



SLOVENSKI STANDARD

SIST EN 2943:2020

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Nadomešča:
SIST EN 2943:2001

Aeronavtika - Vložki s spiralnim navojem MJ in M - Tehnična specifikacija

Aerospace series - Inserts, MJ and M screw threads, helical coil - Technical specification

Luft- und Raumfahrt - Draht-Gewindeeinsätze, MJ und M Gewinde - Technische Lieferbedingungen

Série aérospatiale - Filets rapportés MJ et M filetage - Spécification technique

Ta slovenski standard je istoveten z: **EN 2943:2019**

ICS:

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

SIST EN 2943:2020

en,fr,de

iTeh STANDARD PREVIEW
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Full standard:
<https://standards.iteh.ai/catalog/standards/sist/172a1c13-9188-4e1b-a339-6000f2c4392/sist-en-2943-2020>

EUROPEAN STANDARD

EN 2943

NORME EUROPÉENNE

EUROPÄISCHE NORM

November 2019

ICS 49.030.30

Supersedes EN 2943:1998

English Version

Aerospace series - Inserts, MJ and M screw threads, helical coil - Technical specification

Série aérospatiale - Filets rapportés, filetages MJ et M -
Spécification technique

Luft- und Raumfahrt - Draht-Gewindeeinsätze, MJ- und
M-Gewinde - Technische Lieferbedingungen

This European Standard was approved by CEN on 7 July 2019.

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

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European foreword

This document (EN 2943:2019) 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of an identical text or by endorsement, at the latest by May 2020, and conflicting national standards shall be withdrawn at the latest by May 2020.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN 2943:1998.

According to the CEN-CENELEC Internal Regulations, the national standards organisations 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, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

1 Scope

This European standard specifies the characteristics, qualification and acceptance requirements for helical coil screw thread inserts.

It is applicable whenever referenced.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements 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 2398, *Aerospace series — Heat resisting steel FE-PA2601 (X6NiCrTiMoV26-15) — $R_m \geq 900$ MPa — Bars for machined bolts — $D \leq 25$ mm*

EN 2945, *Aerospace series — Inserts, screw thread, helical coil, self-locking — Assembly procedure*

EN 3044, *Aerospace series — Installation holes for inserts, screw thread, helical coil, self-locking — Design standard*

EN 3219, *Aerospace series — Heat resisting nickel base alloy (Ni-P100HT) — Cold worked and softened — Bar and wire for continuous forging or extrusion for fasteners — $3 \text{ mm} \leq D \leq 30 \text{ mm}$ ¹*

¹ Published as ASD-STAN Prestandard at the date of publication of this standard by AeroSpace and Defence Industries Association of Europe – Standardization (ASD-STAN) (www.asd-stan.org).

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EN 9138, Aerospace Series — Quality Management Systems — Statistical Product — Acceptance Requirements **Error! Bookmark not defined.**

ISO 965-2, ISO general purpose metric screw threads — Tolerances — Part 2: Limits of sizes for general purpose external and internal screw threads — Medium quality

ISO 3353 (all parts), Aerospace — Lead and runout threads

ISO 4288, Geometrical Product Specifications (GPS) — Surface texture: Profile method — Rules and procedures for the assessment of surface texture

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

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <http://www.iso.org/obp>
- IEC Electropedia: available at <http://www.electropedia.org/>

3.1**batch**

quantity of finished thread inserts, of the same type and same diameter, produced from a material obtained from the same melt, manufactured in the course of the same production cycle, following the same manufacturing route and having undergone all the relevant heat treatments and surface treatments

3.2 surface discontinuities**3.2.1****crack**

rupture in the material which may extend in any direction and which may be intercrystalline or transcrystalline in character

3.2.2**seam**

open surface defect

3.2.3**lap**

surface defect caused by folding over metal fins or sharp corners and then compressing them into the surface

3.2.4**inclusions**

non-metallic particles originating from the material manufacturing process

Note 1 to entry: These particles may be isolated or arranged in strings.

3.3**test temperature**

ambient temperature, unless otherwise specified

3.4

simple random sampling

sampling where a sample of n sampling units is taken from a population in such a way that all the possible combinations of n sampling units have the same probability of being taken

3.5 sampling test and examinations

3.5.1

non-destructive tests-visual and dimensional

random sample shall be selected from each production lot, the size for the sample to be as specified in **Table 2**. All dimensional characteristics are considered imperfect when out of tolerance

3.5.2

destructive tests- screw locking torque

random sample shall be selected from each production sample lot as per **Table 2**. Normal size inspection shall be in effect until conditions for adjusting from normal to reduced size are satisfied. Normal size inspection shall resume when the conditions for switching from reduced to normal size occur

3.5.2.1

normal to reduced sample size switching

switching from normal to reduced sample shall be instituted providing the following conditions are satisfied:

- a) the preceding 10 batches have been on normal inspection and all have been accepted;
- b) production of a sample item or items using similar processes has been continuous under normal size sampling without break longer than 90 days;
- c) reduced inspection is considered desirable

3.5.2.2

reduced to normal sample size switching

when reduced sample size inspection is in effect, normal sample size inspection shall be instituted if any of following conditions occur on original inspection:

- a) a batch is rejected;
- b) production of a sample item using similar processes ceases or is delayed for a period greater than 90 days;
- c) other conditions warrant that normal size inspection is resumed

3.6

finished thread insert

thread insert ready for use, inclusive of any possible treatments and/or surface coatings, as specified in the product standards or definition document

3.7

definition document

document specifying all the requirements for finished thread inserts

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3.8

self-locking torque

torque to be applied to the associated bolt to maintain its movement of rotation in relation to the thread insert assembly which is under no axial load and the thread insert locking zone being completely engaged with the bolt (minimum protrusion of two pitches, including the end chamfer)

3.9

seating torque

tightening torque to be applied to the thread insert and bolt assembly to introduce or to increase the axial load in the assembly

3.10

unseating torque

untightening torque to be applied to the thread insert and bolt assembly to reduce or remove the axial load in the assembly

3.11

breakaway torque

torque required to start unscrewing the associated bolt with respect to the installed thread insert, with the insert locking zone still fully engaged on the bolt, but after the axial load in the assembly has been removed by unscrewing half a turn followed by a halt in rotational movement

4 Quality assurance

4.1 Approval of manufacturers

The manufacturer's operations shall be an approved production organisation for aerospace products and shall demonstrate that it has implemented and is able to maintain a quality management system (e.g. according to EN 9100 or an equivalent aerospace accepted and established quality management system).

4.2 Qualification

The qualification procedure for aerospace standard products (e.g. according to EN 9133 or an equivalent aerospace accepted and established qualification procedure) shall be used and documented according to the specified tests if not otherwise agreed between customer and supplier.

Qualification inspections and tests (requirements, methods, numbers of thread inserts) are specified in Table 1. They shall be carried out on

- each type and diameter of thread insert and
- 26 thread inserts selected from a single batch by simple random sampling.

The test programme may possibly be reduced, or the qualification be granted without inspection or testing; any such decision shall be based on the results obtained on similar types and diameters of thread inserts provided that the design and manufacturing conditions are identical.

4.3 Acceptance

4.3.1 Purpose

The purpose of acceptance inspections and tests is to check, as simply as possible, by a method representative of actual use conditions, with the uncertainty inherent to statistical sampling, that the thread inserts constituting the batch satisfy the requirements of this standard.

4.3.2 Conditions

Acceptance inspections and tests (requirements, methods, numbers of thread inserts) are specified in **Table 1**. They shall be carried out on each batch. Thread inserts from the batch to be tested shall be selected by simple random sampling.

Each thread insert may be submitted to several inspections or tests.

4.3.3 Responsibility

Acceptance inspections and tests shall be carried out by the manufacturer, or under his responsibility.

4.3.4 Inspection and test report

A test report showing actual numerical values shall be provided if specified in the purchase order.

5 Requirements

See **Table 1**.

Table 1 — Technical requirements and test methods

Clause	Characteristic	Requirement	Inspection and test method	Q/A ^a	Sample size
5.1	Material	In accordance with the product standard or definition document	Chemical analysis or certificate of compliance issued by the manufacturer of the semi-finished product	—	—
5.2	Dimensions, tolerances and tolerances of form and position	In accordance with the product standard or definition document	Thread gauging	—	—
5.2.1	Thread	In accordance with the product standard or definition document	Thread gauging. The gauging shall be done from the opposite end to the drive tang. ^c The minimum requested number of coils above locking coil is 1,25°. If specified part does not provide the minimum, test parts has to be produced and gauged.	Q	5
				A	Table 2
5.3	Manufacturing	—	—	—	—
5.3.1	Surface roughness	In accordance with the product standard or definition document	ISO 4288 Visual examination	Q	3
				A	2
5.3.2	Surface coating	In accordance with the product standard or definition document	See applicable coating standard.	Q	23
				A	Table 2

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Clause	Characteristic	Requirement	Inspection and test method	Q/A ^a	Sample size
5.3.3	Colour	In accordance with the product standard or definition document	Visual examination	A	Table 2
5.4	Mechanical properties	Thread inserts shall be assembled into test equipment (see Table 3) according to EN 2945	—	—	—
5.4.1	Reusability set test of the locking coil (ambient temperature)	Measured torques of the thread inserts shall not exceed the maximum self-locking torque nor shall be less than the minimum breakaway torque, see Table 5.	—	—	—
5.4.1.1	Self-locking torque at ambient temperature (15 cycles)	Shall be between the minimum breakaway torque and the maximum self-locking torque, see Table 5, for each cycle.	<p>Lubricate the bolt using clean engine oil. Place the bolt in the spacer, fit the bolt in the thread insert, until it protrudes at least two pitches beyond the locking zone of the thread insert.</p> <p>Unscrew, until the bolt has completely left the locking zone.</p> <p>Start of cycles.</p> <p>Screw up again until the bolt protrudes at least two pitches beyond the locking zone of the thread insert, measuring the self-locking torque on screwing. Apply the seating torque to Table 5.</p> <p>Remove the load from the thread insert by unscrewing at least one half turn and until the spacer can be moved freely.</p> <p>Repeat the unscrewing operation, measuring the breakaway torque.</p> <p>Check that the bolt dimensions are within the limits given in Annex C and that their threads have not been damaged.</p> <p>The rotation of the bolts shall be sufficiently slow so that the temperature of the thread insert</p>	Q	10