

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

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

See Eesti standard EVS-EN 3672:2016 sisaldab Euroopa standardi EN 3672:2016 ingliskeelset teksti.	This Estonian standard EVS-EN 3672:2016 consists of the English text of the European standard EN 3672:2016.
Standard on jõustunud sellekohase teate avaldamisega EVS Teatajas	This standard has been endorsed with a notification published in the official bulletin of the Estonian Centre for Standardisation.
Euroopa standardimisorganisatsioonid on teinud Euroopa standardi rahvuslikele liikmetele kättesaadavaks 21.12.2016.	Date of Availability of the European standard is 21.12.2016.
Standard on kättesaadav Eesti Standardikeskusest.	The standard is available from the Estonian Centre for Standardisation.

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English Version

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

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

This European Standard was approved by CEN on 4 March 2016.

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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.

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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 3672:2016) 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 June 2017, and conflicting national standards shall be withdrawn at the latest by June 2017.

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

This document supersedes EN 3672:2008.

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1 Scope

This European Standard 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 MPa ¹⁾/730 °C ²⁾.

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 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 mm ³⁾*

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 ≤ D ≤ 30 mm ³⁾*

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

3 Required characteristics

3.1 Configuration, dimensions, tolerances, masses

See Figure 1 and Table 1 and Table 2. Dimensions and tolerances are in millimetres. They apply after silver plating.

3.2 Material

EN 2959 or EN 3220.

3.3 Surface treatment

EN 2786 on thread, counterbore and chamfers.

Thickness:

- External surfaces: 5 μm to 15 μm;
- Thread ≥ MJ6: 5 μm min. on thread flanks;
- Thread MJ5: shall show complete coverage, without thickness requirement.

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)