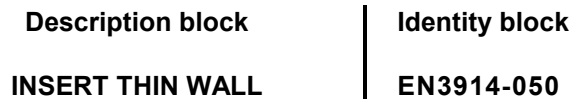
Code	050	060	070	080	100
% Thread loss	31	26	21	17	14

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4 Designation

EXAMPLE



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

5 Marking and identification

EN 2424, style G

Manufacturer's identification grooves shall be V - section 0,1 to 0,2 deep, as indicated in Figure 1. For spacing see TR 3198 List 3.

6 Technical specification

EN 3915