SLOVENSKI STANDARD
SIST EN 6128:2017

01-december-2017

Aeronavtika - Slepa kovica, 100° ugrezna glava, zelo trdna

Aerospace series - Blind bolt, 100° flush head, high strength

Luft- und Raumfahrt - Blindniet 100° Senkkopf, hochfet

Série aérospatiale - Boulon aveugle tête fraisée 100° haute résistance

Ta slovenski standard je istoveten z: **EN 6128:2017**

ICS:

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

SIST EN 6128:2017 **en,fr,de**

EUROPEAN STANDARD

NORME EUROPÉENNE

EUROPÄISCHE NORM

EN 6128

October 2017

ICS 49.030.99

English Version

Aerospace series - Blind bolt, 100° flush head, high strength

Série aérospatiale - Boulon aveugle tête fraisée 100°, haute résistance

Luft- und Raumfahrt - Blindniet 100° Senkkopf, hochfet

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

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

Ref. No. EN 6128:2017 E

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European foreword

This document (EN 6128:2017) 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of an identical text or by endorsement, at the latest by April 2018, and conflicting national standards shall be withdrawn at the latest by April 2018.

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1 Scope

This European Standard specifies the configuration, dimension, tolerances and mass of a stainless steel blind bolt with 100° flush head for aerospace application.

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 4473, *Aerospace series — Aluminium pigmented coatings for fasteners — Technical specification*[1)]

AS 5272, *Lubricant, Solid Film, Heat Cured, Corrosion Inhibiting, Procurement Specification*[2)]

AMS 5687, *Nickel Alloy, Corrosion and Heat Resistant, Wire 74Ni 15.5Cr 8.0Fe, Annealed*[2)]

AMS 5690, *Steel, Corrosion and Heat Resistant, Wire 17Cr-12Ni-2.5Mo (316) Solution Heat Treated*[2)]

AMS 5737, *Steel, Corrosion and Heat Resistant, Bars, Wire, Forgings and Tubing 15Cr 25.5Ni 1.2Mo 2.1Ti 0.006B 0.30V, Consumable Electrode Melted, 1650 °F (899 °C), Solution and Precipitation Heat Treated*[2)]

AMS-QQ-P-35, *Passivation Treatments for Corrosion-Resistant Steel*[2)]

MIL-PRF-46010, *Lubricant, Solid Film, Heat Cured, Corrosion Inhibiting NATO Code — S-1738*[3)]

MIL-L-87132, *Lubricant, CETYL Alcohol, 1-Hexadecanol, Application to Fasteners*[3)]

NASM 8975, *Fastener, blind, high strength, installation formed corrosion resistant steel, heat resistant steel and titanium — General specification for*[3)]

DOD-L-85645, *Lubricant, dry film, molecular bonded*[3)]

3 Requirements

3.1 Configuration, dimensions and tolerances

The configuration, dimensions, tolerances, static and dynamic values shall conform to Figure 1 and Figure 2 and Table 1 and Table 2.

3.2 Grip range and weight

See Table 3 and Table 4.

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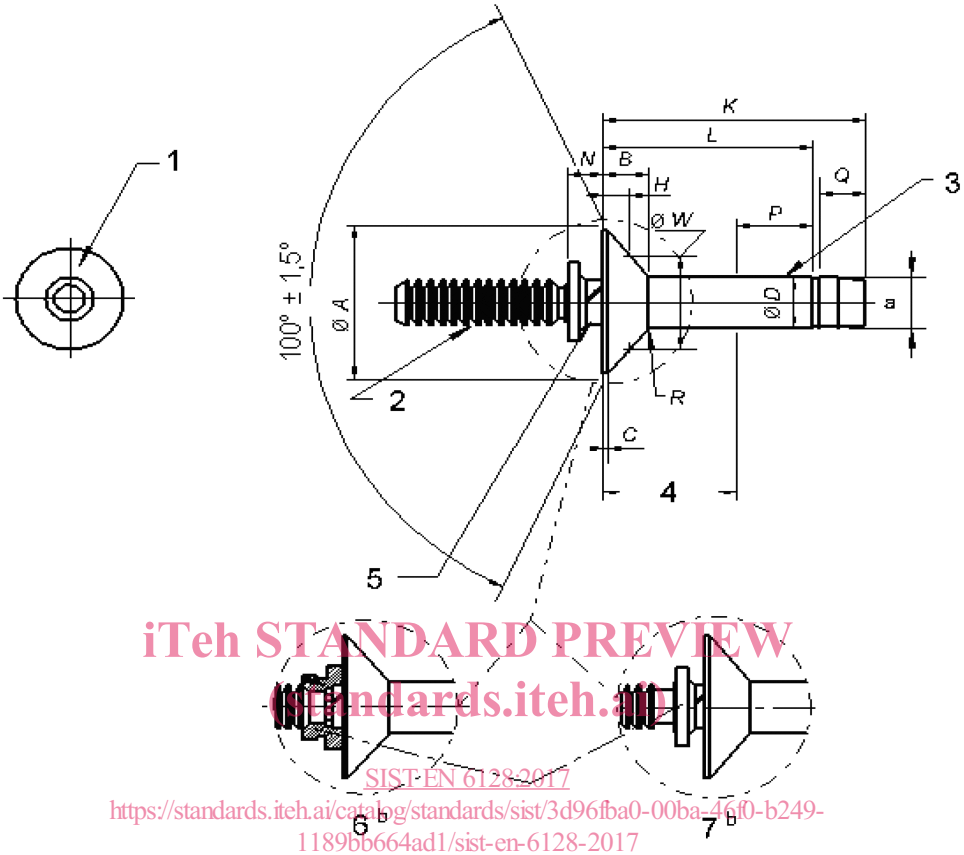
1) Published as ASD-STAN pre-standard at the date of publication of the present standard. www.asd-stan.org

2) Published by: Society of Automotive Engineers (SAE), 400 Commonwealth drive, Warrendale, PA 15096-0001, USA

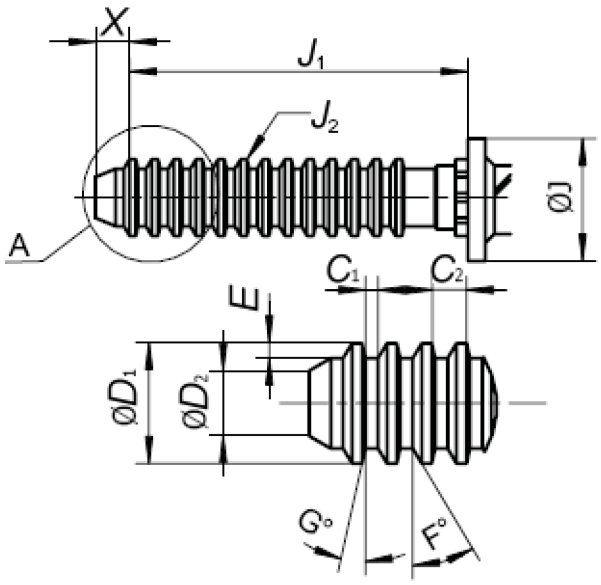
3) Published by: Department of Defense (DOD), the Pentagon, Washington, D.C. 20301.

3.3 Material, finish and lubrication

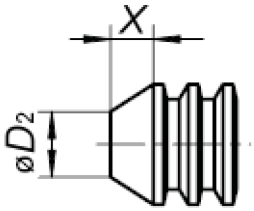
See Table 5 and Table 6.



Detail of serrated pin geometry:



Detail A



Detail A
Optional configuration

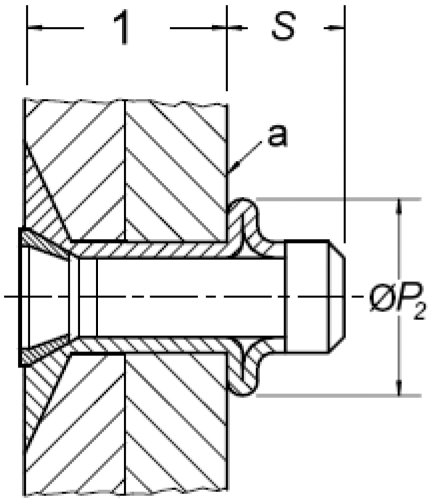
Key

1 Marking see clause 5
2 Serrated pin
3 Sleeve
4 Grip
5 Locking collar
6 Shifting Anvil
7 Drive washer

a Diameter of pin head shall not exceed “Ø D” max.

b Fasteners are supplied with shifting anvil / drive washer of manufacturer's option. The shifting anvil / drive washer is not part of the installed fastener.

Figure 1 — Configuration – Dimensions



Key

1 Grip

a Blind side head may be installed on 7° max slope; 5° max slope for diameter code 10 and 12.

Figure 2 — Typical installation