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Standards

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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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, selbstsichernd mit selbstbräumenden Stiften - Technische Lieferbedingungen

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

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Contents

Page

Foreword	3
1 Scope	4
2 Normative references	4
3 Terms and definitions	4
4 Quality assurance	7
4.1 Qualification	7
4.2 Acceptance	7
4.2.1 Purpose	7
4.2.2 Conditions	7
4.2.3 Responsibility	7
4.2.4 Inspection and test report	7
5 Requirements	7
Annex A (normative) Definition of test block	18
Annex B (normative) Assembly for rotational resistance test	19
Annex C (normative) Axial tensile strength test	21
Annex D (normative) Assembly for reusability test	23
Annex E (normative) "GO" gauge for inspection of the position of the keys	25

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of an identical text or by endorsement, at the latest by September 2010, and conflicting national standards shall be withdrawn at the latest by September 2010.

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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 — $1,2\text{ mm} \leq (a \text{ or } D) \leq 150\text{ mm}$ — 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

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

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