Nederlandse norm

NEN-EN 3915

(en)

Aerospace series - Insert, thin wall, self-locking, MJ threads, in heat resisting nickel base alloy NI-PH2601 (NI-P100HT, Inconel 718), for salvage of components - Classification: 1 275 MPa (at ambient temperature) / 550 °C - Technical specification

ICS 49.030.99

mei 2008

Als Nederlandse norm is aanvaard:
- EN 3915:2008,IDT

Normcommissie 345 030 "Lucht- en ruimtevaart"

NEN

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Postbus 5059, 2600 GB Delft
Telefoon (015) 2 690 390, Fax (015) 2 690 190

Nederlands voorwoord

Voor de in deze norm vermelde normatieve verwijzingen bestaan in Nederland de volgende equivalenten:

vermelde norm	Nederlandse norm	titel
EN 2404	-	-
EN 3298	NEN-EN 3298	Aerospace series - Inserts, thin wall, self-locking - Installation and removal procedure (en)
EN 3676	NEN-EN 3676	Lucht- en ruimtevaart - Dunwandige, zelfborgende schroefdraadvoeringen - Ontwerpnorm (en)
EN 4376	-	-
EN 4377	-	-
EN 9133	NEN-EN 9133	Aerospace series - Quality management systems - Qualification procedure for aerospace standard parts (en)
EN ISO 4288	NEN-EN-ISO 4288	Geometrische productspecificaties (GPS) - Oppervlaktegesteldheid - Profielmethode - Regels en procedures voor de beoordeling van de oppervlaktextuur (nl)
ISO 2859-1	-	-
ISO 3452	-	-
ISO 3534:1977	NEN 3117:1990 2e Ontw.	Statistiek - Termen, definities en symbolen (nl)
ISO 5855-2	-	-
ISO 8642	-	-

EUROPEAN STANDARD

NORME EUROPÉENNE

EUROPÄISCHE NORM

EN 3915

April 2008

ICS 49.030.99

English Version

Aerospace series - Insert, thin wall, self-locking, MJ threads, in heat resisting nickel base alloy NI-PH2601 (NI-P100HT, Inconel 718), for salvage of components - Classification: 1 275 MPa (at ambient temperature) / 550 °C - Technical specification

Série aérospatiale - Douilles filetées, à paroi mince, à freinage interne, filetage MJ, en alliage résistant à chaud à base de nickel NI-PH2601 (NI-P100HT, Inconel 718), pour récupération - Classification : 1 275 MPa (à température ambiante) / 550 °C - Spécification technique

Luft- und Raumfahrt - Gewindeeinsätze, dünnwandig, selbstsichernd, MJ-Gewinde, aus hochwarmfester Nickelbasislegierung NI-PH2601 (NI-P100HT, Inconel 718), zur Nacharbeit von Bauteilen - Klasse: 1 275 MPa (bei Raumtemperatur) / 550 °C - Technische Lieferbedingungen

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Ref. No. EN 3915:2008: E

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Foreword

This document (EN 3915:2008) 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 October 2008, and conflicting national standards shall be withdrawn at the latest by October 2008.

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1 Scope

This standard specifies the characteristics, qualification and acceptance requirements for self-locking thin wall salvage inserts with MJ threads in NI-PH2601 (NI-P100HT).

Classification: 1 275 MPa [1] / 550 °C [2].

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.

EN 2404 [3], *Heat resisting nickel base alloy NI-P100-HT — Solution treated and precipitation treated — Bars — Aerospace series.* [4]

EN 3298, *Aerospace series — Inserts, thin wall, self-locking — Installation and removal procedure.*

EN 3676, *Aerospace series — Inserts, thin wall, self-locking — Design standard.*

EN 4376, *Aerospace series — Heat resisting alloy NI-PH2601 (NiCr19Fe19Nb5Mo3) — Solution treated and precipitation treated — Bar and section — $D_e \leq 200$ mm.* [5]

EN 4377, *Aerospace series — Heat resisting alloy NI-PH2601 (NiCr19Fe19Nb5Mo3) — Non heat treated — Forging stock — a or D ≤ 300 mm.* [5]

EN 9133, *Aerospace series — Quality management systems — Qualification procedure for aerospace standard parts.*

EN ISO 4288, *Geometrical Product Specifications (GPS) — Surface texture: Profile method — Rules and procedures for the assessment of surface texture (ISO 4288:1996).*

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

ISO 3452, *Non-destructive testing — Penetrant inspection — General principles.*

ISO 3534:1977, *Statistics — Vocabulary and symbols.*

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

ISO 8642, *Aerospace — Self-locking nuts with maximum operating temperature greater than 425 °C — Test methods.*

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1) The strength class of the insert is equal to the minimum tensile stress which the insert is able to withstand at ambient temperature without breaking or cracking when tested with a bolt of higher strength class.

2) Maximum test temperature of the parts.

3) Inactive for new designation, see EN 4376 and EN 4377.

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

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

ASTM E 112-96, *Standard test methods for determining average grain size*. [6)]

AMS 4117, *Aluminum alloy, rolled or cold finished bars, rods, and wire and flash welded rings, 1.0Mg – 0.60Si – 0.28Cu – 0.20Cr, solution and precipitation heat treated*. [7)]

AMS-QQ-A-225/8, *Aluminum alloy 6061, bar, rod, wire, and special shapes; rolled, drawn, or cold finished*. [7)]

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

3.1
production batch
quantity of finished thin wall salvage inserts manufactured, using the same process, from a single material cast (single heat of alloy), having the same number (of product standard or definition document), thread code and diameter, heat treated together to the same specified condition and produced as one continuous run

3.2
inspection lot
quantity of thin wall salvage inserts from a single production batch with same number (of product standard or definition document) which completely defines the thin wall insert

3.3 Discontinuities

3.3.1
crack
rupture in the material which may extend in any direction and which may be intercrystalline or transcrystalline in character

3.3.2
seam
open surface defect

3.3.3
lap
surface defect caused by folding over metal fins or sharp corners and then rolling or forging them into the surface

3.3.4
inclusions
non-metallic particles originating from the material manufacturing process. These particles may be isolated or arranged in strings.

3.4
test temperature
ambient temperature, unless otherwise specified

6) Published by: American Society for Testing and Materials (ASTM), 100 Barr Harbor Drive,. PO Box C700, West Conshohocken, PA 19428-2959 USA.

7) Published by: Society of Automotive Engineers, Inc. (SAE), 400 Commonwealth Drive, Warrendale, PA 15096-0001, USA.

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__ ex. NEN-EN 3915:2008 en Aerospace series - Insert, thin wall, self-locking, MJ threads, in heat resisting nickel base alloy NI-PH2601 (NI-P100HT, Inconel 718), for salvage of components - Classification: 1 275 MPa (at ambient temperature) / 550 °C - Technical specification — € 50.04

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