

BS EN 3323:2009

Incorporating corrigendum September 2015



BSI Standards Publication

**Aerospace series — Bolts with
double hexagon head, relieved
shank long thread, — In heat
resisting steel FE-PM 38 (FV
535) — Classification: 1 000
MPa/550 °C**

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National foreword

This British Standard is the UK implementation of EN 3323:2009.

The UK participation in its preparation was entrusted to Technical Committee ACE/12, Aerospace fasteners and fastening systems.

A list of organizations represented on this committee can be obtained on request to its secretary.

This publication does not purport to include all the necessary provisions of a contract. Users are responsible for its correct application.

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Amendments/corrigenda issued since publication

Date	Text affected
31 October 2015	Implementation of CEN Correction Notice 4 March 2009: Figure 1 and its key updated

English Version

**Aerospace series - Bolts with double hexagon head, relieved
shank long thread, - In heat resisting steel FE-PM 38 (FV 535) -
Classification: 1 000 MPa/550 °C**

Série aérospatiale - Vis à tête bihexagonale, à tige réduite,
à filetage long, en acier résistant à chaud FE-PM38
(FV535) - Classification : 1 000 MPa/550 °C

Luft- und Raumfahrt - Zwölfkantschrauben, Dünnschaft,
langes Gewinde, - Aus hochwarmfestem Stahl FE-PM 38
(FV 535) - Klasse: 1 000 MPa/550 °C

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Foreword

This document (EN 3323:2009) 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of an identical text or by endorsement, at the latest by August 2009, and conflicting national standards shall be withdrawn at the latest by August 2009.

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1 Scope

This standard specifies the characteristics of double hexagon head bolts with relieved shank and long thread in heat resisting steel FM-PM 38, tensile strength class 1 000 MPa at room temperature. The maximum test temperature of the material is 550 °C.

These bolts are to be used in aerospace fastening systems, of parts made in titanium, mainly stressed in tension.

2 Normative references

- EN 2424 Aerospace series — Marking of aerospace products¹
- EN 2493 Aerospace series — Heat resisting steel FE-PM 38 — $1\,000\text{ MPa} \leq R_m \leq 1140\text{ MPa}$ — Bars²
- EN 3302 Aerospace series - Bolts in heat resisting steel FE-PM1708 (FV535) - Classification: 1 000 MPa/550 °C - Technical specification¹
- ISO 3353-1 Aerospace — Lead and runout threads — Part 1: Rolled external threads
- ISO 4095 Aerospace — Bihexagonal drives — Wrenching configuration — Metric series
- ISO 5855-1 Aerospace — MJ Threads — Part 1: General requirements
- ISO 5855-2 Aerospace — MJ Threads — Part 2: Limit dimensions for bolts and nuts

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

² Published as ASD Prestandard at the date of publication of this standard.