SLOVENSKI STANDARD
SIST EN 3268:2015

01-januar-2015

Nadomešča:
SIST EN 3268:2004

Aeronavtika - Cevni priključek 8°30' iz titanove zlitine - Tlačni vtiči (slepi priključki)

Aerospace series - Pipe coupling 8°30' in titanium alloy - Pressure plugs

Luft- und raumfahrt - Rohrverschraubung 8°30' aus Titanlegierung - Blindverschraubungen

Série aérospatiale - Système de raccordement 8°30' en alliage de titane - Obturateurs de tuyauterie

Ta slovenski standard je istoveten z: EN 3268:2014

ICS:

49.025.30	Titan	Titanium
49.080	Letalski in vesoljski hidravlični sistemi in deli	Aerospace fluid systems and components

SIST EN 3268:2015 **en,fr,de**

EUROPEAN STANDARD

NORME EUROPÉENNE

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EN 3268

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ICS 49.080

Supersedes EN 3268:2001

English Version

Aerospace series - Pipe coupling 8°30' in titanium alloy - Pressure plugs

Série aérospatiale - Système de raccordement 8°30' en alliage de titane - Obturateurs de tuyauterie

Luft- und Raumfahrt - Rohrverschraubung 8°30' aus Titanlegierung - Blindverschraubungen

This European Standard was approved by CEN on 4 January 2014.

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COMITÉ EUROPÉEN DE NORMALISATION
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Contents

Page

Foreword 3

1 Scope 4

2 Normative references 4

3 Required characteristics 4
3.1 Configuration – Dimensions – Mass 4
3.2 Surface roughness 4
3.3 Materials 4
3.4 Surface treatment 4

4 Designation 6

5 Marking 7

6 Technical specification 7

Annex A (informative) **Standard evolution form** 8

Foreword

This document (EN 3268:2014) 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of an identical text or by endorsement, at the latest by April 2015, and conflicting national standards shall be withdrawn at the latest by April 2015.

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This document supersedes EN 3268:2001.

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, Former Yugoslav Republic of Macedonia, 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.

1 Scope

This European Standard specifies the characteristics of pressure plugs for pipe couplings 8°30', in titanium alloy, for aerospace applications.

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 2491, *Aerospace series - Molybdenum disulphide dry lubricants - Coating methods*

EN 3274, *Aerospace series - Pipe coupling 8°30' - Thread end - Geometric configuration*

EN 3275, *Aerospace series - Pipe coupling 8°30' up to 28 000 kPa - Dynamic beam seal - Metric series - Technical specification*

EN 3311, *Aerospace series - Titanium alloy TI-P64001 (Ti-6Al-4V) - Annealed - Bar for machining - D < 110 mm*

EN 3314, *Aerospace series - Titanium alloy TI-P64001 - Solution treated and aged - Bar for machining - D ≤ 75 mm* [1)]

ISO 5855-3, *Aerospace - MJ threads - Part 3: Limit dimensions for fittings for fluid systems*

MIL-PRF-24635, *Performance specification - Coating systems, weather resistant, exterior use* [2)]

FED-STD-595, *Federal Standard: colors used in government procurement (Color FS 11136)* [2)]

3 Required characteristics

3.1 Configuration – Dimensions – Mass

According to Figure 1 and Table 1.

Dimensions applied before lubricating.

3.2 Surface roughness

According to Figure 1.

3.3 Materials

According to EN 3311 or EN 3314.

3.4 Surface treatment

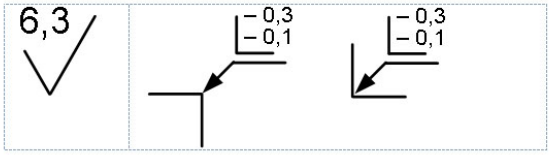
Lubrication: according to EN 2491 on thread and sealing face, film thickness: 0.005 mm to 0.013mm.

1) Published as ASD-STAN Prestandard at the date of publication of this standard (www.asd-stan.org).

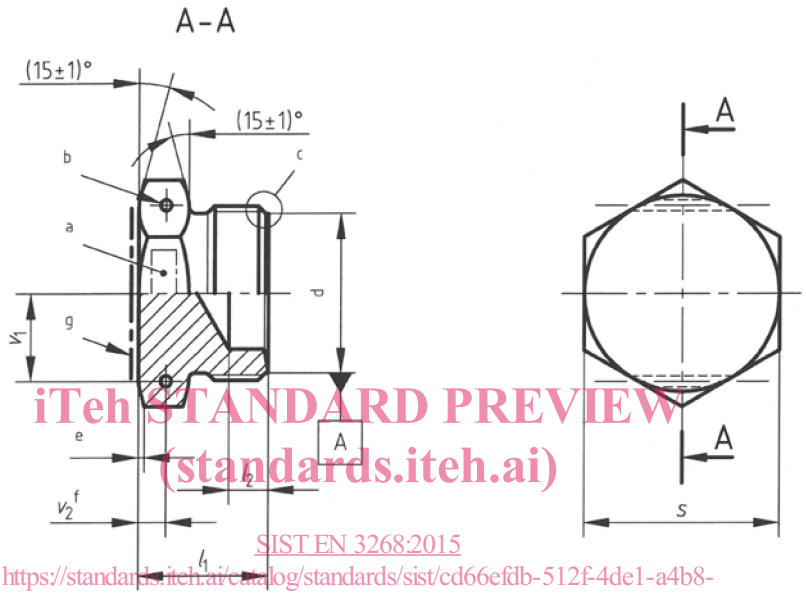
2) Published by: DoD National (US) Mil. Department of Defense (http://www.defenselink.mil/).

Optional, red coating FED-STD-595/11136 in accordance with MIL-PRF-24635 (see Figure 1 and Table 2).

Prior to application of lubricant or coating, the surface shall be abrasive blasted using non-metallic grit.



Dimensions in millimetres



Key

a Area for marking

b Two holes Ø d_1 (optional, see Table 1)

c According to EN 3274, form B

d Thread

e 0,3 to 0,6 applicable to both faces

f From either face

g Red coating zone (optional, see Table 2)

Figure 1

Table 1

Dimensions in millimetres

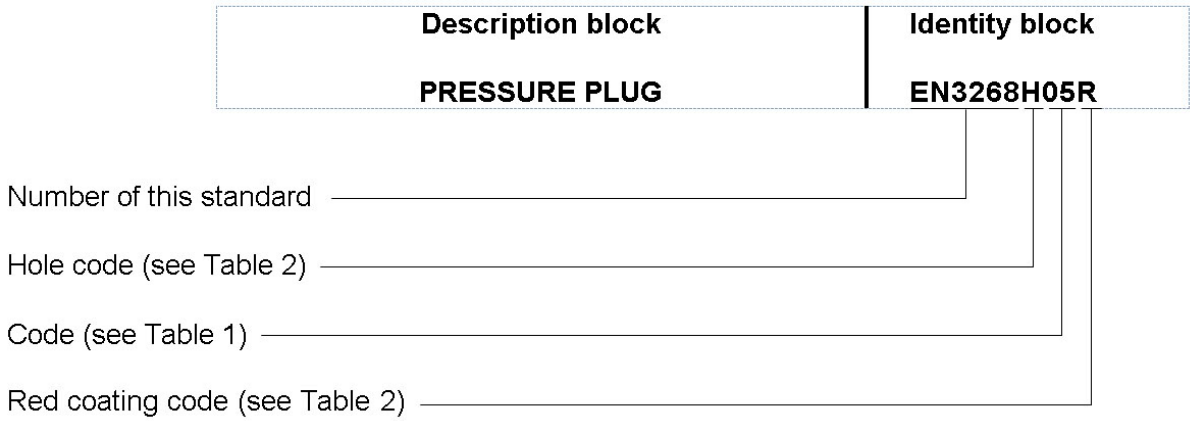
Code a	**Thread** b	d_1	l_1	l_2	s	v_1	v_2	**Mass** g/piece
	4g6g	H13	± 0,2	± 0,4	h13	± 0,2	min.	max.
05	MJ10×1	1	11,3	5,6	11	4,21	2,1	1,96
06	MJ12×1,25	1,5	13,5	7,1	13	4,94	2,6	3,04
08	MJ14×1,5		15,8	8,4	16	6,54	3,1	5,92
10	MJ16×1,5		16,3	7,8	17	6,9	3,6	6,80
12	MJ18×1,5		16,8	7,3	19	7,97	3,85	10,15
14	MJ20×1,5		17,3	7	22	9,68		13,57
16	MJ22×1,5		17,8	6,5	24	10,51		17,75
18	MJ24×1,5			5,9	27	12,11		23,00
20	MJ27×1,5		18,2	5,1	30	13,77		31,01
22	MJ30×1,5		18,3	4,3	32	14,76		37,70
25	MJ33×1,5			3,9	34	15,66		43,35
28	MJ36×1,5			2,9			4,6	66,70
32	MJ39×1,5		18,8	2,1	41	19,56		71,81

a Corresponds to the pipe nominal outside diameter.

b According to ISO 5855-3.

4 Designation

EXAMPLE



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

Table 2

Option	Code
Lockwire hole	H
No hole	– (hyphen)
Red coating	R
No red coating	No code

5 Marking

According to EN 2424, style A and Figure 1.

WARNING — Items marked with red colour reference are NON-FLIGHTWORTHY COMPONENTS and must be REMOVED BEFORE FLIGHT.

6 Technical specification

According to EN 3275.