
Aeronavtika - Zakovičena matica, samovarovalna, iz toplotnoodporne zlitine na nikljevi osnovi NI-P101HT (Waspaloy), posrebrena, za odprtine 30° - Klasifikacija: 1210 MPa (pri okoljski temperaturi)/730 °C

Aerospace series - Shank nut, self-locking, in heat resisting nickel base alloy NI-P101HT (Waspaloy), silver plated, for 30° swage - Classification: 1 210 MPa (at ambient temperature) / 730 °C

Luft- und Raumfahrt - Einnietmutter, selbstsichernd, aus hochwarmfester Nickelbasislegierung NI-P101HT (Waspaloy), versilbert, für 30° Aufweitung - Klasse: 1 210 MPa (bei Raumtemperatur) / 730 °C

Série aérospatiale - Écrous à sertir, à freinage interne, en alliage résistant à chaud à base de nickel NI-P101HT (Waspaloy), argentés, pour sertissage 30° - Classification: 1 210 MPa (à température ambiante) / 730 °C

Ta slovenski standard je istoveten z: prEN 3672

ICS:

49.030.30 Matice Nuts

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EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

DRAFT
prEN 3672

March 2023

ICS 49.030.30

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English Version

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This draft European Standard is submitted to CEN members for enquiry. It has been drawn up by the Technical Committee ASD-STAN.

If this draft becomes a European Standard, 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.

This draft European Standard was established by CEN 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.

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Recipients of this draft are invited to submit, with their comments, notification of any relevant patent rights of which they are aware and to provide supporting documentation.

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

CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

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European foreword

This document (prEN 3672:2023) 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 document has received the approval of the National Associations and the Official Services of the member countries of ASD-STAN, prior to its presentation to CEN.

This document is currently submitted to the CEN Enquiry.

This document will supersede EN 3672:2016.

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prEN 3672:2023 (E)**1 Scope**

This document specifies the characteristics of self-locking shank nuts in NI-P101HT, silver plated, for use in 30° cone holes, for aerospace applications.

Classification: 1 210 MPa¹/730 °C².

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 2424, *Aerospace series - Marking of aerospace products*

EN 2786, *Aerospace series - Electrolytic silver plating of fasteners*

EN 2959, *Aerospace series - Heat resisting alloy NI-PH1302 (NiCr20Co13Mo4Ti3Al) - Solution treated and cold worked - Bar for forged fasteners - 3 mm ≤ D ≤ 30 mm³*

EN 3005, *Aerospace series - Nuts, self-locking, MJ threads, in heat resisting nickel base alloy NI-PH1302 (Waspaloy), silver plated or uncoated - Classification: 1 210 MPa (at ambient temperature) / 730 °C - Technical specification*

EN 3220, *Aerospace series - Heat resisting nickel base alloy (Ni-P101HT) - Cold worked and softened - Bar and wire for continuous forging or extrusion for fasteners - 3 mm ≤ D ≤ 30 mm³*

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

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¹ The strength class of the bolt concerned which can withstand the load at ambient temperature when tested at 100 % load without cracking or breaking of the nut.

² Maximum test temperature of the parts.

³ 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).

3 Terms and definitions

No terms and definitions are listed in this document.

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

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

4 Required characteristics

4.1 Configuration, dimensions, tolerances, masses

Configuration, dimensions, tolerances and masses shall be according to Figure 1 and Table 1 and Table 2. Dimensions and tolerances are in millimetres and apply after silver plating.

4.2 Material

Material shall be according to EN 2959 or EN 3220.

4.3 Surface treatment

Surface treatment shall be according to EN 2786 on thread, counterbore and chamfers.

Thickness:

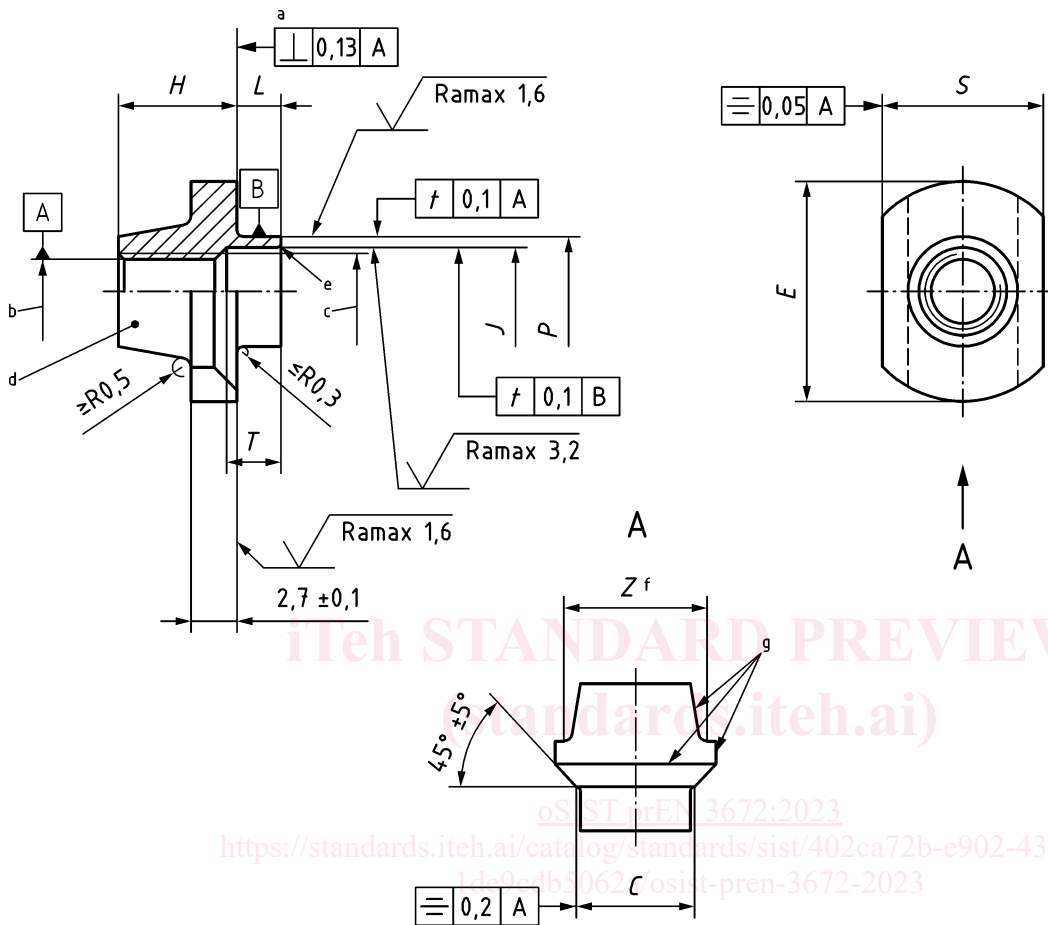
- External surfaces: 5 μm to 15 μm ;
- Thread \geq MJ6: 5 μm min.;
- Thread MJ5: shall show complete coverage, without thickness requirement.

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$$\sqrt{\text{Ramax } 6,3} \left(\sqrt{\text{Ramax } 1,6}, \sqrt{\text{Ramax } 3,2} \right)$$

Values apply before silver plating. Thread surface will be as achieved by normal methods of manufacture.



Remove sharp edges 0,1 mm to 0,4 mm

Details of form not stated are left to the manufacturer's discretion.

Key

- a Not convex
- b Pitch diameter
- c Thread
- d Form-out-round in this area to achieve the self-locking requirement (tooling marks permissible)
- e Chamfer or radius max. 0,08
- f Limit of the blend radius
- g Marking in these areas but not in locking area

Figure 1 — Shank nut

Table 1 — Dimensions and masses, (not for new design)

Code	Thread ^a Designation	<i>C</i>	$\varnothing E$	<i>H</i>	$\varnothing J$	<i>L</i>	$\varnothing P$	<i>S</i>	<i>T</i>	$\varnothing Z$	Mass 1 000 pieces kg ≈
		± 0,1	± 0,25	h14	+0,1 0	± 0,1	0 -0,1	± 0,1	± 0,25	max.	
050	MJ5 × 0,8-4H6H	7	13	7	5,2	2,6	6,5	9,5	3,2	8,5	2,77
060	MJ6 × 1-4H5H	8	14	8	6,2	2,9	7,5	10,5	3,5	9,5	3,47
070	MJ7 × 1-4H5H	9	16	9	7,2	3,1	8,5	11,5	3,7	10,5	4,2
080	MJ8 × 1-4H5H	10	17	10	8,2	3,3	9,5	12,5	4	11,5	5,41

^a In accordance with ISO 5855-2. In the self-locking zone, the tolerances apply before forming out-of-round.

Table 2 — Dimensions and masses

Code	Thread ^a Designation	<i>C</i>	$\varnothing E$	<i>H</i>	$\varnothing J$	<i>L</i>		$\varnothing P$	<i>S</i>	<i>T</i>	$\varnothing Z$	Mass 1 000 pieces kg ≈
		± 0,1	± 0,25	h14	+0,1 0	nom.	Tol.	0 +0,3	± 0,1	± 0,25	max.	
051	MJ5 × 0,8-4H6H	7	13	7	5,2	1,8		6,5	9,5	2,4	8,5	2,78
061	MJ6 × 1-4H5H	8	14	8	6,2		±0,1	7,5	10,5		9,5	3,45
071	MJ7 × 1-4H5H	9	16	9	7,2	2,8		8,5	11,5	3,4	10,5	4,28
081	MJ8 × 1-4H5H	10	17	10	8,2	3,2	±0,1 5	9,5	12,5	3,9	11,5	5,56

^a In accordance with ISO 5855-2. In the self-locking zone, the tolerances apply before forming out-of-round.

5 Designation

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

EXAMPLE

Description block **Identity block**
NUT **EN 3672-051**

Number of this standard _____

Thread code (see
Table 1 and Table 2) _____

6 Marking

Marking shall be according to EN 2424, Style A, as indicated in Figure 1.

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7 Technical specification

Technical specification shall be according to EN 3005.

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