



SLOVENSKI STANDARD

SIST EN 3706:2012

01-maj-2012

Aeronavtika - Brezglava navojna zapirala s križno zarezo iz aluminijeve zlitine 5086

Aerospace series - Headless threaded plugs, cross recess, in aluminium alloy 5086

Luft- und Raumfahrt - Verschlusschraube ohne Kopf mit Kreuzschlitz, aus Aluminiumlegierung 5086

Série aérospatiale - Bouchons filetés, sans tête, empreinte cruciforme, en alliage d'aluminium 5086

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Ta slovenski standard je istoveten z: **EN 3706:2012**

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ICS:

49.025.20	Aluminij	Aluminium
49.030.20	Sorniki, vijaki, stebelni vijaki	Bolts, screws, studs

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en,de

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EUROPEAN STANDARD

EN 3706

NORME EUROPÉENNE

EUROPÄISCHE NORM

March 2012

ICS 49.030.20

English Version

Aerospace series - Headless threaded plugs, cross recess, in aluminium alloy 5086

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This European Standard was approved by CEN on 24 September 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.

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COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

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Foreword

This document (EN 3706:2012) 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.

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EN 3706:2012 (E)**1 Scope**

This European standard specifies characteristics of headless threaded plugs, cross recess, in aluminium alloy 5086, for aerospace purpose.

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 2424, *Aerospace series — Marking of aerospace products*

EN 2699, *Aerospace series — Aluminium alloy (5086) — Annealed and straightened (H 111) — Drawn bar — $6 \leq D \leq 50$ mm*¹

EN 3707, *Aerospace series — Headless threaded plugs — Installation holes*

ISO 5855-1, *Aerospace — MJ Threads — Part 1: General requirements*

ISO 965-3, *ISO general purpose metric screw threads -- Tolerances -- Part 3: Deviations for constructional screw threads*

3 Required characteristics**3.1 Configuration — Dimensions — Tolerances**

Configuration: See figure.

Dimensions and tolerances:

— see Figure 1 and Table 1;

— dimensions are in millimetres.

3.2 Material

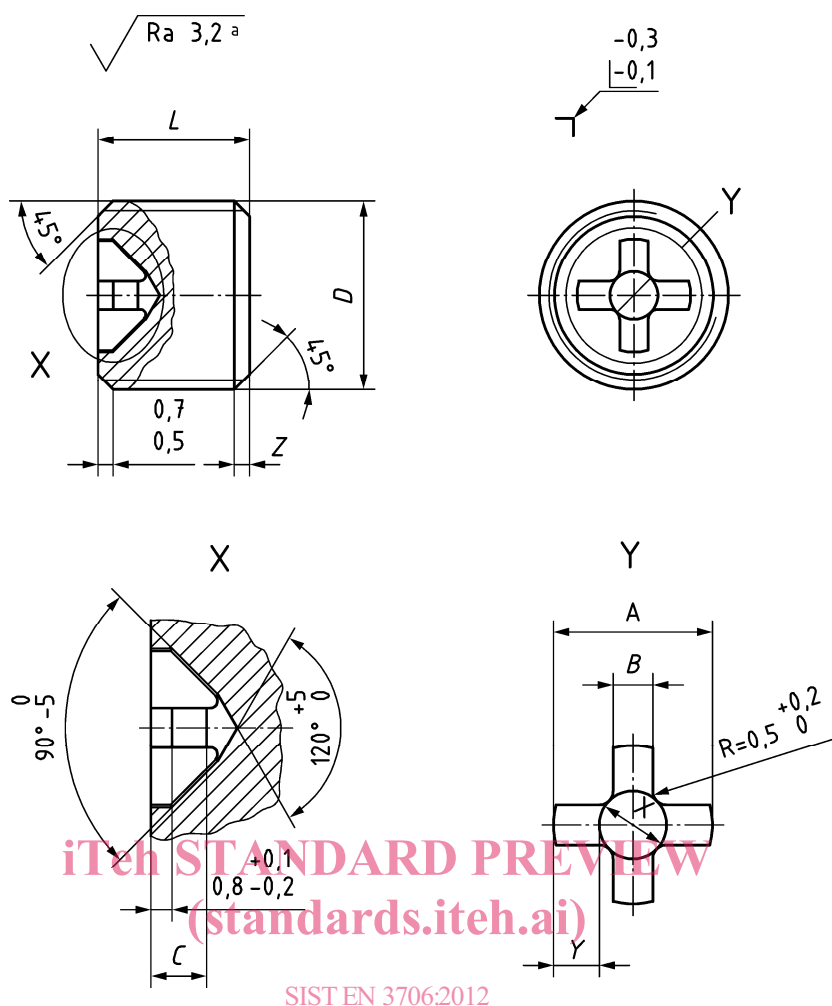
EN 2699

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1) Published as ASD-STAN pre-standard at the date of publication of the present standard.

**Key**

- a Thread surface will be achieved by normal methods of manufacturing.
 X Detail I
 Y see detail I

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Figure 1**Table 1**

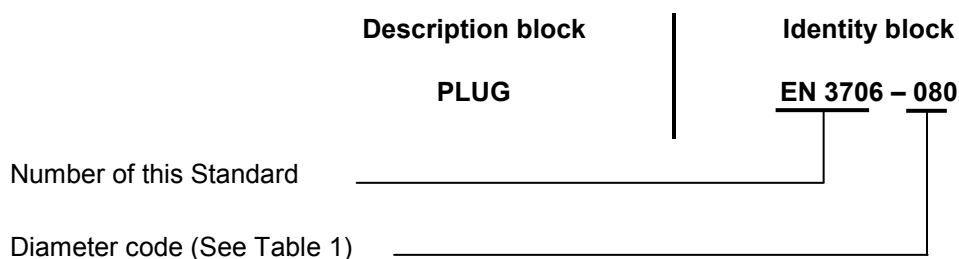
Dimensions in millimetres

Diameter code	$\varnothing D^a$	L $\pm 0,25$	Z $^{+0,3}_0$	$\varnothing A$ $^{+0,3}_0$	B $^{+0,2}_0$	C $^{+0,3}_{-0,1}$	X min.	Y min.
060	MJ6×1,00 – 4g5g	6	0,5	3	0,8	0,9	1,56	0,4
070	MJ7×1,00 – 4g5g	7	0,8	4	1	1	1,84	0,6
080	MJ8×1,00 – 4g5g	8	0,8	5	1	1,4	1,84	0,12
100	MJ10×1,00 – 4g5g	8	0,8	6	1,5	2,1	2,55	1,34
120	MJ12×1,00 – 4g5g	8	1,2	6	1,5	2,1	2,55	1,34
140	MJ14×1,00 – 4g5g	8	1,2	7	2	2,7	3,28	1,54
160	MJ16×1,00 – 4g5g	10	1,2	7	2	2,7	3,28	1,54
180	MJ18×1,00 – 4g5g	10	1,2	7	2	2,7	3,28	1,54
200	MJ20×1,00 – 4g5g	10	1,2	7	2	2,7	3,28	1,54

^a Basic profile is in conformity with ISO 5855-1 and tolerances with ISO 965-3.

EN 3706:2012 (E)**4 Designation**

EXAMPLE



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

5 Marking

According to EN 2424, category G.

6 Installation holes

See EN 3707.

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