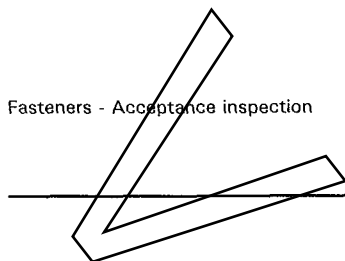


**norm****NEN-EN-ISO 3269**Bevestigingsartikelen -  
Aanvaardingskeuring

Publicatie uitsluitend voor commentaar



Fasteners - Acceptance inspection

juli 1998

ICS 21.060.01

Commentaar voor 1998-10-01

Als Europees normontwerp is gepubliceerd: prEN ISO 3269:1998

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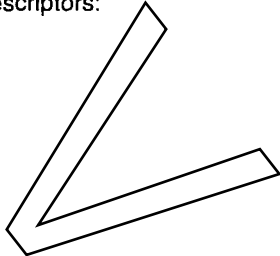
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Voorbeeld  
Preview

May 1998

ICS

Descriptors:



English version

## Fasteners - Acceptance inspection

Eléments de fixation - Contrôle de réception

Mechanische Verbindungselemente - Annahmeprüfung

This draft European Standard is submitted to CEN members for parallel enquiry. It has been drawn up by the Technical Committee CEN/TC 185.

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 Central Secretariat has the same status as the official versions.

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

Preview



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

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

## Foreword

The text of the International Standard ISO/DIS 3269:1998 has been prepared by Technical Committee ISO/TC 2 "Fasteners" in collaboration with Technical Committee CEN/TC 185 "Threaded and non-threaded mechanical fasteners and accessories", the secretariat of which is held by DIN.

This European Standard has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association, and supports essential requirements of EU Directive(s).

This document is currently submitted to the parallel Enquiry.

## Endorsement notice

The text of the International Standard ISO/DIS 3269:1998 has been approved by CEN as a European Standard without any modifications.

NOTE: Normative references to International Standards are listed in annex ZA (normative).



# Fasteners — Acceptance inspection

[Revision of second edition (ISO 3269:1988)]

*Éléments de fixation — Contrôle de réception*

ICS 21.060.01

Descriptors: fasteners, bolts, screws, studs, nuts (fasteners), pins, washers, blind rivets, inspection methods, acceptance.

Preview

## ISO/CEN PARALLEL ENQUIRY

The CEN Secretary-General has advised the ISO Secretary-General that this ISO/DIS covers a subject of interest to European standardization. **In accordance with subclause 5.1 of the Vienna Agreement, consultation on this ISO/DIS has the same effect for CEN members as would a CEN enquiry on a draft European Standard.** Should this draft be accepted, a final draft, established on the basis of comments received, will be submitted to a parallel two-month FDIS vote in ISO and formal vote in CEN.

THIS DOCUMENT IS A DRAFT CIRCULATED FOR COMMENT AND APPROVAL. IT IS THEREFORE SUBJECT TO CHANGE AND MAY NOT BE REFERRED TO AS AN INTERNATIONAL STANDARD UNTIL PUBLISHED AS SUCH.

IN ADDITION TO THEIR EVALUATION AS BEING ACCEPTABLE FOR INDUSTRIAL, TECHNOLOGICAL, COMMERCIAL AND USER PURPOSES, DRAFT INTERNATIONAL STANDARDS MAY ON OCCASION HAVE TO BE CONSIDERED IN THE LIGHT OF THEIR POTENTIAL TO BECOME STANDARDS TO WHICH REFERENCE MAY BE MADE IN NATIONAL REGULATIONS.

Voorbeeld  
Preview

## Fasteners – Acceptance inspection

### 0 Introduction

Although every fastener should meet all requirements of its standard specification, in mass production this is not always possible. The manufacturer is expected to take due care during all production stages to minimize the risk of parts which do not satisfy all requirements but the control processes used for this purpose are not the subject of this standard.

The purchaser may wish to confirm, within the limitations of inspection by attributes of a completed lot of fasteners, that the fasteners as received can be reasonably assumed to have been manufactured to the specified requirements. It must be recognised however, that quality assessment in this manner cannot provide complete confidence that non-conforming fasteners do not exist within the production lot.

It is desirable that both the supplier and the purchaser have a clear understanding of the quality assessment processes which will be used by the purchaser. This standard therefore establishes requirements to be applied by the purchaser if no other prior agreement exists, but the specification of AQLs does not imply that the supplier has the right to supply knowingly any non-conforming unit.

NOTE: A further ISO standard will be developed which takes into account the situation where the fasteners have been produced under in-process control and a certified quality assurance system is operated by the manufacturer. The new standard will apply to specified characteristics only.

### 1 Scope

1.1 This International Standard specifies the procedure to be followed by the purchaser at his acceptance inspection in order to decide whether a lot of fasteners may be accepted or rejected, when no other acceptance procedure has been agreed with the supplier at the time of ordering the fasteners. Additional specific acceptability requirements may be included within a specific product standard (for example, prevailing torque type nuts). This procedure is also to be applied when conformance to specification is disputed.

1.2 It applies to bolts, screws, studs, nuts, pins, washers, blind rivets and other related fasteners not intended for high volume machine assembly, for special purpose applications or for specially engineered applications requiring greater in-process control and lot traceability (see however the NOTE in the introduction). Procedure for these products shall be agreed between supplier and customer prior to confirmation of the order.

1.3 It applies to fully manufactured products only and neither implies nor includes any particular in-process control procedure or inspection during production.

1.4 Accessories, services and partially fabricated parts (for example, washers, nuts, plating, heat treatment, blanks, etc.) may be purchased by the supplier from other suppliers for use in production of fasteners. However, the supplier of the fully manufactured product shall be solely responsible for the quality of the final product.

The requirements of this International Standard apply only to the delivery condition of the fasteners. Any process carried out after receipt (e.g. plating) will invalidate the requirements of this standard.

1.5 The annex B gives notes for guidance and explains the principles of this International Standard.

## 2 Normative references

The following normative documents contain provisions which, through reference in this text, constitute provisions of this International Standard. At the time of publication, the editions indicated were valid. All normative documents are subject to revision, and 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. Members of IEC and ISO maintain registers of currently valid International Standards.

- ISO/DIS 898-1 : 1996  
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/DIS 898-5 : 1996  
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 : 1983  
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 : 1989  
Sampling procedures for inspection by attributes – Part 1: Sampling plans indexed by acceptance quality level (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 3534-2 : 1993  
Statistics – Vocabulary and symbols – Part 2: Statistical quality control
- ISO/DIS 4042 : 1996  
Fasteners – Electroplated coatings
- ISO/DIS 4759-1 : 1997  
Tolerances for fasteners – Part 1: Bolts, screws, studs and nuts – Product grades A, B and C



ISO 4759-3<sup>2)</sup>

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/DIS 7035-1<sup>1)</sup>

Mechanical and performance requirements of thread rolling screws – Part 1: Case hardened and tempered thread rolling screws

ISO 8402 : 1986

Quality – Vocabulary

ISO 8839 : 1986

Mechanical properties of fasteners – Bolts, screws, studs and nuts made of non-ferrous metals

ISO 8992 : 1986

Fasteners – General requirements for bolts, screws, studs and nuts

### 3 General principles and requirements

**3.1** The purchaser may test the fasteners delivered for function and utilization, as he judges necessary or economically justifiable, provided that the supplier's risk is not more than 5 % (see table 2), unless prior agreement has been reached.

**3.2** It is important that, during acceptance inspection, stress is laid on the fitness of the product to perform its intended function. Objections shall only be raised if the non-conformities impair the intended function and/or utilization of the fasteners. Therefore it is not always necessary to carry out all tests specified in the standards.

The purchaser shall give the supplier the opportunity of verifying nonconformities discovered.

If at the time of inspection the subsequent function is uncertain (for example, stock parts), any deviation from the specified tolerances shall be regarded as impairing the function and/or utilization.

**3.3** A rejected lot of fasteners shall not be presented for reinspection unless the nonconformity has been rectified or the lot sorted (see 5.6).

NOTE: If such rectification could impair the intended function and utilization, it requires the consent of the purchaser.

**3.4** Gauges and measuring instruments used for inspection shall not determine any fastener to be unacceptable if in fact the fastener dimensions and properties are within specification limits. If disputes arise, direct measurements shall be made for decision.

This does not apply to threads for which the checking with gauges is always decisive, see also ISO 1502.

<sup>1)</sup> To be published

<sup>2)</sup> At present at the stage of draft

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