

STN	Letectvo a kozmonautika Spojovacie súčasti s vonkaším závitom, 100° normálnou zapustenou hlavou, špirálovou drážkou Trieda: 1 100 MPa (pri teplote okolia)/425 °C	STN EN 4853 31 3188
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Aerospace series - Externally threaded fastener, 100 countersunk normal head, Spiral Drive Recess - Classification: 1 100 MPa (at ambient temperature)/425 C

Táto norma obsahuje anglickú verziu európskej normy.
This standard includes the English version of the European Standard.

Táto norma bola oznámená vo Vestníku ÚNMS SR č. 06/22

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EUROPEAN STANDARD

EN 4853

NORME EUROPÉENNE

EUROPÄISCHE NORM

March 2022

ICS 49.030.01

English Version

Aerospace series - Externally threaded fastener, 100°
countersunk normal head, Spiral Drive Recess -
Classification: 1 100 MPa (at ambient temperature)/425
°C

Série aérospatiale - Élément de fixation à filetage
extérieur, tête fraisée normale 100°, empreinte en
spirale - Classification : 1 100 MPa (à température
ambiante)/425 °C

Luft- und Raumfahrt - Verbindungselement mit
Außengewinde, 100° Senkkopf, mit Spiral-Antrieb -
Klasse: 1 100 MPa (bei Raumtemperatur)/425 °C

This European Standard was approved by CEN on 10 January 2022.

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 CEN-CENELEC Management Centre or to any CEN member.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

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EN 4853:2022 (E)

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European foreword

This document (EN 4853:2022) 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 2022, and conflicting national standards shall be withdrawn at the latest by September 2022.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN 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, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

EN 4853:2022 (E)**Introduction**

Aerospace and Defence Standardisation (ASD-STAN) draws attention to the fact that it is claimed that compliance with this document may involve the use of a patent “Spiral Drive System for Threaded Fasteners” EP1025370B1.

ASD-STAN takes no position concerning the evidence, validity and scope of this patent right.

The holder of this patent right has assured ASD-STAN that he/she is willing to negotiate licences under reasonable and non-discriminatory terms and conditions with applicants throughout the world. In this respect, the statement of the holder of this patent right is registered with ASD-STAN. Information may be obtained from:

Phillips Screw Company
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USA

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights other than those identified above. ASD-STAN shall not be held responsible for identifying any or all such patent rights.

1 Scope

This document specifies the characteristics of externally threaded fasteners, 100° countersunk normal head, Spiral Drive Recess, for aerospace applications.

Classification: 1 100 MPa¹/425 °C².

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements 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 2133, *Aerospace series — Cadmium plating of steels with specified tensile strength $\leq 1\,450$ MPa, copper, copper alloys and nickel alloys*

EN 2137, *Aerospace series — Steel FE-PL75 — $1\,100\text{ MPa} \leq R_m \leq 1\,250\text{ MPa}$ — Bars — $D_e \leq 100\text{ mm}$*

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

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

EN 2516, *Aerospace series — Passivation of corrosion resisting steels and decontamination of nickel base alloys*

EN 3021, *Aerospace series — Molybdenum disulphide dry film lubricants graphite and halogen free — Technical specification*

EN 3514, *Steel FE-PL711 — hardened and tempered — $1\,100 \leq R_m \leq 1\,300\text{ MPa}$ — Bar and wire for bolts — $D_e \leq 25\text{ mm}$ ³*

EN 3761, *Aerospace series — Heat resisting alloy FE-PA2601 — Softened and cold worked — Bar for forged fasteners — $D \leq 50\text{ mm}$ — $1\,100\text{ MPa} \leq R_m \leq 1\,300\text{ MPa}$*

EN 3813, *Aerospace series — Titanium alloy TI-P64001 (Ti-6Al-4V) — Annealed — Bar and wire for forged fasteners — $D_e \leq 50\text{ mm}$*

EN 4473, *Aerospace series — Aluminium pigmented coatings for fasteners — Technical specification*

EN 4609, *Aerospace series — Spiral drive recesses for threaded fasteners — Geometrical definition and technical requirements*

ISO 3161, *Aerospace — UNJ threads — General requirements and limit dimensions*

ISO 3353-1, *Aerospace — Lead and runout threads — Part 1: Rolled external threads*

ISO 7913, *Aerospace — Bolts and screws, metric — Tolerances of form and position*

¹ Minimum tensile strength of the material at ambient temperature.

² Maximum temperature that the screw can withstand without continuous change in its original characteristics, after return to ambient temperature. The maximum temperature is determined by the material.

³ Published as ASD-STAN Prestandard at the date of publication of this standard by AeroSpace and Defence Industries Association of Europe — Standardization (ASD-STAN) (www.asd-stan.org).

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NAS621, *Fasteners, Titanium Alloy Procurement Specification*⁴

NAS4002, *Fastener, Alloy Steel, Externally Threaded, 160 KSI Ftu, 95 KSI Fsu, 450 °F*⁴

NAS4003, *Fastener, A286 Corrosion Resistant Alloy, Externally Threaded, 160 KSI Ftu, 95 KSI Fsu, 1 000 °F*⁴

NAS4004, *Fastener, 6AL-4V Titanium Alloy, Externally Threaded, 160 KSI Ftu, 95 KSI Fsu, 450 °F*⁴

NAS9800, *Head Protrusion Gaging, 100° Flush Head Fasteners, Gage Block, Gage Diameters and Stylus*⁴

SAE AMS4928W, *Titanium Alloy Bars, Wire, Forgings, Rings, and Drawn Shapes, 6Al — 4V Annealed*⁵

SAE AMS4967M, *Titanium Alloy, Bars, Wire, Forgings, and Rings 6.0Al — 4.0V Annealed, Heat Treatable*⁵

SAE AMS5731L, *Steel, Corrosion and Heat-Resistant, Bars, Wire, Forgings, Tubing, and Rings 15Cr — 25.5Ni — 1.2Mo — 2.1Ti — 0.006B — 0.30V Consumable Electrode Melted, 1 800 °F (982 °C) Solution Heat Treated*⁵

SAE AMS5732J, *Steel, Corrosion and Heat-Resistant, Bars, Wires, Forgings, Tubing, and Rings, 15Cr — 25.5Ni — 1.2Mo — 2.1Ti — 0.006B — 0.30V Consumable Electrode Melted 1 800°F (982 °C) Solution and Precipitation Heat Treated*⁵

SAE AMS5737G, *Steel, Corrosion and Heat Resistant, Bars, Wire, Forgings, and Tubing 15Cr — 25.5Ni — 1.2Mo — 2.1Ti — 0.006B — 0.30V Consumable Electrode Melted 1 650 °F (899 °C) Solution and Precipitation Heat Treated*⁵

SAE AMS5853D, *Steel, Corrosion and Heat-Resistant, Bars and Wire 15Cr — 25.5Ni — 1.2Mo — 2.1Ti — 0.006B — 0.30V, Consumable Electrode Melted, 1 800 °F (982 °C) Solution Treated and Work-Strengthened Capable of 160 ksi (1 103 MPa) Tensile Strength*⁵

SAE AMS6322R, *Steel Bars, Forgings, and Rings 0.50Cr — 0.55Ni — 0.25Mo (0.38 — 0.43C) (SAE 8740)*⁵

SAE AMS6382R, *Steel, Bars, Forgings, and Rings 0.95Cr — 0.20Mo (0.38 — 0.43C) (SAE 4140) Annealed*⁵

SAE AMS6415U, *Steel, Bars, Forgings, and Tubing 0.80Cr — 1.8Ni — 0.25Mo (0.38 — 0.43C) (SAE 4340)*⁵

koniec náhľadu – text ďalej pokračuje v platenej verzii STN

⁴ Published by: Aerospace Industries Association (AIA), 1000 Wilson Boulevard, Suite 1700, Arlington, VA 22209-3901, USA.

⁵ Published by: Society of Automotive Engineers (SAE), 400 Commonwealth Drive, Warrendale, PA 15096-0001, USA.