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I.S. EN 4078:2009

Aerospace series - Inserts, threaded, thin wall, locked and self-locking, in heat resisting steel, MoS₂ lubricated -
Classification: 1 100 MPa (at ambient temperature) / 315°C

I.S. EN 4078:2009

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English Version

**Aerospace series - Inserts, threaded, thin wall, locked and self-locking, in heat resisting steel, MoS2 lubricated - Classification:
1 100 MPa (at ambient temperature) / 315 °C**

Série aérospatiale - Douilles filetées, à paroi mince, freinées et à freinage interne, en acier résistant à chaud lubrifiées MoS2 - Classification: 1 100 MPa (à température ambiante) / 315 °C

Luft- und Raumfahrt - Gewindeeinsatz, dünnwandig, gesichert und schraubensichernd, aus hochwarmfestem Stahl, MoS2 geschmiert - Klasse: 1 100 MPa (bei Raumtemperatur) / 315 °C

This European Standard was approved by CEN on 15 September 2009.

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Foreword

This document (EN 4078:2009) 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of an identical text or by endorsement, at the latest by May 2010, and conflicting national standards shall be withdrawn at the latest by May 2010.

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1 Scope

This European Standard specifies the characteristics of threaded thin wall inserts, locked and with a self-locking feature achieved by deforming out-of-round the internal thread of mid length, in heat resisting steel, MoS₂ lubricated.

Classification : 1 100 MPa¹⁾ / 315 °C²⁾.

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, *Aerospace series — Marking of aerospace products*

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

EN 4217, *Aerospace series — Inserts, thin wall, for airframe applications — Installation and removal procedure³⁾*

EN 4218, *Aerospace series — Inserts, thin wall, self-locking, MJ threads, in heat resisting steel, MoS₂ lubricated — Classification 1 100 MPa (at ambient temperature) / 315 °C — Technical specification³⁾*

ISO 965-1, *ISO general-purpose metric screw threads — Tolerances — Part 1: Principles and basic data*

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

TR 3791, *Aerospace series — Materials for self-locking nuts, threaded inserts and screw thread inserts of temperature classes ≥ 425 °C*

2.1 Configuration – Dimensions – Masses

See Figure 1 and Table 1.

Dimensions and tolerances are expressed in millimetres and apply before MoS₂ lubrication.

Details of form not stated are at the manufacturer's option.

2.2 Materials

TR 3791.

2.3 Surface treatment

EN 2491, thickness not specified.

1) Corresponds 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 a higher strength class.

2) Maximum temperature that the insert is able to withstand, without permanent alteration to its original characteristics, after ambient temperature has been restored. The maximum temperature is conditioned by the MoS₂ lubricant.

3) In preparation at the date of publication of this standard.

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