



SLOVENSKI STANDARD

SIST EN 3278:2012

01-maj-2012

Aeronavtika - Obojke, cevaste, štrleče glave, iz korozijsko odpornega jekla, pasivirane (debelina stene 0,25 mm)

Aerospace series - Sleeves, tubular, protruding head, in corrosion resisting steel, passivated (0,25 mm wall thickness)

Luft- und Raumfahrt - Hülsen, überstehender Kopf, aus korrosionsbeständigem Stahl, passiviert (Wanddicke 0,25 mm)

Série aérospatiale - Douilles tubulaires, tête saillante en acier résistant à la corrosion, passivé (Épaisseur de paroi 0,25 mm)

<https://standards.iteh.ai/catalog/standards/sist/e2d9f30c-60ed-448d-bb46-4f342a480807/sist-en-3278-2012>

Ta slovenski standard je istoveten z: EN 3278:2012

ICS:

49.030.99 Drugi vezni elementi Other fasteners

SIST EN 3278:2012

en,de

iTeh STANDARD PREVIEW
(standards.iteh.ai)

SIST EN 3278:2012

<https://standards.iteh.ai/catalog/standards/sist/e2d9f30c-60ed-448d-bb46-4f342a480807/sist-en-3278-2012>

EUROPEAN STANDARD

EN 3278

NORME EUROPÉENNE

EUROPÄISCHE NORM

March 2012

ICS 49.030.99

English Version

Aerospace series - Sleeves, tubular, protruding head, in corrosion resisting steel, passivated (0,25 mm wall thickness)

Série aérospatiale - Douilles tubulaires, tête saillante en acier résistant à la corrosion, passivé (Épaisseur de paroi 0,25 mm)

Luft- und Raumfahrt - Hülsen, überstehender Kopf, aus korrosionsbeständigem Stahl, passiviert (Wanddicke 0,25 mm)

This European Standard was approved by CEN on 24 August 2011.

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

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, Croatia, 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, Turkey and United Kingdom.

<https://standards.iteh.ai/catalog/standards/sist/e2d9f30c-60ed-448d-bb46-4f342a480807/sist-en-3278-2012>



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

Management Centre: Avenue Marnix 17, B-1000 Brussels

Contents

Page

Foreword	3
1 Scope.....	4
2 Normative references	4
3 Definitions	4
4 Required characteristics	4
4.1 Configuration — Dimensions — Tolerances	4
4.2 Surface roughness.....	4
4.3 Material.....	4
4.4 Surface treatment.....	4
5 Designation.....	7
6 Marking.....	7
7 Technical requirements.....	7
7.1 Manufacture	7
7.2 Surface appearance	7
7.3 Sampling	7

iTeh STANDARD PREVIEW
(standards.iteh.ai)

[SIST EN 3278:2012](https://standards.iteh.ai/catalog/standards/sist/e2d9f30c-60ed-448d-bb46-4f342a480807/sist-en-3278-2012)

<https://standards.iteh.ai/catalog/standards/sist/e2d9f30c-60ed-448d-bb46-4f342a480807/sist-en-3278-2012>

Foreword

This document (EN 3278:2012) 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 September 2012, and conflicting national standards shall be withdrawn at the latest by September 2012.

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, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

iTeh STANDARD PREVIEW (standards.iteh.ai)

[SIST EN 3278:2012](https://standards.iteh.ai/catalog/standards/sist/e2d9f30c-60ed-448d-bb46-4f342a480807/sist-en-3278-2012)

<https://standards.iteh.ai/catalog/standards/sist/e2d9f30c-60ed-448d-bb46-4f342a480807/sist-en-3278-2012>

EN 3278:2012 (E)**1 Scope**

This European standard specifies the characteristics and technical requirements for protruding head tubular sleeves, in corrosion resisting steel, which may be plain or provided with a series of annular grooves.

They are for use in aerospace assemblies whose maximum operating temperature does not exceed 650 °C.

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 2175, *Aerospace series - Heat resisting alloy FE-PA2602 (X4NiCrTiMoV26-15) - Solution treated and precipitation treated - Sheet, strip and plate - 0,5 mm ≤ a ≤ 10 mm - Rm ≥ 850 MPa*

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

EN 2516, *Aerospace series — Passivation of corrosion resistant steels*

ISO 2859 (all parts), *Sampling procedures for inspection by attributes*

3 Definitions

3.1 Crack: Rupture in the material which may extend in any direction and which may be intercrystalline or transcrystalline in character.

3.2 Seam: Open surface defect which is the result of the extrusion of the material.

3.3 Lap: Surface defect caused by folding over metal fins or sharp corners and then rolling or forging them into the surface.

4 Required characteristics**4.1 Configuration — Dimensions — Tolerances**

The configuration shall be in accordance with the figure; the dimensions and tolerances shall conform to the values shown in the figure and in tables 1 and 2 after passivation.

4.2 Surface roughness

See figure. The values apply after passivation.

4.3 Material

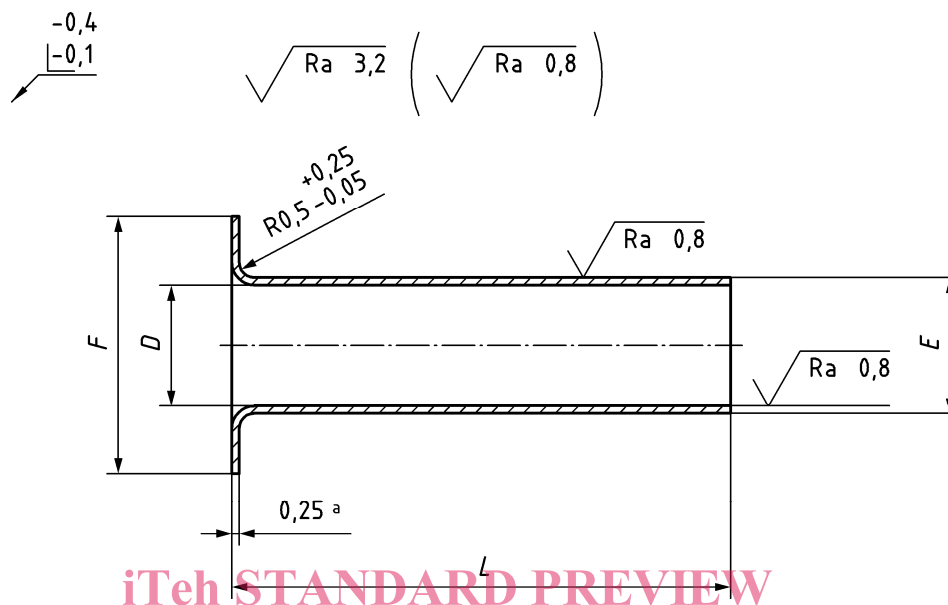
Steel EN 2175, received in the annealed condition and cold worked during manufacture.

4.4 Surface treatment

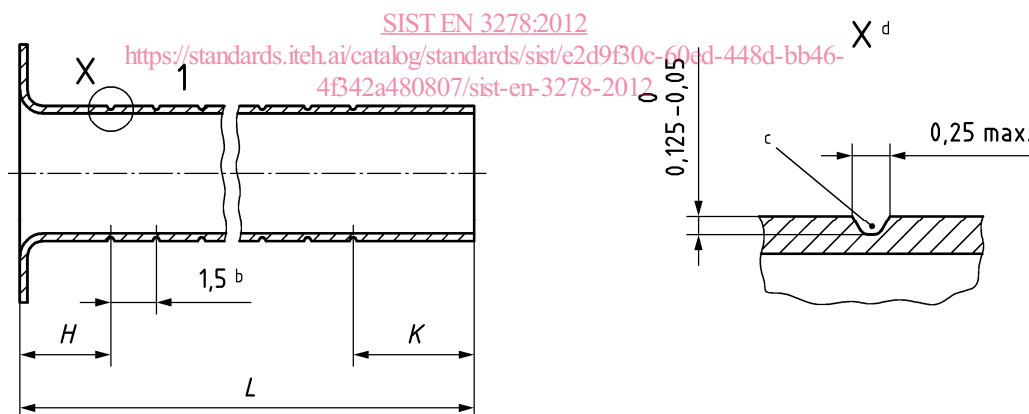
Passivation EN 2516.

Values in micrometres apply prior to surface treatment.

Plain form
(code "P")



Grooved form
(code "G")



Key

- 1 Unspecified dimensions: as plain form
- a Ref.
- b Pitch of grooves
- c Form of groove at manufacturer's option
- d Enlarged

Figure 1 — Configuration

Table 1 — Dimensions

Dimensions in millimetres

Diameter code	D		E		F	H	K
	max.	min.	max.	min.	± 0,3	± 0,5	± 0,5
040	3,999	3,960	4,499	4,474	8,5	3	4
050	4,999	4,960	5,499	5,474	10	3	5,5
060	5,999	5,960	6,499	6,474	11,5	4,5	7
080	7,994	7,955	8,494	8,470	14,5	6	7
100	9,994	9,955	10,494	10,470	17,5	7,5	10

Table 2 — Lengths and masses

Dimensions in millimetres

Diameter code		040	050	060	080	100
Form	Length		Mass			
	Code	$L_{0}^{+0,5}$	kg/1 000 pieces ^a			
Plain	030	3	0,167	0,215	—	—
	045	4,5	0,206	0,264	0,325	—
	060	6	0,246	0,312	0,383	0,489
	075	7,5	0,285	0,361	0,441	0,565
	090	9	0,325	0,410	0,499	0,642
	105	10,5	0,364	0,459	0,557	0,719
	120	12	0,404	0,508	0,615	0,795
	135	13,5	0,443	0,556	0,673	0,872
	150	15	0,483	0,605	0,731	0,949
	165	16,5	0,520	0,654	0,790	1,025
	180	18	0,562	0,703	0,848	1,102
	195	19,5	0,601	0,751	0,906	1,179
	210	21	0,641	0,800	0,964	1,256
	225	22,5	0,680	0,849	1,022	1,332
	240	24	0,720	0,898	1,080	1,409
	255	25,5	0,759	0,947	1,138	1,486
Grooved	—	25	0,747	0,931	1,119	1,460

^a Calculated on basis of 7,95 kg/dm³.