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IRISH STANDARD

I.S. EN 3328:2008

ICS 49.030.20

National Standards
Authority of Ireland
Northwood, Dublin 9
Ireland
Tel: +353 1 807 3800
Fax: +353 1 807 3838
http://www.nsai.ie

Sales
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AEROSPACE SERIES - BOLTS, DOUBLE HEXAGON HEAD, CLOSE TOLERANCE, MEDIUM THREAD LENGTH, IN HEAT RESISTING STEEL FE-PM38 (FV535), UNCOATED - CLASSIFICATION: 1 000 MPA/550 °C

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EUROPEAN STANDARD

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English Version

Aerospace series - Bolts, double hexagon head, close tolerance, medium thread length, in heat resisting steel FE-PM38 (FV535), uncoated - Classification: 1 000 MPa/550 °C

Série aérospatiale - Vis de précision à tête bihexagonale, à filetage moyen, en acier résistant à chaud FE-PM38 (FV535), non revêtu - Classification: 1 000 MPa/550 °C

Luft-und Raumfahrt - Zwölftkant-Passschrauben, mittlere Gewindelänge, aus hochwarmfestem Stahl FE-PM38 (FV535), blank - Klasse: 1 000 MPa/550 °C

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Foreword

This document (EN 3328:2008) 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of an identical text or by endorsement, at the latest by November 2008, and conflicting national standards shall be withdrawn at the latest by November 2008.

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1 Scope

This standard specifies the dimensions of the uncoated double hexagon head bolts, close tolerance, with MJ-thread, medium thread length, in heat resisting steel FE-PM38 for aerospace applications.

Maximum test temperature of the parts is 550 °C.

These bolts are to be used in aerospace fastening systems mainly stressed in shearing force.

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 2424, *Aerospace series — Marking of aerospace products*[1)]

EN 2493, Aerospace series — Heat resisting steel FE-PM38 — *1 000 MPa* $\leq R_m \leq$ *1 140 MPa — Bars*

EN 3302, *Aerospace series — Bolts in heat resisting steel FE-PM38 (FV535) — Classification: 1 000 MPa/550 °C — Technical specification*[1)]

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

ISO 4095, *Aerospace — Bihexagonal drives — Wrenching configuration — Metric series*

ISO 5855-1, *Aerospace — MJ threads — Part 1: General requirements*

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

3 Required characteristics

3.1 Configuration, dimensions, tolerances, masses

Configuration shall be in accordance with Figure 1. Dimensions, tolerances and masses shall conform to Figure 1 and Tables 1 and 2. Details of form, not stated are at the manufacturer's option.

3.2 Material

Heat resisting steel FE-PM38 according to EN 2493.

3.3 Surface treatment

None.

3.4 Thread surface

See Figure 1.

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1) Published as AECMA prestandard at the date of publication of this standard.

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