

BS EN 3706:2012



BSI Standards Publication

Aerospace series — Headless threaded plugs, cross recess, in aluminium alloy 5086

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National foreword

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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 3706

NORME EUROPÉENNE

EUROPÄISCHE NORM

March 2012

ICS 49.030.20

English Version

**Aerospace series - Headless threaded plugs, cross recess, in
aluminium alloy 5086**

Série aérospatiale - Bouchons filetés, sans tête, empreinte
cruciforme, en alliage d'aluminium 5086

Luft- und Raumfahrt - Verschlusschraube ohne Kopf mit
Kreuzschlitz, aus Aluminiumlegierung 5086

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Foreword

This document (EN 3706:2012) 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of an identical text or by endorsement, at the latest by September 2012, and conflicting national standards shall be withdrawn at the latest by September 2012.

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1 Scope

This European standard specifies characteristics of headless threaded plugs, cross recess, in aluminium alloy 5086, for aerospace purpose.

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 2424, *Aerospace series — Marking of aerospace products*

EN 2699, *Aerospace series — Aluminium alloy (5086) — Annealed and straightened (H 111) — Drawn bar — $6 \leq D \leq 50 \text{ mm}$* ¹

EN 3707, *Aerospace series — Headless threaded plugs — Installation holes*

ISO 5855-1, *Aerospace — MJ Threads — Part 1: General requirements*

ISO 965-3, *ISO general purpose metric screw threads -- Tolerances -- Part 3: Deviations for constructional screw threads*

3 Required characteristics

3.1 Configuration — Dimensions — Tolerances

Configuration: See figure.

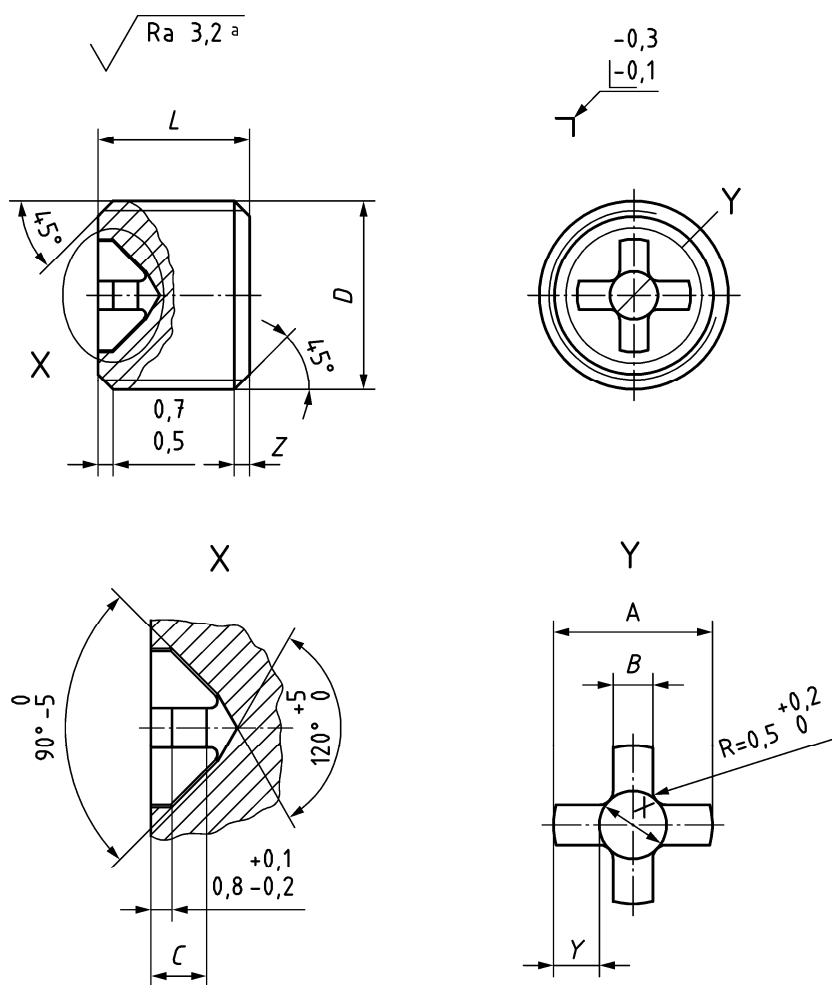
Dimensions and tolerances:

- see Figure 1 and Table 1;
- dimensions are in millimetres.

3.2 Material

EN 2699

1) Published as ASD-STAN pre-standard at the date of publication of the present standard.



Key

- a Thread surface will be achieved by normal methods of manufacturing.
- X Detail I
- Y see detail I

Figure 1

Table 1

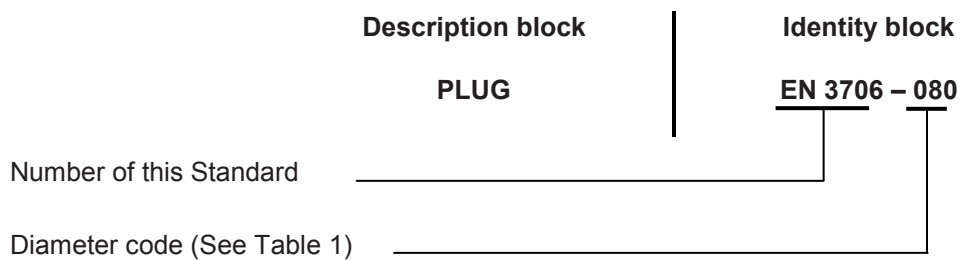
Dimensions in millimetres

Diameter code	$\varnothing D^a$	L $\pm 0,25$	Z $\begin{matrix} +0,3 \\ 0 \end{matrix}$	$\varnothing A$ $\begin{matrix} +0,3 \\ 0 \end{matrix}$	B $\begin{matrix} +0,2 \\ 0 \end{matrix}$	C $\begin{matrix} +0,3 \\ -0,1 \end{matrix}$	X min.	Y min.
060	MJ6×1,00 – 4g5g	6	0,5	3	0,8	0,9	1,56	0,4
070	MJ7×1,00 – 4g5g	7	0,8	4	1	1	1,84	0,6
080	MJ8×1,00 – 4g5g	8	0,8	5	1	1,4	1,84	0,12
100	MJ10×1,00 – 4g5g	8	0,8	6	1,5	2,1	2,55	1,34
120	MJ12×1,00 – 4g5g	8	1,2	6	1,5	2,1	2,55	1,34
140	MJ14×1,00 – 4g5g	8	1,2	7	2	2,7	3,28	1,54
160	MJ16×1,00 – 4g5g	10	1,2	7	2	2,7	3,28	1,54
180	MJ18×1,00 – 4g5g	10	1,2	7	2	2,7	3,28	1,54
200	MJ20×1,00 – 4g5g	10	1,2	7	2	2,7	3,28	1,54

^a Basic profile is in conformity with ISO 5855-1 and tolerances with ISO 965-3.

4 Designation

EXAMPLE



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

5 Marking

According to EN 2424, category G.

6 Installation holes

See EN 3707.

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