



SLOVENSKI STANDARD

SIST EN 4807:2017

01-julij-2017

Aeronavtika - Prirobnične spojke - Varjena spojka, koleno 90°, iz toplotnoodpornega jekla - Palčne mere

Aerospace series - Flange couplings - Weld coupling, 90° elbow, in heat resisting steel - Inch series

Luft- und Raumfahrt - Rohrverschraubung mit Flanschen und Schweißstutzen, Winkelstutzen 90°, aus hochwarmfestem Stahl - Inch-Reihe

Série aérospatiale - Raccordement à bride - Raccord à souder, coude à 90°, en acier résistant à chaud - Série en inches

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Ta slovenski standard je istoveten z: EN 4807:2017

ICS:

23.040.60	Prirobnice, oglavki in spojni elementi	Flanges, couplings and joints
49.080	Letalski in vesoljski hidravlični sistemi in deli	Aerospace fluid systems and components

SIST EN 4807:2017

en,fr,de

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EUROPEAN STANDARD

EN 4807

NORME EUROPÉENNE

EUROPÄISCHE NORM

May 2017

ICS 49.080

English Version

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This European Standard was approved by CEN on 14 November 2016.

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, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and United Kingdom.



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

CEN-CENELEC Management Centre: Avenue Marnix 17, B-1000 Brussels

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European foreword

This document (EN 4807:2017) 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 November 2017, and conflicting national standards shall be withdrawn at the latest by November 2017.

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.

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, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

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EN 4807:2017 (E)**1 Scope**

This standard specifies the characteristics of straight welded coupling in heat resisting steel for swivel flange couplings for inch series aerospace applications.

Nominal pressure: The parts shall withstand nominal pressures given in Table 1. The nominal pressure of the assembly depends on associated seal, tube material characteristics, tube diameter and tube wall thickness (see EN 4814).

NOTE Assembly in accordance with TR 4815.

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 2516, *Aerospace series — Passivation of corrosion resistant steels and decontamination of nickel base alloys*

EN 3363, *Aerospace series — Steel FE-CM68 — Solution treated — $R_m \geq 485$ MPa — Sand or investment casting*¹⁾

EN 3468, *Aerospace series — Steel FE-PA13 — Softened — $500 \leq R_m \leq 700$ MPa — Forgings — $D_e \leq 100$ mm*¹⁾

EN 3487, *Aerospace series — Steel FE-PA3601 (X6CrNiTi18-10) — Air melted — Softened — Bar for machining — a or $D \leq 250$ mm — 500 MPa $\leq R_m \leq 700$ MPa*

EN 4814, *Aerospace series — Flange couplings up to 21 000 kPa — Technical specification — Inch series*

EN 9100, *Quality Management Systems — Requirements for Aviation, Space and Defence Organizations*

TR 4815, *Aerospace series — Flange couplings up to 21 000 kPa — Design standard — Inch series*²⁾

3 Required characteristics**3.1 Configuration - Dimensions - Tolerances - Masses**

See Figure 1 and Table 1. Dimensions and tolerances are in millimetres, except otherwise specified.

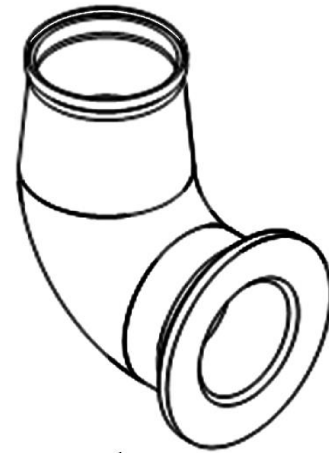
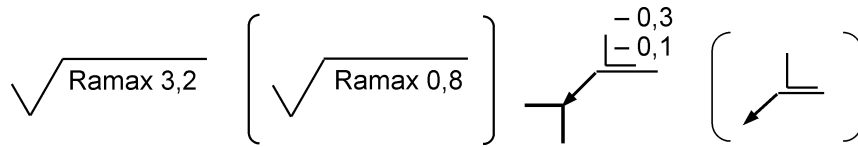
3.2 Material and surface treatment

EN 3363 or EN 3468 or EN 3487.

Surface finish: Passivation EN 2516.

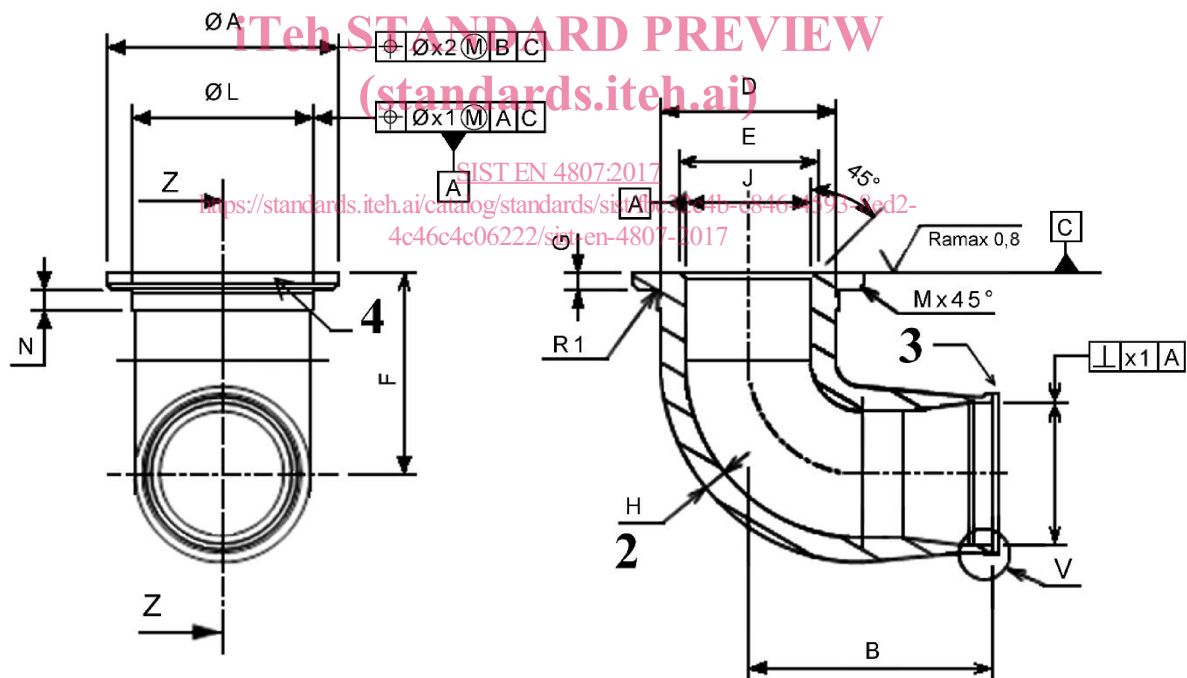
¹⁾ Published as ASD-STAN Prestandard at the date of publication of this standard. (<http://www.asd-stan.org/>)

²⁾ Published as ASD-STAN Technical Report at the date of publication of this standard. (<http://www.asd-stan.org/>)



1

Z-Z



Key

- 1 3D view (for information only)
- 2 Constant thickness
- 3 Marking of identity block
- 4 Marking of manufacturer's monogram

Figure 1

EN 4807:2017 (E)

Table 1

Dimensional code ^a	Nominal diameter		Wall thickness of tube	ØA ±0,05	B +0,1 0	D ±0,20	E ±0,10	F ±0,65	G		H		J min	ØL ±0,20	M ±0,1	N ±0,8	R1 ±0,125	x1	x2	V	Mass ^b
	inch	mm							min	max	min	max									
A10	.625	15,875	0,711	28,50	31,30	19,60	13,80	27,95	2,80	3,05	3,00	3,90	11,60	19,60	1,0	3,3	0,625	0,20	0,10	EN4549A010	67,5
B10			0,889																	EN4549B010	
A12	.750	19,050	0,711	31,70	36,85	23,60	17,00	30,15	2,80	3,05	3,20	4,20	14,90	23,60	1,0	3,3	0,625	0,20	0,10	EN4549A012	97,1
B12			0,889																	EN4549B012	
A16	1.000	25,400	0,711	38,05	40,15	29,80	23,00	33,15	2,80	3,05	3,60	4,40	20,80	29,80	1,0	3,3	0,625	0,20	0,10	EN4549A016	148,5
B16			0,889																	EN4549B016	
A20	1.250	31,750	0,711	46,80	51,30	36,30	28,90	38,75	3,05	3,20	4,00	4,90	26,75	36,30	1,0	3,3	0,625	0,20	0,10	EN4549A020	251,4
B20			0,889																	EN4549B020	
A24	1.500	38,100	0,711	53,90	54,65	42,40	34,85	43,55	3,30	3,45	4,40	5,40	31,50	42,40	1,0	3,3	0,625	0,20	0,10	EN4549A024	348,2
B24			0,889																	EN4549B024	
A28	1.750	44,450	0,711	60,30	59,95	49,30	40,80	47,85	3,55	3,70	4,80	5,70	37,10	49,30	1,0	3,3	0,625	0,20	0,10	EN4549A028	470,7
B28			0,889																	EN4549B028	
A32	2.000	50,800	0,711	69,80	65,40	55,60	46,75	52,15	3,55	3,70	5,20	6,10	42,50	55,60	1,0	3,3	0,625	0,20	0,10	EN4549A032	625,1
B32			0,889																	EN4549B032	

^a This code is composed with the following elements:

- Tube wall thickness code (A: 0,711 mm; B: 0,889 mm);
- Nominal diameter given in 16th of inches within 2 digit.

^b Mass ≈ quoted in kg/1 000 parts.