

**Lennunduse ja kosmonautika seeria.  
Poldid, millel on tavaline kuuskantpea,  
väikese tolerantsiga normaalvarb,  
lühike keere, mis on legeerterasest ja  
kadmeeritud. Liigitus: 1100 MPa  
(õhutemperatuuril)/235 °C**

Aerospace series - Bolts, normal hexagonal head, close tolerance normal shank, short thread, in alloy steel, cadmium plated, metric series - Classification: 1 100 MPa (at ambient temperature) / 235 °C

## EESTI STANDARDI EESSÕNA

## NATIONAL FOREWORD

<p>Käesolev Eesti standard EVS-EN 2859:2006 sisaldab Euroopa standardi EN 2859:2006 ingliskeelset teksti.</p> <p>Käesolev dokument on jõustatud 30.08.2006 ja selle kohta on avaldatud teade Eesti standardiorganisatsiooni ametlikus väljaandes.</p> <p>Standard on kättesaadav Eesti standardiorganisatsioonist.</p>	<p>This Estonian standard EVS-EN 2859:2006 consists of the English text of the European standard EN 2859:2006.</p> <p>This document is endorsed on 30.08.2006 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> See standard määrab kindlaks selliste poltide parameetrid, millel on tavaline kuuskantpea, väikese tolerantsiga normaalvarb, lühike keere, mis on legeerterasest ja kadmeeritud. Liigitus: 1100 MPa / 235 °C.</p>	<p><b>Scope:</b> This standard specifies the characteristics of bolts, normal hexagonal head, close tolerance normal shank, short thread, in alloy steel, cadmium plated, metric series.</p>
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**ICS** 49.030.20

**Võtmesõnad:** kaadmium, kruvi, kruvikeere, kuuskantpeakruvi, legeerteras, lennukitööstus, lennundusvarustus, mass, mõõtmed, mõõtmetolerantsid, parameetrid, pinnatöötlus, spetsifikatsioon, tähistus

## English Version

Aerospace series - Bolts, normal hexagonal head, close tolerance normal shank, short thread, in alloy steel, cadmium plated, metric series - Classification: 1 100 MPa (at ambient temperature) / 235 °C

Série aérospatiale - Vis à tête hexagonale normale, fût normal à tolérance serrée, filetage court, en acier allié, cadmiées - Classification : 1 100 MPa (à température ambiante) / 235 °C

Luft- und Raumfahrt - Sechskant-Paßschrauben, kurzes Gewinde, aus legiertem Stahl, verkadmet - Klasse: 1 100 MPa (bei Raumtemperatur) / 235 °C

This European Standard was approved by CEN on 13 January 2006.

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.

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 Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.



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**Contents**

Page

Foreword.....3

1 Scope .....4

2 Normative references .....4

3 Required characteristics.....5

4 Designation .....9

5 Marking .....9

6 Technical specification ..... 10

7 Oversized bolts ..... 10

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## Foreword

This European Standard (EN 2859:2006) has been prepared by the European Association of Aerospace Manufacturers - Standardization (AECMA-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 AECMA, 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 January 2007, and conflicting national standards shall be withdrawn at the latest by January 2007.

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 2859:1995.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and the United Kingdom.

## 1 Scope

This standard specifies the characteristics of bolts, normal hexagonal head, close tolerance normal shank, short thread, in alloy steel, cadmium plated, metric series.

Classification: 1 100 MPa <sup>1)</sup> / 235 °C <sup>2)</sup>.

## 2 Normative references

The following referenced documents are indispensable for the application 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.

ISO 3193, *Aerospace – Bolts, normal hexagonal head, normal shank, short or medium length MJ threads, metallic material, coated or uncoated, strength classes less than or equal to 1 100 MPa – Dimensions.*

ISO 3353-1, *Aerospace – Lead and runout threads – Part 1: Rolled external threads.*

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

ISO 7689, *Aerospace – Alloy steel bolts with strength classification 1 100 MPa and MJ threads – Procurement specification.*

ISO 7913, *Aerospace – Bolts and screws, metric – Tolerances of form and position.*

EN 2133, *Aerospace series – Cadmium plating of steels with specified tensile strength  $\leq 1 450$  MPa, copper, copper alloys and nickel alloys.*

EN 2424, *Aerospace series – Marking of aerospace products.*

EN 4016, *Aerospace series – Oversized bolts.* <sup>3)</sup>

EN 9100, *Aerospace series – Quality management systems – Requirements (based on ISO 9001:2000) and Quality systems – Model for quality assurance in design, development, production, installation and servicing (based on ISO 9001:1994).*

EN 9133, *Aerospace series – Quality management systems – Qualification Procedure for aerospace standard parts.*

TR 3775, *Aerospace series – Bolts and pins – Materials.* <sup>4)</sup>

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1) Minimum tensile strength of the material at ambient temperature.

2) Maximum temperature that the bolt can withstand without continuous change in its original characteristics, after return to ambient temperature. The maximum temperature is determined by the surface treatment.

3) Published as ASD Prestandard at the date of publication of this standard.

4) Published as ASD Technical Report at the date of publication of this standard.