

BS EN 3635:2014



BSI Standards Publication

Aerospace series — Weld lip — Geometrical configuration

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National foreword

This British Standard is the UK implementation of EN 3635:2014. It supersedes BS EN 3635:2008 which is withdrawn.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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EUROPEAN STANDARD

EN 3635

NORME EUROPÉENNE

EUROPÄISCHE NORM

October 2014

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English Version

Aerospace series - Weld lip - Geometrical configurationSérie aérospatiale - Embout à souder - Configuration
géométriqueLuft- und Raumfahrt - Rohranschlussende geschweißt -
Masse

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Contents

	Page
Foreword.....	3
1 Scope	4
2 Normative references	4
3 Fitting dimensions	4
4 Tube end geometry	6
5 Designation	6
6 Indications on drawings	7
Annex A (informative) Standard evolution form	8

Foreword

This document (EN 3635:2014) 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.

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1 Scope

The purpose of this European Standard is to specify the dimensions and tolerances for orbital-welding fittings, intended for stainless steel fluid pipes to EN 3717.

2 Normative references

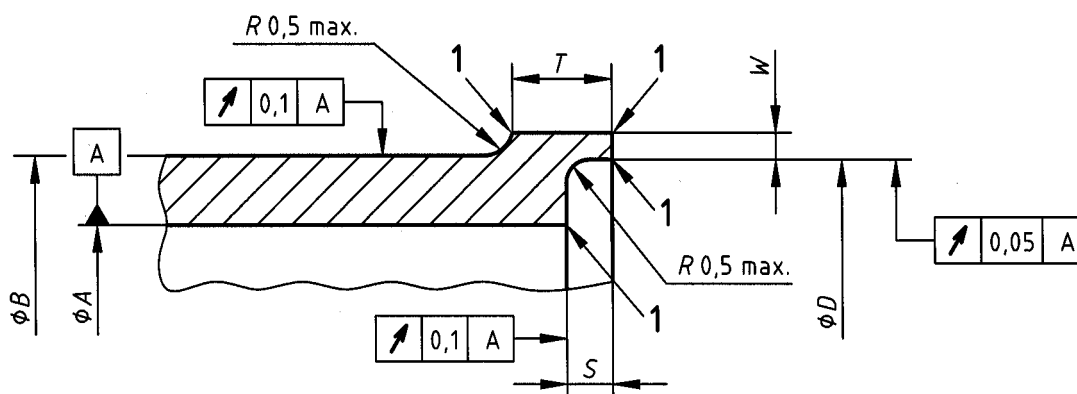
The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 3717, *Aerospace series — Tubes — Selection for engines fluid systems*

3 Fitting dimensions

See Figure 1 and Table 1.

1,6
√



Key

1 Break edges 0,1 max.

Figure 1

Table 1 — Dimensions

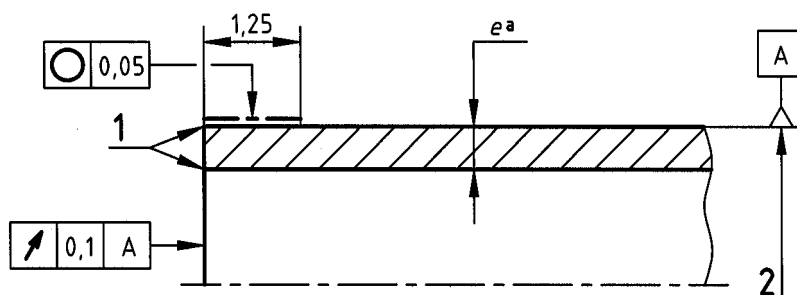
Dimensions in millimetres

Diameter code	Tube outside diameter h12	(e) ^a	$\varnothing A$	$\varnothing B$	$\varnothing D$	<i>S</i>	<i>T</i>	<i>W</i>
			+0,1 0	0 -0,1	+0,1 0	+0,1 0	0 -0,1	0 -0,1
060	6	0,6 0,8 1	4,7 4,3 3,9	6	6	0,4	1	0,4
080	8	0,6 0,8 1	6,7 6,3 5,9	8	8	0,6	1,4	
100	10	0,6 0,8 1	8,7 8,3 7,9	10	10			
120	12	0,6 0,8 1	10,7 10,3 9,9	12	12			
140	14	0,6 0,8 1	12,7 12,3 11,9	14	14			
160	16	0,6 0,8 1	14,7 14,3 13,9	16	16			
180	18	0,6 0,8 1	16,7 16,3 15,9	18	18			
200	20	0,6 0,8 1	18,7 18,3 17,9	20	20			
220	22	0,6 0,8 1	20,7 20,3 19,9	22	22			
250	25	0,6 0,8 1	23,7 23,3 22,9	25	25			
280	28	0,6 0,8 1	26,7 26,3 25,9	28	28			
320	32	0,6 0,8 1	30,7 30,3 29,9	32	32			

^a Nominal wall thickness of the tube.

4 Tube end geometry

See Figure 2 and Table 2.



Key

- 1 Break edges 0,15 max.
- 2 \varnothing tube
- ^a Nominal wall thickness of the tube

Figure 2

Table 2

Diameter code	<i>e</i>
060	0,6
080	0,8
100	1

5 Designation

EXAMPLE

Description block

Welded fitting

Identity block

EN3635-060-080

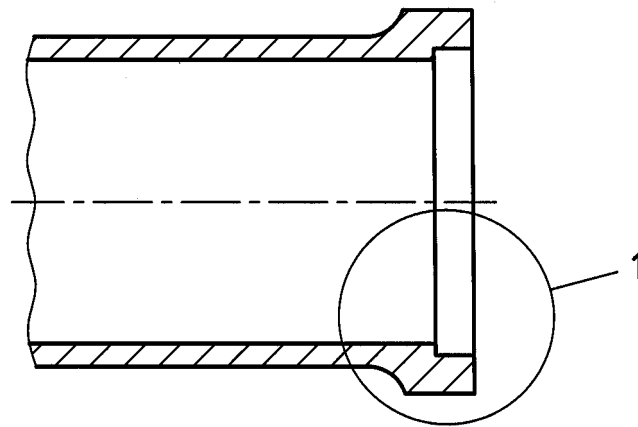
Number of EN standard

Diameter code (see Table 1)

Thickness code (see Table 2)

6 Indications on drawings

EXAMPLE See Figure 3.



Key

1 Welded fitting EN 3635-160-080

Figure 3

Annex A
(informative)

Standard evolution form

MODIFICATION	REASON AND VALIDATION
Page 3: drawing Clause 3, internal radius of the welding Before: 0,5 mm After: 0,15 mm	Radius back to previous prEN value Short radius necessary to allow fitting of facing pipe.
Page 5: header of second column of Table1: Before: Tube h12 After: Tube outside diameter h12	Precision
Page 5: footnote "a" of Table1: Before: Nominal thickness of the tube After: Nominal wall thickness of the tube	Precision
Page 6: paragraph 4, key "a": Before: Nominal thickness of the tube After: Nominal wall thickness of the tube	Precision
Page 6: Table 2: Before: Thickness code After : Diameter code	Correction

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