



National Standards Authority of Ireland  
Údarás um Chaighdeáin Náisiúnta na hÉireann

IRISH STANDARD

**I.S. EN 3915:2008**

ICS 49.030.99

**AEROSPACE SERIES - INSERT, THIN WALL,  
SELF-LOCKING, MJ THREADS, IN HEAT  
RESISTING NICKEL BASE ALLOY NI-PH2601  
(NI-P100HT, INCONEL 718), FOR SALVAGE OF  
COMPONENTS - CLASSIFICATION: 1 275 MPA  
(AT AMBIENT TEMPERATURE) / 550 °C -  
TECHNICAL SPECIFICATION**

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ICS 49.030.99

English Version

**Aerospace series - Insert, thin wall, self-locking, MJ threads, in heat resisting nickel base alloy NI-PH2601 (NI-P100HT, Inconel 718), for salvage of components - Classification: 1 275 MPa (at ambient temperature) / 550 °C - Technical specification**

Série aérospatiale - Douilles filetées, à paroi mince, à freinage interne, filetage MJ, en alliage résistant à chaud à base de nickel NI-PH2601 (NI-P100HT, Inconel 718), pour récupération - Classification : 1 275 MPa (à température ambiante) / 550 °C - Spécification technique

Luft- und Raumfahrt - Gewindeeinsätze, dünnwandig, selbstsichernd, MJ-Gewinde, aus hochwarmfester Nickelbasislegierung NI-PH2601 (NI-P100HT, Inconel 718), zur Nacharbeit von Bauteilen - Klasse: 1 275 MPa (bei Raumtemperatur) / 550 °C - Technische Lieferbedingungen

This European Standard was approved by CEN on 29 February 2008.

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This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN Management Centre has the same status as the official versions.

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## **Contents**

Page

<b>Foreword</b> .....	<b>3</b>
<b>1 Scope</b> .....	<b>4</b>
<b>2 Normative references</b> .....	<b>4</b>
<b>3 Terms and definitions</b> .....	<b>5</b>
<b>4 Quality assurance</b> .....	<b>7</b>
<b>4.1 Qualification</b> .....	<b>7</b>
<b>4.1.1 Purpose</b> .....	<b>7</b>
<b>4.1.2 EN 9133</b> .....	<b>7</b>
<b>4.2 Acceptance</b> .....	<b>7</b>
<b>4.2.1 Purpose</b> .....	<b>7</b>
<b>4.2.2 Conditions</b> .....	<b>8</b>
<b>4.2.3 Responsibility</b> .....	<b>8</b>
<b>4.2.4 Inspection and test report</b> .....	<b>8</b>
<b>5 Requirements</b> .....	<b>8</b>

## **Foreword**

This document (EN 3915:2008) 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 October 2008, and conflicting national standards shall be withdrawn at the latest by October 2008.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN [and/or CENELEC] shall not be held responsible for identifying any or all such patent rights.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and the United Kingdom.

## 1 Scope

This standard specifies the characteristics, qualification and acceptance requirements for self-locking thin wall salvage inserts with MJ threads in NI-PH2601 (NI-P100HT).

Classification: 1 275 MPa <sup>1)</sup> / 550 °C <sup>2)</sup>.

## 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 2404 <sup>3)</sup>, *Heat resisting nickel base alloy NI-P100-HT — Solution treated and precipitation treated — Bars — Aerospace series.* <sup>4)</sup>

EN 3298, *Aerospace series — Inserts, thin wall, self-locking — Installation and removal procedure.*

EN 3676, *Aerospace series — Inserts, thin wall, self-locking — Design standard.*

EN 4376, *Aerospace series — Heat resisting alloy NI-PH2601 (NiCr19Fe19Nb5Mo3) — Solution treated and precipitation treated — Bar and section —  $D_e \leq 200$  mm.* <sup>5)</sup>

EN 4377, *Aerospace series — Heat resisting alloy NI-PH2601 (NiCr19Fe19Nb5Mo3) — Non heat treated — Forging stock —  $a$  or  $D \leq 300$  mm.* <sup>5)</sup>

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

EN ISO 4288, *Geometrical Product Specifications (GPS) — Surface texture: Profile method — Rules and procedures for the assessment of surface texture (ISO 4288:1996).*

ISO 2859-1, *Sampling procedures for inspection by attributes — Part 1: Sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection.*

ISO 3452, *Non-destructive testing — Penetrant inspection — General principles.*

ISO 3534:1977, *Statistics — Vocabulary and symbols.*

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

ISO 8642, *Aerospace — Self-locking nuts with maximum operating temperature greater than 425 °C — Test methods.*

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

2) Maximum test temperature of the parts.

3) Inactive for new designation, see EN 4376 and EN 4377.

4) Published as ASD Standard at the date of publication of this standard.

5) Published as ASD Prestandard at the date of publication of this standard.

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