

BS EN 3264:2010



BSI Standards Publication

# Aerospace series — Pipe coupling 8°30' in titanium alloy — Thrust wire nuts

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**National foreword**

This British Standard is the UK implementation of EN 3264:2010. It supersedes BS EN 3264:2001, which is withdrawn.

The UK participation in its preparation was entrusted to Technical Committee ACE/12, Aerospace fasteners and fastening systems.

A list of organizations represented on this committee can be obtained on request to its secretary.

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**Amendments issued since publication**

Date	Text affected
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English Version

**Aerospace series - Pipe coupling 8°30' in titanium alloy - Thrust  
wire nuts**Série aérospatiale - Système de raccordement 8°30' en  
alliage de titane - Écrous à joncLuft- und Raumfahrt - Rohrverschraubung 8°30' aus  
Titanlegierung - Muttern mit Schubdraht

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## Foreword

This document (EN 3264:2010) 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of an identical text or by endorsement, at the latest by January 2010, and conflicting national standards shall be withdrawn at the latest by January 2010.

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## 1 Scope

This European Standard specifies the characteristics of thrust wire nuts for pipe couplings 8°30', in titanium alloy, for aerospace applications.

Nominal pressure: up to 28 000 kPa

Temperature range: – 55 °C to 135 °C

## 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 2491, *Aerospace series — Molybdenum disulphide dry lubricants — Coating methods*

EN 3275, *Aerospace series — Pipe coupling 8°30' up to 28 000 kPa — Dynamic beam seal — Metric series — Technical specification*

EN 3311, *Aerospace series — Titanium alloy TI-P64001 (Ti-6Al-4V) — Annealed — Bar for machining — D ≤ 110 mm*

EN 3314, *Aerospace series — Titanium alloy TI-P64001 — Solution treated and aged — Bar for machining — D ≤ 75 mm<sup>1)</sup>*

EN 4032, *Aerospace series — Pipe coupling 8°30' in titanium alloy — Thrust wire*

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

ISO 5855-3, *Aerospace — MJ threads — Part 3: Limit dimensions for fittings for fluid systems*

ISO 8788, *Aerospace — Nuts, metric — Tolerances of form and position*

## 3 Required characteristics

### 3.1 Configuration – Dimensions – Mass

According to Figure 1 and Table 1. The values apply before lubricating.

### 3.2 Surface roughness

According to Figure 1.

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1) Published as ASD-STAN Prestandard at the date of publication of this standard by Aerospace and Defence Industries Association of Europe-Standardization (ASD-STAN), ([www.asd-stan.org](http://www.asd-stan.org)).

### 3.3 Material

According to EN 3311 or EN 3314

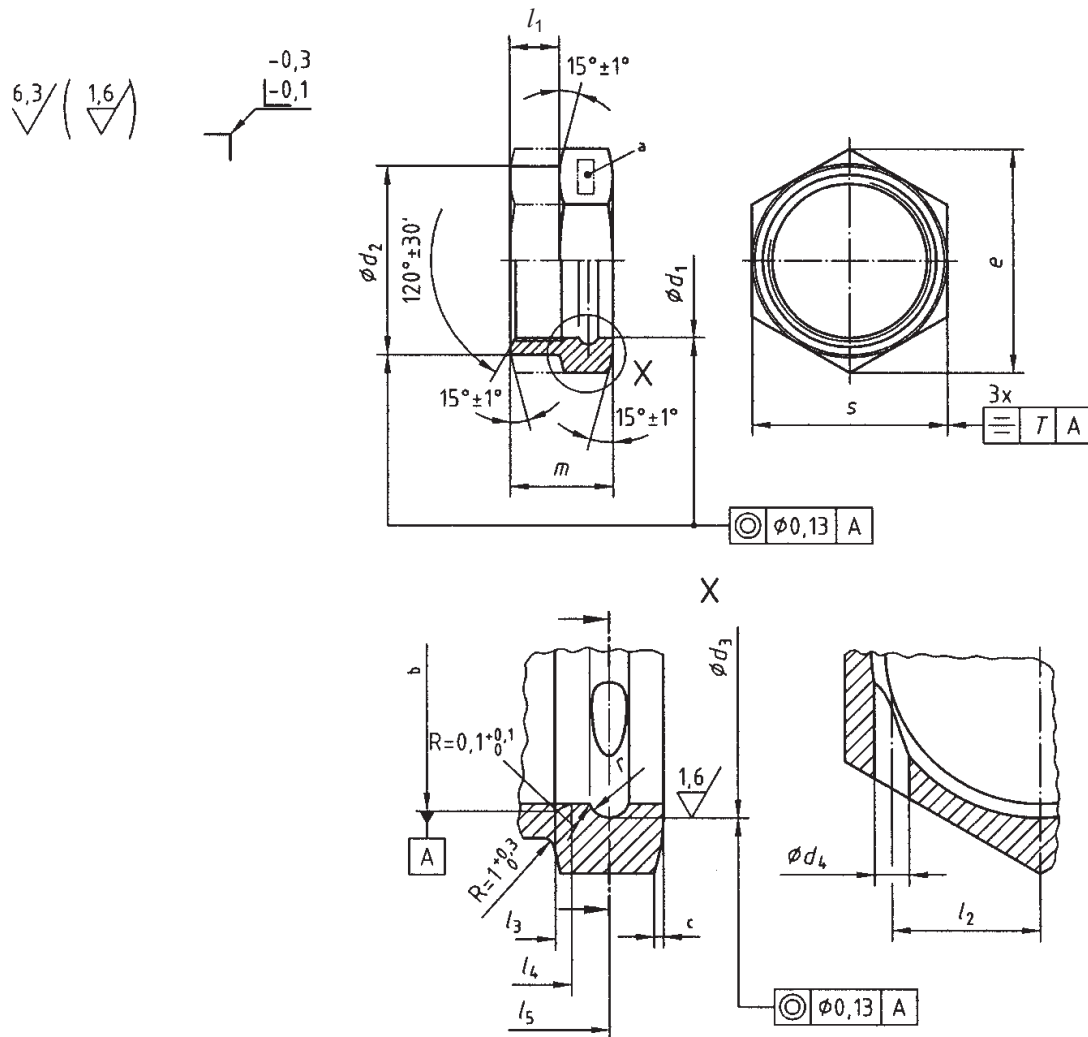
### 3.4 Surface treatment

Lubrication: according to EN 2491, on the bottom of the groove only.

Prior to application of the lubricant the surface shall be abrasive blasted using non-metallic grit.

Film thickness: 0,005 mm to 0,013 mm

Dimensions in millimetres



- a Area for marking
- b Thread
- c 0,3 to 0,5 applicable to both faces

Figure 1

Table 1

Dimensions in millimetres

Code <sup>a</sup>	Thread <sup>b</sup> 4H5H	$d_1$ $\pm 0,1$	$d_2$ $\begin{matrix} 0 \\ -0,2 \end{matrix}$	$d_3$ $\begin{matrix} +0,1 \\ 0 \end{matrix}$	$d_4^c$ $\begin{matrix} +0,1 \\ 0 \end{matrix}$	$e$ min.	$l_1$ $\pm 0,4$	$l_2$ $\pm 0,1$	$l_3^d$	$l_4$ max.	$l_5$ $\pm 0,1$	$m$ h11	$r$ $\begin{matrix} +0,1 \\ 0 \end{matrix}$	$s$ h13	$T^e$	Mass g/piece max.	
05	MJ10 × 1	9,1	–	11,0	2,2	15,51	–	4,2	7,2	8,4	10,0	13,0	1,3	14	0,36	5,52	
06	MJ12 × 1,25	10,8	–	12,6		17,77	–	5,2	8,0	9,2	11,0	14,0		16	0,43	7,36	
08	MJ14 × 1,5	12,6	17,0	14,6		20,03	11,0	6,2	9,5	11,0	13,0	16,0		18			9,00
10	MJ16 × 1,5	14,6	19,0	16,6		23,36	10,5	7,2	14,0	16,5	21	10,64					
12	MJ18 × 1,5	16,6	21,0	19,2	24,49	8,2		17,5		22							
14	MJ20 × 1,5	18,6	23,0	21,2	2,7	26,75	9,2	18,0	1,6	24	11,56						
16	MJ22 × 1,5	20,6	26,0	23,2		30,14	10,2	27	17,50								
18	MJ24 × 1,5	22,6	28,0	25,2	3,2	33,53	10,0	11,2		10,5	12,0	19,0	1,9	30	0,52	23,66	
20	MJ27 × 1,5	25,6	31,0	28,2		35,72		12,5	32								23,23
22	MJ30 × 1,5	28,6	35,0	31,2		39,98		13,7	36								
25	MJ33 × 1,5	31,6	38,0	34,2	45,63	9,5	15,5	14,5	19,5	41	36,63						
28	MJ36 × 1,5	34,6	41,0	37,2	51,28		17,2					46	0,62	42,00			
32	MJ39 × 1,5	37,6	45,0	40,2	55,80		18,6								50	51,45	

<sup>a</sup> Corresponds to the pipe nominal outside diameter.

<sup>b</sup> According to ISO 5855-3.

<sup>c</sup> Corresponding wire diameter according to EN 4032.

<sup>d</sup> Minimum usable thread length.

<sup>e</sup> According to ISO 8788.

## 4 Designation

EXAMPLE

<p><b>Description block</b></p> <p><b>THRUST WIRE NUT</b></p>		<p><b>Identity block</b></p> <p><b>EN3264-05</b></p>
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Number of this standard \_\_\_\_\_

Code (see Table 1) \_\_\_\_\_

NOTE If necessary, the code I9005 shall be placed between the description block and the identity block.



## **5 Marking**

According to EN 2424, style A and Figure 1.

## **6 Technical specification**

According to EN 3275, type II.

## **7 Qualification**

According to EN 9133.

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