National Standards Authority of Ireland

IRISH STANDARD

I.S. EN 3444:2006

ICS 49.030.30

AEROSPACE SERIES - BOLT, LARGE BIHEXAGONAL HEAD, CLOSE TOLERANCE NORMAL SHANK, MEDIUM LENGTH THREAD, IN HEAT RESISTING NICKEL BASE ALLOY, PASSIVATED - CLASSIFICATION: 1 250 MPA (AT AMBIENT TEMPERATURE) / 650 °C

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EUROPEAN STANDARD

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EUROPÄISCHE NORM

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English Version

Aerospace series - Bolt, large bihexagonal head, close tolerance normal shank, medium length thread, in heat resisting nickel base alloy, passivated - Classification: 1 250 MPa (at ambient temperature) /650 °C

Série aérospatiale - Vis à tête bihexagonale large, tige normale à tolérance serrée, filetage moyen, en alliage résistant à chaud à base de nickel, passivées - Classification: 1 250MPa (à température ambiante) / 650 °C

Luft- und Raumfahrt - Zwölfkant-Passschrauben, mittlere Gewindelänge, aus hochwarmfester Nickelbasislegierung, passiviert, - Klasse: 1 250 MPa (bei Raumtemperatur)/650 °C

This European Standard was approved by CEN on 9 March 2006.

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

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Foreword

This European Standard (EN 3444:2006) has been prepared by the AeroSpace and Defense 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of an identical text or by endorsement, at the latest by January 2007, and conflicting national standards shall be withdrawn at the latest by January 2007.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.

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1 Scope

This standard specifies the characteristics of bolts, large bihexagonal head, close tolerance normal shank, medium length thread, in heat resisting nickel base alloy, passivated.

Classification: 1 250 MPa[1] / 650 °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 2424, *Aerospace series — Marking of aerospace products*

EN 2516, *Aerospace series — Passivation of corrosion resistant steels and decontamination of nickel base alloys*

EN 3769, *Aerospace series — Electrolytic polishing of corrosion resistant steels and heat resisting alloys*

EN 4016, *Aerospace series — Oversized bolts*[3]

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*

ISO 3186, *Aerospace — Bolts, large bihexagonal head, normal shank, short or medium length MJ threads, metallic material, coated or uncoated, strength classes 1 250 MPa to 1 800 MPa — Dimensions*

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

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

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

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

ISO 9154, *Aerospace — Bolts, with MJ threads, made of heat-resistant nickel-based alloy, strength class 1 550 MPa — Procurement specification*

TR 3775, *Aerospace series — Bolts and pins — National materials*[4]

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

2) Maximum temperature that the nut is able to withstand, without permanent alteration to its original characteristics, after ambient temperature has been restored. The maximum temperature is conditioned by the cadmium plating.

3) In preparation at the date of publication of this standard.

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