

Inserts, thickwall, self-locking — Installation and removal procedure

The European Standard EN 4015:2004 has the status of a
British Standard

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National foreword

This British Standard is the official English language version of EN 4015:2004. It supersedes BS EN 4015:2003 which is withdrawn.

The UK participation in its preparation was entrusted to Technical Committee ACE/12, Aerospace fasteners and fastening systems, which has the responsibility to:

- aid enquirers to understand the text;
- present to the responsible international/European committee any enquiries on the interpretation, or proposals for change, and keep the UK interests informed;
- monitor related international and European developments and promulgate them in the UK.

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This European Standard was approved by CEN on 11 September 2003.

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Management Centre: rue de Stassart, 36 B-1050 Brussels

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Foreword

This document (EN 4015:2004) has been prepared by the European Association of Aerospace Manufacturers - Standardization (AECMA-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 AECMA, 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of an identical text or by endorsement, at the latest by May 2005, and conflicting national standards shall be withdrawn at the latest by May 2005.

This document supersedes EN 4015:2003.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

1 Scope

This standard specifies the conditions of installation and removal procedure (hole serration profile, tools, swaging) of self-locking thickwall inserts defined by EN standards, for aerospace applications.

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 3831, *Aerospace series – Inserts, thickwall, self-locking, MJ threads, in heat resisting steel FE-PM3801 (17-4PH), MoS₂ coated*

EN 4014, *Aerospace series – Inserts, thickwall, self-locking – Design standard*

3 Insert information

Tables 1 and 2 provide the cross reference between the insert codification, the related bolt thread and the tapped hole diameter.

Table 1 — Normal size insert

Insert reference	Bolt thread diameter	Tapped hole diameter	Tapped hole reference
EN3831-050-0	MJ5×0,8	MJ8×1	EN4014-050-0
EN3831-060-0	MJ6×1	MJ9×1	EN4014-060-0
EN3831-070-0	MJ7×1	MJ10×1	EN4014-070-0
EN3831-080-0	MJ8×1	MJ11×1	EN4014-080-0
EN3831-100-0	MJ10×1,25	MJ13×1	EN4014-100-0

Table 2 — First repair size insert

Insert reference	Bolt thread diameter	Tapped hole diameter	Tapped hole reference
EN3831-050-1	MJ5×0,8	MJ9×1	EN4014-050-1
EN3831-060-1	MJ6×1	MJ10×1	EN4014-060-1
EN3831-070-1	MJ7×1	MJ11×1	EN4014-070-1
EN3831-080-1	MJ8×1	MJ12×1	EN4014-080-1
EN3831-100-1	MJ10×1,25	MJ14×1	EN4014-100-1