Aerospace series — Nuts, anchor, self-locking, fixed, two lug, with counterbore, in heat resisting steel, MoS_2 lubricated — Classification: 1 100 MPa (at ambient temperature)/315 °C

ICS 49.030.30

National foreword

This British Standard is the UK implementation of EN 3537:2010.

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.

This publication does not purport to include all the necessary provisions of a contract. Users are responsible for its correct application.

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This British Standard was published under the authority of the Standards Policy and Strategy Committee on 31 March 2010

ISBN 978 0 580 70740 7

Amendments/corrigenda issued since publication

Date	Comments

EUROPEAN STANDARD

NORME EUROPÉENNE

EUROPÄISCHE NORM

EN 3537

February 2010

ICS 49.030.30

English Version

Aerospace series - Nuts, anchor, self-locking, fixed, two lug, with counterbore, in heat resisting steel, MoS_2 lubricated - Classification: 1 100 MPa (at ambient temperature)/315 °C

Série aérospatiale - Écrous à river, à freinage interne, fixes, double patte, avec chambrage, en acier résistant à chaud, lubrifiés MoS_2 - Classification: 1 100 MPa (à température ambiante)/315 °C

Luft- und Raumfahrt - Annietmuttern, selbstsichernd, beiderseitiger Flansch, mit zylindrischer Aussenkung, aus hochwarmfestem Stahl, MoS_2-geschmiert - Klasse: 1 100 MPa (bei Raumtemperatur)/315 °C

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EUROPÄISCHES KOMITEE FÜR NORMUNG

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Ref. No. EN 3537:2010: E

Contents

Page

Foreword

This document (EN 3537:2010) 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of an identical text or by endorsement, at the latest by August 2010, and conflicting national standards shall be withdrawn at the latest by August 2010.

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1 Scope

This European Standard specifies the characteristics of two lug, counterbored fixed anchor nuts, with a self-locking feature achieved by forming the upper portion out-of-round, in heat resisting steel, MoS_2 lubricated.

Classification: 1 100 MPa [1] / 315 °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.

ISO 3223, *Aerospace — Nuts, anchor, self-locking, fixed, two lug, with counterbore, with MJ threads, classifications: 1 100 MPa (at ambient temperature)/235 °C, 1 100 MPa (at ambient temperature)/315 °C and 1 100 MPa (at ambient temperature)/425 °C — Dimensions*

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

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

EN 2398, *Aerospace series — Heat resisting steel FE-PA2601 (X6NiCrTiMoV26-15) — $R_m \geq 900$ MPa — Bars for machined bolts — $D \leq 25$ mm*

EN 2399, *Aerospace series — Heat resisting steel FE-PA2601 (X4NiCrTiMoV26-15) — $R_m \geq 900$ MPa — Bars for forged bolts — $D \leq 25$ mm*

EN 2424, *Aerospace series — Marking of aerospace products*

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

EN 3638, *Aerospace series — Heat resisting alloy FE-PA2601 (X6NiCrTiMoV26-15) — Consumable electrode remelted — Solution and precipitation treated — Sheet, strip and plate — $0,5 \text{ mm} \leq a \leq 10$ mm*

EN 3639, *Aerospace series — Heat resisting alloy FE-PA2601 — Softened and cold worked — Wire for forged fasteners — $D \leq 15$ mm — 900 MPa $\leq R_m \leq$ 1 100 MPa* [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)*

1) Corresponds to strength class of the associated bolt, the 100 per cent load of which it is able to withstand, when tested at ambient temperature, without breaking or cracking.

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 surface treatment.

3) Published as ASD-STAN Prestandard at the date of publication of this standard.

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

TR 3791, *Aerospace series — Materials for self-locking nuts, threaded inserts and screw thread inserts of temperature classes ≤ 425 °C* [4)]

3 Required characteristics

3.1 Configuration — Dimensions — Masses

See Figure 1 and Table 1.

Dimensions and tolerances are: in conformity with ISO 3223, expressed in millimetres and apply before MoS_2 lubrication.

Form and position tolerances shall be in conformity with ISO 8788 and those specified in Table 1.

3.2 Materials

EN 2398, EN 2399, EN 3638, EN 3639 or TR 3791

3.3 Surface treatment

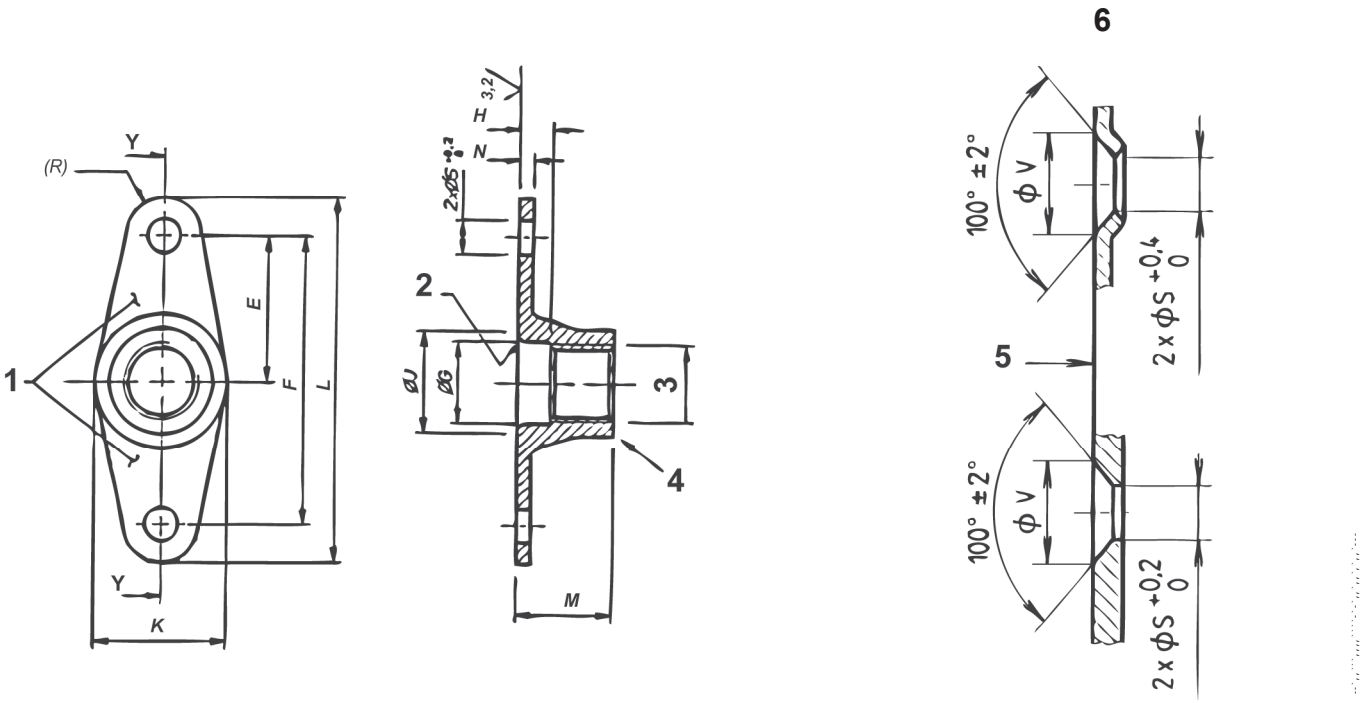
EN 2491, thickness not specified.

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

6,3 [3,2] These values in micrometres apply before surface treatment. The values do not apply to threads and sheared edges the surface texture of which will be achieved by usual manufacturing methods.

Remove sharp edges 0,1 to 0,4.

Details of form not stated are at the manufacturer's option.



Key

1 Marking

2 Radius or chamfer

3 Thread

4 Form out-of-round in this area to achieve the self-locking. Tooling marks are permitted in this area.

5 Bearing face of the nut

6 Alternatives: countersunk rivet holes (when specified by purchaser) may be dimpled or cut countersunk (at manufacturer's option).

Figure 1

Table 1

Diameter code	Thread [a]	*E*	*F*	*G* min.	*H* min.	*J* [b] max.	*K* max.	*L* max.	*M* max.	*N* [c] max.	*R* aux.	*S*	*V* ± 0,25	Mass kg/1000 pieces approx.
030	MJ3×0,5-4H6H	6	12	d	d	4,6	6	17,2	3,2	1	2,5	2,5	4,8	0,45
040	MJ4×0,7-4H6H	8,5	17	4,4	2,2	6,2	8	23,2	5,8					1,15
050	MJ5×0,8-4H6H	9,5	19	5,5	2,4	7,3	9	25,2	6,9		3			1,30
060	MJ6×1-4H5H	11	22	6,5	2,7	8,7	10	29,2	8,1	1,2	3,5			2,10
080	MJ8×1-4H5H			8,5		10,9	13		9,9	1,5		3	5,7	4,40
100	MJ10×1,25-4H5H	13	26	10,5	3	12,9	16,2	35,2	12	1,6	5	3,5	6,6	7,65

[a] In accordance with ISO 5855-2. In the self-locking zone, the tolerances apply before forming out-of-round.

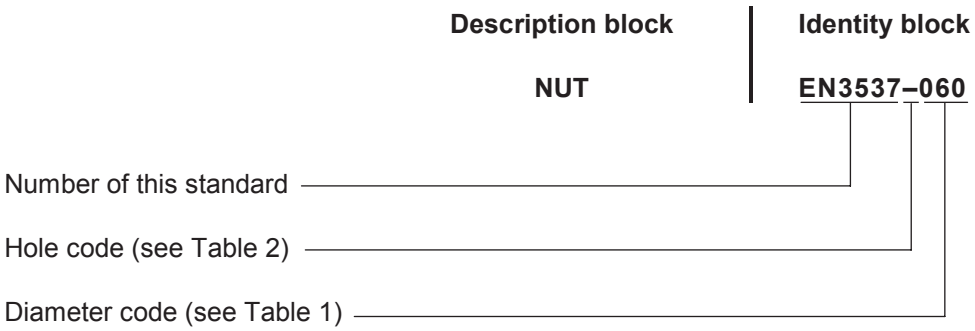
[b] Is to sharp corners (chamfered) or point of tangency (radiused).

[c] Is applicable at the rivet hole location.

[d] Diameter code 030 does not have a counterbore.

4 Designation

EXAMPLE



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

Table 2

Option	Code
Plain rivet holes	— (hyphen)
Countersunk or dimpled rivet holes	K

5 Marking

EN 2424, style N. See Figure 1.

6 Technical specification

ISO 5858-2, except for:

— Approval of manufacturers: see EN 9100;

— Qualification of products: see EN 9133.

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