This is a free page sample. Access the full version online.

NSAI Standards

Irish Standard
I.S. EN 3916:2008

Aerospace series - Insert, thin wall - Salvage procedure for components

© NSAI 2008 No copying without NSAI permission except as permitted by copyright law.

This is a free page sample. Access the full version online.

I.S. EN 3916:2008

Incorporating amendments/corrigenda issued since publication:

This standard replaces:	*This standard is based on:* EN 3916:2008	*Published:* 6 August, 2008

This Irish Standard was published under the authority of the NSAI and comes into effect on: 15 September, 2008	ICS number: 49.030.99

NSAI 1 Swift Square, Northwood, Santry Dublin 9	T +353 1 807 3800 F +353 1 807 3838 E standards@nsai.ie W NSAI.ie	Sales: T +353 1 857 6730 F +353 1 857 6729 W standards.ie	Price Code: G

Údarás um Chaighdeáin Náisiúnta na hÉireann

This is a free page sample. Access the full version online.

I.S. EN 3916:2008

EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

EN 3916

August 2008

ICS 49.030.99

English Version

Aerospace series - Insert, thin wall - Salvage procedure for components

Série aérospatiale - Douilles filetées, à paroi mince - Procédure pour récupération

Luft- und Raumfahrt - Gewindeeinsätze, dünnwandig - Verfahren für Nacharbeit von Bauteilen

This European Standard was approved by CEN on 3 April 2008.

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 CEN Management Centre 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 CEN Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, 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.

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

Management Centre: rue de Stassart, 36 B-1050 Brussels

© 2008 CEN All rights of exploitation in any form and by any means reserved worldwide for CEN national Members.

Ref. No. EN 3916:2008: E

This is a free page sample. Access the full version online.

Contents

Page

Foreword 3

1 Scope 4

2 Normative references 4

3 Conditions of use 4

4 Re-machining of an existing insert hole 5

5 Insert and tapped hole particulars 6

6 Installation of oversize inserts 9

7 Minimum criteria for the installation and removal tools and their methods of application 9

8 Assembly drive tool and swage tool 10

9 Assembly procedure 11

9.1 Insertion 11

9.2 Swaging 12

9.3 Gauging and inspection 13

10 Oversize insert removal, replacement and tools 14

This is a free page sample. Access the full version online.

Foreword

This document (EN 3916:2008) 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 February 2009, and conflicting national standards shall be withdrawn at the latest by February 2009.

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.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, 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.

This is a free page sample. Access the full version online.

1 Scope

1.1 This specification covers the accepted methods for the reclamation of installation holes for standard thin wall inserts, within assemblies.

1.2 To enable rectification when defects or damage occur to the standard insert tapped installation hole, or to rectify any out of position of the hole within the specified parameters of use.

1.3 To control the machining of the existing insert hole and the installation requirements of the replacement oversize thin wall insert.

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 3676:1998, *Aerospace series — Inserts, thin wall, self-locking — Design standard*

EN 3913, *Aerospace series — Insert, thin wall, self-locking, short, in heat resisting nickel base alloy NI-PH2601 (NI-P100HT, Inconel 718), silver plated on internal thread, for salvage of components*

EN 3914, *Aerospace series — Insert, thin wall, self-locking, long, in heat resisting nickel base alloy NI-PH2601 (NI-P100HT, Inconel 718), silver plated on internal thread, for salvage of components*

EN 3915, *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*

ISO 965-1, *ISO general-purpose metric screw threads — Tolerances — Part 1: Principles and basic data*

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

3 Conditions of use

3.1 After reclamation, assemblies shall conform to the dimensional requirements of their respective Engineering Drawings.

3.2 Table 1 shows the values for the maximum out of position as applied to the theoretical centreline of the original hole. In practice this is a cylinder of diameter *x,xx* applied down the theoretical centreline of the original hole. If the actual position of the hole centreline falls outside the perimeter of this cylinder, the hole cannot be reclaimed.

3.3 Salvage using oversize inserts is only possible if the 'Boss thickness for component salvage' has been used in the original design (see EN 3676:1998, Table 6).

3.4 The reclamation facility shall at this stage investigate the component Engineering Drawings to check that the operations detailed and controlled by sections 4 and 5 will not cause a further non conformance of the component.

Table 2 demonstrates that 2 types of oversize insert can be used i.e. long or short. Before commencing reclamation, the original Engineering Drawings shall be checked to establish which type of standard insert has been used i.e. long or short. The replacement oversize insert and accompanying dimensions from this specification shall correspond with it, i.e. short for short, long for long.

SAI GLOBAL

This is a free preview. Purchase the entire publication at the link below:

Product Page

Looking for additional Standards? Visit Intertek Inform Infostore

Learn about LexConnect, All Jurisdictions, Standards referenced in Australian legislation