



NSAI
Standards

Irish Standard
I.S. EN 3327:2008

Aerospace series - Bolts, double hexagon head, close tolerance, medium thread length, in heat resisting nickel base alloy NIP100HT (Inconel 718), uncoated - Classification: 1 275 MPa/650 °C

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English Version

Aerospace series - Bolts, double hexagon head, close tolerance,
medium thread length, in heat resisting nickel base alloy NI-
P100HT (Inconel 718), uncoated - Classification: 1 275 MPa/650
°C

Série aérospatiale - Vis de précision à tête bihexagonale à
filetage moyen en alliage résistant à chaud à base de
nickel NI-P100HT (Inconel 718), non revêtu - Classification:
1 275 MPa/650 °C

Luft- und Raumfahrt - Zwölfkant-Passschrauben, mittlere
Gewindelänge, aus hochwarmfester Nickelbasislegierung
NI-P100HT (Inconel 718), blank - Klasse: 1 275 MPa/650
°C

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Contents

Page

Foreword	3
1 Scope	4
2 Normative references	4
3 Required characteristics	4
3.1 Configuration, dimensions, tolerances, masses	4
3.2 Material	4
3.3 Surface treatment	4
3.4 Thread surface	4
4 Designation	9
5 Marking	9
6 Technical specification	9
Figures	
Figure 1 — Configuration	5
Tables	
Table 1 — Dimensions	6
Table 2 — Lengths and masses	7

Foreword

This document (EN 3327:2008) 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of an identical text or by endorsement, at the latest by December 2008, and conflicting national standards shall be withdrawn at the latest by December 2008.

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1 Scope

This standard specifies the dimensions of uncoated double hexagon head bolts, close tolerance, with MJ-thread, medium thread length, in heat resisting nickel base alloy NI-PH2601 for aerospace applications.

Maximum test temperature of the parts is 650 °C.

These bolts are to be used in aerospace fastening systems mainly stressed in shearing force.

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 2424:2008, *Aerospace series — Marking of aerospace products*

EN 2583, *Aerospace series — Bolts, MJ threads, in heat resisting nickel base alloy NI-PH2601 (Inconel 718) — Classification: 1 275 MPa (at ambient temperature)/650 °C — Technical specification*

EN 2952, *Aerospace series — Heat resisting alloy NI-PH2601 — Solution treated and cold worked — Bar for forged fasteners $D \leq 50$ mm, $1\ 270$ MPa $\leq R_m \leq 1550$ MPa¹*

ISO 3353-1, *Aerospace — Lead and runout threads — Part 1: Rolled external threads*

ISO 4095, *Aerospace — Bihexagonal drives — Wrenching configuration — Metric series*

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

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

3 Required characteristics

3.1 Configuration, dimensions, tolerances, masses

Configuration shall be in accordance with the figure. Dimensions, tolerances and masses shall conform to Figure 1 and Tables 1 and 2. Details of form, not stated are at the manufacturer's option.

3.2 Material

Heat resisting nickel base alloy NI-PH2601 according to EN 2952.

3.3 Surface treatment

None.

3.4 Thread surface

See Figure 1.

¹ Published as ASD prestandard at the date of publication of this standard.

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