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National Standards Authority of Ireland

IRISH STANDARD

I.S. EN 2647:2006

ICS 49.030.30

AEROSPACE SERIES - NUTS, HEXAGONAL, SELF-LOCKING, BALL SEAT, IN ALLOY STEEL, CADMIUM PLATED, MOS2 LUBRICATED - CLASSIFICATION: 900 MPA (AT AMBIENT TEMPERATURE)/235 °C

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EUROPEAN STANDARD

NORME EUROPÉENNE

EUROPÄISCHE NORM

EN 2647

June 2006

ICS 49.030.30

Supersedes EN 2647:1995

English Version

Aerospace series - Nuts, hexagonal, self-locking, ball seat, in alloy steel, cadmium plated, MoS2 lubricated - Classification: 900 MPa (at ambient temperature)/235 °C

Série aérospatiale - Écrous hexagonaux, à freinage interne, orientables, en acier allié, cadmiés, lubrifiés MoS2 - Classification: 900 MPa (à température ambiante)/235 °C

Luft- und Raumfahrt - Sechskantmuttern, selbstsichernd, für Neigungsausgleich, aus legiertem Stahl, verkadmet, MoS2-geschmiert - Klasse: 900 MPa (bei Raumtemperatur)/235 °C

This European Standard was approved by CEN on 3 February 2006.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

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Foreword

This European Standard (EN 2647:2006) has been prepared by the AeroSpace and Defense 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of an identical text or by endorsement, at the latest by December 2006, and conflicting national standards shall be withdrawn at the latest by December 2006.

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1 Scope

This standard specifies the characteristics of self-locking hexagonal nuts with ball seat in alloy steel, cadmium plated, MoS_2 lubricated.

Classification: 900 MPa[1)] / 235 °C[2)]

They are intended to be used with washers to EN 2648 or suitable parts, see Annex A.

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

ISO 5858, *Aerospace — Self-locking nuts with maximum operating temperature ≤ 425 °C — Procurement specification*

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

EN 2000, *Aerospace series — Quality assurance — EN aerospace products — Approval of the quality system of manufacturers*

EN 2133, *Aerospace series — Cadmium plating of steels, with maximum specified tensile strength ≤ 1 450 MPa, copper, copper alloys and nickel alloys*

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

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

EN 2648, *Aerospace series — Washers, concave, in alloy steel, cadmium plated*

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

TR 3791, *Aerospace series — Materials for all metal self-locking nuts and thin wall inserts of temperature classes ≤ 425 °C*[3)]

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1) Corresponds to the minimum tensile stress which the nut is able to withstand at ambient temperature without breaking or cracking when tested with a bolt of a higher strength class.

2) Maximum temperature that the nut is able to withstand, without permanent alteration to is original characteristics, after ambient temperature has been restored. The maximum temperature is conditioned by the cadmium plating.

3) Published as AECMA Technical Report at the date of publication of this standard

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