SLOVENSKI STANDARD
SIST EN 4634:2009

01-oktober-2009

Aeronavtika - Vijaki, 100° ugrezna glava, šestzoba vdolbina, kratek navoj, iz toplotnoodpornega jekla FE-PA2601 (A286), pasivirani - Klasifikacija: 900 MPa (pri temperaturi okolice)/650 °C

Aerospace series - Screws, 100° countersunk head, six lobe recess, short thread, in heat resisting steel FE-PA2601 (A286), passivated - Classification: 900 MPa (at ambient temperature)/650 °C

Luft- und Raumfahrt – 100° Senkschrauben, kurzes Gewinde, Sechs-Bogenzahn, aus hochwarmfester Stahl FE-PA2601 (A286), passiviert - Klasse: 900 MPa (bei Raumtemperatur)/650° C

Série aérospatiale - Vis, 100° à tête fraisée, à filetage court, à empreinte six lobes, en acier résistant à chaud FE-PA2601 (A286), passivées - Classification: 900 Mpa (à température ambiante)/650°C

Ta slovenski standard je istoveten z: **EN 4634:2009**

ICS:

49.030.20	Sorniki, vijaki, stebelni vijaki	Bolts, screws, studs

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EUROPEAN STANDARD

NORME EUROPÉENNE

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English Version

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

Management Centre: Avenue Marnix 17, B-1000 Brussels

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Foreword

This document (EN 4634:2009) 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of an identical text or by endorsement, at the latest by January 2010, and conflicting national standards shall be withdrawn at the latest by January 2010.

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1 Scope

This standard specifies the characteristics of screws with 100° countersunk head, with six lobes recess, short thread, in heat resisting steel FE-PA2601, passivated, for aerospace applications.

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.

ISO 3353-1, *Aerospace — Lead and runout threads — Part 1: Rolled external threads.*

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

ISO 7913, *Aerospace — Bolts and screws, metric — Tolerances of form and position.*

EN 2399, *Aerospace series — Heat resisting steel FE-PA2601 (X4NiCrTiMoV26-15) — Rm ≥ 900 MPa — Bars for forged bolts D ≤ 25 mm.*

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

EN 2516, *Aerospace series — Passivation of corrosion resisting steels and decontamination of nickel base alloys.*

EN 2576, *Aerospace series — Bolts in heat resisting steel FE-PA92HT (A286) — Classification: 900 MPa/650 °C — Technical specification.* [1)]

EN 3639, *Aerospace series — Heat resisting alloy FE-PA2601 — Softened and cold worked — Wire for forged fasteners — D ≤ 15 mm - 900 MPa ≤ R_m ≤ 1100 MPa.* [1)]

EN 3911, *Aerospace series — Six lobe recess — Geometrical definition*. [1)]

TR 3775, *Aerospace series — Bolts and pins — Materials*. [2)]

3 Required characteristics

3.1 Configuration – Dimensions – Tolerances – Masses

See Figure 1 and Table 1.

Dimensions and tolerances are in millimetres and apply after surface treatment.

3.2 Materials

EN 2399, EN 3639, TR 3775

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

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

3.3 Surface treatment

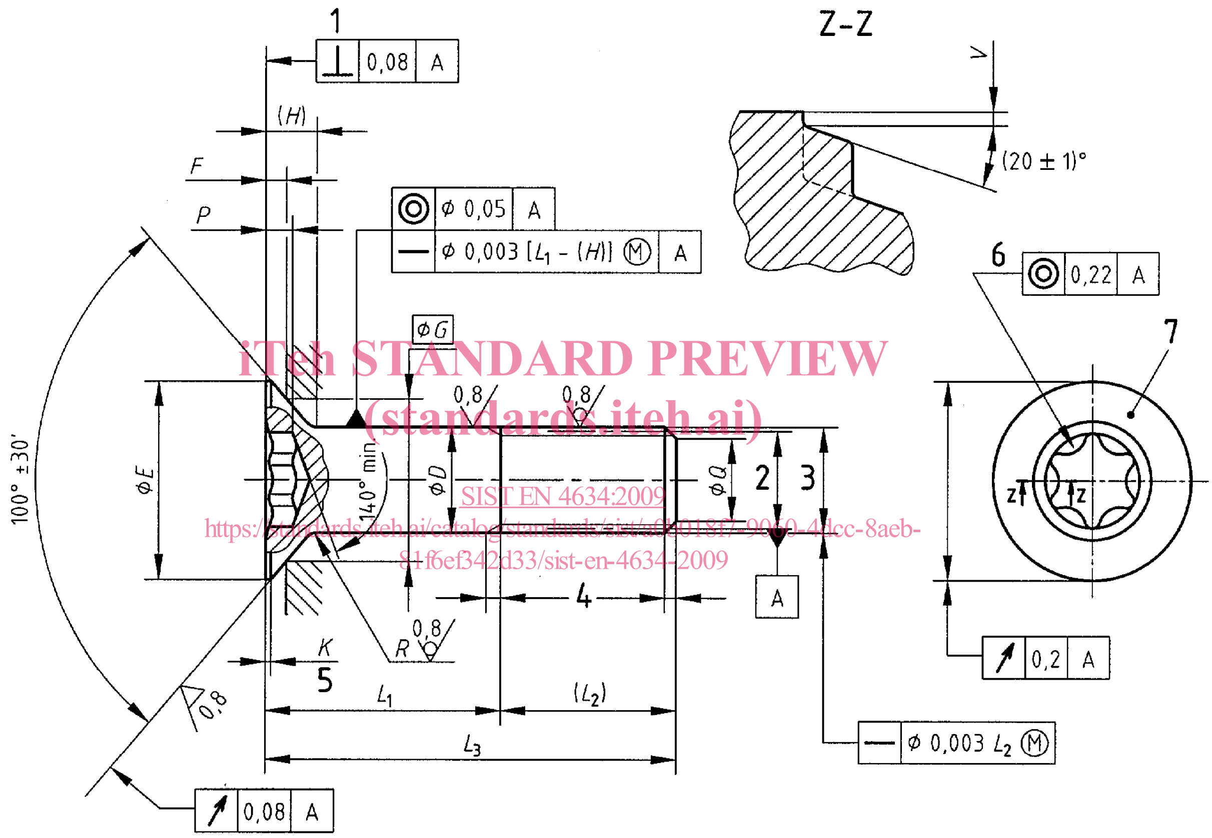
EN 2516

3.4 Tolerances of form and position

ISO 7913

Values in micrometres apply prior to surface treatment.

Remove sharp edges 0,1 to 0,4.



Key

1 Not concave
2 Pitch diameter
3 Thread
4 Conforms to ISO 3353-1
5 The rounded angle accepted
6 Six lobe recess conforms to EN 3911
7 Marking

Figure 1

Table 1

Thread		D	$\varnothing E$	F	G	H	K	$L_1 \pm 0{,}2$		L_2
Code	**Designation**	h12	min.	$^{0}_{-0{,}08}$	Ref.	Ref.	min.	**Length code**	min.	
030	MJ3×0,5-4h6h	3	5,6	0,63	4,50	1,3	0,06	003 to 030	3	6
040	MJ4×0,7-4h6h	4	7,5	0,93	5,78	1,7	0,08	003 to 040	3	7,5
050	MJ5×0,8-4h6h	5	9,5	0,96	7,71	2,1	0,1	004 to 050	4	9
060	MJ6×1-4h6h	6	11,5	1,26	9,00	2,6	0,1	005 to 060	5	10
080	MJ8×1-4h6h	8	15,4	1,60	12,21	3,4	0,1	006 to 080	6	11,5
100	MJ10×1,25-4h6h	10	19,3	1,93	15,43	4,2	0,1	008 to 100	8	14,5
120	MJ12×1,25-4h6h	12	23	2,53	18,00	5	0,1	010 to 100	10	16

Thread [a]		P		Q		R		V	Recess code [b]
Code	**Designation**	nom.	Tol.	nom.	Tol.	max.	min.	mm	
030	MJ3×0,5-4h6h	0,8	$^{0}_{-0{,}1}$	2,3	$^{0}_{-0{,}5}$	0,4	0,2	0,13	EN3911-09
040	MJ4×0,7-4h6h	1		2,9					EN3911-15
050	MJ5×0,8-4h6h	1,1	$^{0}_{-0{,}2}$	3,8		0,5	0,3	0,25	EN3911-20
060	MJ6×1-4h6h	1,5		4,5					EN3911-27
080	MJ8×1-4h6h	2	$^{0}_{-0{,}3}$	6,2	± 0,5	0,7	0,5		EN3911-40
100	MJ10×1,25-4h6h	2,3	$^{0}_{-0{,}5}$	7,9		0,7	0,5		EN3911-45
120	MJ12×1,25-4h6h	2,8		9,9		0,8	0,6		EN3911-50

[a] Conforms to ISO 5855-2.

[b] See EN 3911.

4 Designation

EXAMPLE

Description block	Identity block
SCREW	EN4634-040003

Number of this standard

Diameter code (see Table 1)

Length code (see Table 1)