

STN	Letectvo a kozmonautika Kružky, typ strih, zo zliatiny hliníka 6061, s konverzným povlakom Palcový rad	STN EN 6054 31 3540
------------	---	---

Aerospace series - Collar, swage locking, shear type, in aluminium alloy 6061, conversion coating - Inch series

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. 03/26

Obsahuje: EN 6054:2025

142201

EUROPEAN STANDARD

EN 6054

NORME EUROPÉENNE

EUROPÄISCHE NORM

December 2025

ICS 49.030.99

English Version

Aerospace series - Collar, swage locking, shear type, in aluminium alloy 6061, conversion coating - Inch series

Série aérospatiale - Bague à sertir, type cisaillement, en alliage d'aluminium 6061, revêtement de conversion - Série en inches

Luft- und Raumfahrt - Schließring für Quetschverriegelung, für Scherbeanspruchung, aus Aluminiumlegierung 6061, Schmierfilm behandelt - Zoll-Reihe

This European Standard was approved by CEN on 26 October 2025.

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.

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-CENELEC Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Türkiye and United Kingdom.



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

CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

EN 6054:2025 (E)

Contents		Page
European foreword		3
1	Scope.....	4
2	Normative references.....	4
3	Terms and definitions.....	4
4	Requirements.....	5
4.1	Configuration, dimensions, tolerances and mass.....	5
4.2	Material and surface treatment.....	5
5	Designation	6
6	Marking	6
7	Technical specification	6
8	Example of installation	7
9	Quality management system	7
Bibliography		8

European foreword

This document (EN 6054:2025) has been prepared by ASD-STAN.

After enquiries and votes carried out in accordance with the rules of this Association, this document has received the approval of the National Associations and the Official Services of the member countries of ASD-STAN, 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 June 2026, and conflicting national standards shall be withdrawn at the latest by June 2026.

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.

Any feedback and questions on this document should be directed to the users' national standards body. A complete listing of these bodies can be found on the CEN website.

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, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Türkiye and the United Kingdom.

EN 6054:2025 (E)**1 Scope**

This document specifies the characteristics of a collar, swage locking, shear type, in aluminium alloy 6061-T7, with a maximum operating temperature of 80 °C for aerospace applications.

This document is applicable in combination with EN 6050, EN 6100 or EN 6120.

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 2424, *Aerospace series — Marking of aerospace products*

EN 6052, *Aerospace series — Rivet-collar-system, aluminium alloy, shear type, inch series — Technical Specification*

EN 6117,¹ *Aerospace series — Specification for lubrication of fasteners with cetyl alcohol*

FED-SPEC QQ-A-430,² *Aluminum Alloy Rod and Wire; for Rivets and Cold Heading//Inactive for new design*

MIL-DTL-5541,² *Chemical Conversion Coatings on Aluminum and Aluminum Alloys*

SAE AS87132,³ *Lubricant, Cetyl Alcohol, 1-Hexadecanol, Application to Fasteners*

koniec náhľadu – text ďalej pokračuje v platenej verzii STN

¹ Published as ASD-STAN prEN at the date of publication of this document, available at: <https://www.asd-stan.org/>.

² Published by Department of Defense (DoD), available at: <https://assist.dla.mil/online/start/>.

³ Published by Society of Automotive Engineers (SAE), available at: <https://www.sae.org/>.