Irish Standard
I.S. EN 4621:2010

Aerospace series - Inserts, MJ threads, self-locking, selfbroaching keys - Technical specification

I.S. EN 4621:2010

Incorporating amendments/corrigenda/National Annexes issued since publication:

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EUROPEAN STANDARD

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EN 4621

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English Version

Aerospace series - Inserts, MJ threads, self-locking, self-broaching keys - Technical specification

Série aérospatiale - Douilles filetées, à filetages MJ, à freinage interne à clavettes auto-brochantes - Spécification technique

Luft- und Raumfahrt - Gewindeeinsätze, MJ-Gewinden, selbstsicherndmit selbsträumenden Stiften - Technische Lieferbedingungen

This European Standard was approved by CEN on 9 January 2010.

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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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Foreword

This document (EN 4621:2010) 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of an identical text or by endorsement, at the latest by September 2010, and conflicting national standards shall be withdrawn at the latest by September 2010.

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.

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1 Scope

This standard specifies the characteristics, qualification and acceptance requirements for self-locking inserts, self-broaching keys with MJ threads, for aerospace applications.

It is applicable whenever referenced.

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 2638, *Aerospace series — Aluminium alloy 2024-T3 — Extruded bar and section — 1,2 mm ≤ (a or D) ≤ 150 mm — With coarse peripheral grain control* [1)]

EN 4619, *Aerospace series — Inserts, MJ threads, self-locking, with self-broaching keys — Installation and removal procedure*

EN 4620, *Aerospace series — Inserts, MJ threads, self-locking, with self-broaching keys — Design standard*

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

ISO 2859-1:1999, *Sampling procedures for inspection by attributes — Part 1: Sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection*

ISO 3452:1984, *Non-destructive testing — Penetrant inspection — General principles*

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

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

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

ASTM E 112-96, *Standard Test Methods for Determining Average Grain Size* [2)]

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

3.1
batch
quantity of finished parts, of the same type and same diameter, produced from the same material obtained from the same melt, manufactured in the course of the same production cycle, following the same manufacturing route and having undergone all the relevant heat treatments and surface treatments

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

2) Published by: American Society for Testing and Materials (ASTM), 1916, Race Street, Philadelphia, PA 19103, USA.