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## **Fasteners - Acceptance inspection**

Fasteners - Acceptance inspection

## EESTI STANDARDI EESSÕNA

## NATIONAL FOREWORD

<p>Käesolev Eesti standard EVS-EN ISO 3269:2000 sisaldab Euroopa standardi EN ISO 3269:2000 ingliskeelset teksti.</p> <p>Käesolev dokument on jõustatud 15.11.2000 ja selle kohta on avaldatud teade Eesti standardiorganisatsiooni ametlikus väljaandes.</p> <p>Standard on kättesaadav Eesti standardiorganisatsioonist.</p>	<p>This Estonian standard EVS-EN ISO 3269:2000 consists of the English text of the European standard EN ISO 3269:2000.</p> <p>This document is endorsed on 15.11.2000 with the notification being published in the official publication of the Estonian national standardisation organisation.</p> <p>The standard is available from Estonian standardisation organisation.</p>
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<p><b>Käsitlusala:</b></p> <p>This International Standard specifies the acceptance inspection procedure that the purchaser of fasteners must follow in order to determine whether a lot of fasteners will be accepted or rejected in cases where no other such procedure was agreed with the supplier at the time fasteners were ordered.</p>	<p><b>Scope:</b></p> <p>This International Standard specifies the acceptance inspection procedure that the purchaser of fasteners must follow in order to determine whether a lot of fasteners will be accepted or rejected in cases where no other such procedure was agreed with the supplier at the time fasteners were ordered.</p>
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**ICS** 21.060.01

**Võtmesõnad:** acceptance, blind rivets, bolts, fasteners, inspection methods, nuts, pins, screws, washers

**English version**

**Fasteners**

Acceptance inspection  
(ISO 3269 : 2000)

Éléments de fixation – Contrôle de  
réception (ISO 3269 : 2000)

Mechanische Verbindungselemente –  
Annahmeprüfung (ISO 3269 : 2000)

This European Standard was approved by CEN on 2000-05-25.

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 Central Secretariat or to any CEN member.

The European Standards exist 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 Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, the Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, the Netherlands, Norway, Portugal, Spain, Sweden, Switzerland, and the United Kingdom.

**CEN**

European Committee for Standardization  
Comité Européen de Normalisation  
Europäisches Komitee für Normung

**Central Secretariat: rue de Stassart 36, B-1050 Brussels**

## Foreword

International Standard

ISO 3269 : 2000 Fasteners – Acceptance inspection,

which was prepared by ISO/TC 2 'Fasteners' of the International Organization for Standardization, has been adopted by Technical Committee CEN/TC 185 'Threaded and non-threaded mechanical fasteners and accessories', the Secretariat of which is held by DIN, as a European Standard.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, and conflicting national standards withdrawn, by December 2000 at the latest.

In accordance with the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard:

Austria, Belgium, the Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, the Netherlands, Norway, Portugal, Spain, Sweden, Switzerland, and the United Kingdom.

## Endorsement notice

The text of the International Standard ISO 3269 : 2000 was approved by CEN as a European Standard without any modification.

NOTE: Normative references to international publications are listed in Annex ZA (normative).

## Contents

Page

Foreword.....	2
Introduction .....	3
1 Scope .....	4
2 Normative references .....	4
3 Terms and definitions .....	6
4 General principles and requirements .....	7
5 Acceptance inspection procedure for fastener characteristics .....	8
<b>Annex A</b> (informative) <b>Recommendations for acceptance-inspection procedures (for example, for dimensional characteristics)</b> .....	14
<b>Annex B</b> (informative) <b>Guidance and explanation concerning the principles of this International Standard</b> .....	16
Bibliography .....	18

## Introduction

Although every fastener should meet all the requirements of the standard to which it is specified, in mass production this is not always possible. The manufacturer is expected to take due care during all stages of production so that the risk of parts that do not satisfy requirements is minimized. Nevertheless, the control processes used for that purpose are not the subject of this International Standard.

The purchaser may wish to confirm whether, considering the limitations of inspection by attributes of a fastener lot, it is reasonable to assume that the delivered fasteners were made to specification. In any case, it must be recognised that quality assessment of this sort cannot provide complete confidence that nonconforming fasteners do not exist within a production lot.

It is desirable that both supplier and purchaser possess a clear understanding of the quality-assessment processes to be used by the purchaser. Consequently, this International Standard defines those requirements to be applied by the purchaser where no other prior agreement exists. However, specification of acceptable quality level (AQL) values does not imply the supplier's right to knowingly supply a nonconforming unit.

**NOTE** A new ISO International Standard is to be developed to take into account fasteners produced under in-process control and a certified quality assurance system operated by the manufacturer. The new standard will also cover special agreements for selected characteristics.

## 1 Scope

**1.1** This International Standard specifies the acceptance inspection procedure that the purchaser of fasteners must follow in order to determine whether a lot of fasteners will be accepted or rejected in cases where no other such procedure was agreed with the supplier at the time the fasteners were ordered. Additional requirements for acceptance may be included in a specific product standard (for example, one on prevailing torque-type nuts). The same procedure is also to be applied in cases where conformance to specification is disputed.

**1.2** This International Standard is applicable to bolts, screws, studs, nuts, pins, washers, blind rivets and other related fasteners not intended for high volume machine assembly, special-purpose applications or specially engineered applications requiring greater in-process control and lot traceability (see the note in the introduction). The procedure for these products shall be agreed upon by the supplier and the purchaser prior to the confirmation of the order.

**1.3** This International Standard is applicable only to fully manufactured products; it neither implies nor includes any particular in-process control procedure or inspection during production.

**1.4** The production of accessories, services and partially fabricated parts (for example, washers, nuts, plating, heat treatment and blanks) for use in the manufacture of fasteners may be subcontracted to other suppliers by the fastener supplier. Nevertheless, the supplier of the final, finished product shall be solely responsible for the fastener's quality.

The requirements of this International Standard apply only to the condition of fasteners at the time of delivery. Any process carried out after receipt (for example, plating) will invalidate the requirements of this International Standard.

**1.5** Annex B (informative) offers guidance to, and an explanation of, the principles upon which this International Standard is based.

## 2 Normative references

The following normative documents contain provisions which, through reference in this text, constitute provisions of this International Standard. For dated references, subsequent amendments to, or revisions of, any of these publications do not apply. However, parties to agreements based on this International Standard are encouraged to investigate the possibility of applying the most recent editions of the normative documents indicated below. For undated references, the latest edition of the normative document referred to applies. Members of ISO and IEC maintain registers of currently valid International Standards.

ISO 898-1:1999, *Mechanical properties of fasteners made of carbon steel and alloy steel — Part 1: Bolts, screws and studs.*

ISO 898-2:1992, *Mechanical properties of fasteners — Part 2: Nuts with specified proof load values — Coarse thread.*

ISO 898-5:1998, *Mechanical properties of fasteners made of carbon steel and alloy steel — Part 5: Set screws and similar threaded fasteners not under tensile stresses.*

ISO 898-6:1994, *Mechanical properties of fasteners — Part 6: Nuts with specified proof load values — Fine pitch thread.*

ISO 1478:1999, *Tapping screws thread.*

ISO 1502:1996, *ISO general-purpose metric screw threads — Gauges and gauging.*

ISO 2320:1997, *Prevailing torque type steel hexagon nuts — Mechanical and performance properties.*

ISO 2702:1992, *Heat-treated steel tapping screws — Mechanical properties.*

ISO 2859-1:1999, *Sampling procedures for inspection by attributes — Part 1: Sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection.*

ISO 3506-1:1997, *Mechanical properties of corrosion-resistant stainless-steel fasteners — Part 1: Bolts, screws and studs.*

ISO 3506-2:1997, *Mechanical properties of corrosion-resistant stainless-steel fasteners — Part 2: Nuts.*

ISO 3506-3:1997, *Mechanical properties of corrosion-resistant stainless-steel fasteners — Part 3: Set screws and similar fasteners not under tensile stress.*

ISO 4042:1999, *Fasteners — Electroplated coatings.*

ISO 4759-1:—<sup>1)</sup>, *Tolerances for fasteners — Part 1: Bolts, screws, studs and nuts — Product grades A, B and C.*

ISO 4759-3:2000, *Tolerances for fasteners — Part 3: Plain washers for bolts, screws and nuts — Product grades A and C.*

ISO 6157-1:1988, *Fasteners — Surface discontinuities — Part 1: Bolts, screws and studs for general requirements.*

ISO 6157-2:1995, *Fasteners — Surface discontinuities — Part 2: Nuts.*

ISO 6157-3:1988, *Fasteners — Surface discontinuities — Part 3: Bolts, screws and studs for special requirements.*

ISO 7085:1999, *Mechanical and performance requirements of case hardened and tempered metric thread rolling screws.*

ISO 8839:1986, *Mechanical properties of fasteners — Bolts, screws, studs and nuts made of non-ferrous metals.*

ISO 10683:—<sup>2)</sup>, *Fasteners — Non-electrolytically applied zinc flake coatings.*

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1) To be published. (Revision of ISO 4759-1:1978)

2) To be published.