

BS EN 6072:2010



BSI Standards Publication

Aerospace series — Metallic materials — Test methods — Constant amplitude fatigue testing

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National foreword

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Date	Text affected
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June 2010

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Luft- und Raumfahrt - Metallische Werkstoffe -
Prüfverfahren - Ermüdungstest mit konstanter Amplitude

This European Standard was approved by CEN on 25 December 2009.

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Contents

Page

Foreword	3
1 Scope	4
2 Normative references	4
3 Terms and definitions	4
4 Principles of the method	5
5 Apparatus	5
6 Test specimens	5
7 Procedure	6
8 Analysis of test results	7
9 Test report	7
Annex A (normative) Axial Fatigue - Cylindrical specimen	13
Annex B (normative) Axial Fatigue - Flat specimen ($K_t = 1,0$)	17
Annex C (normative) Axial Fatigue - Flat specimen - "T-Type" and mini "T-Type" specimen ($K_t = 2,3$)	19
Annex D (normative) Bending Fatigue - Flat specimen	22
Annex E (normative) Recommendations for machining procedure of specimen	24
E.1 Cylindrical specimens	24
E.2 Flat specimens	27
Annex F (normative) Indication of failure sites	30
Annex G (normative) Table of fatigue test results	31
Annex H (normative) Representation of fatigue data	32
Annex I (informative) Example of inspection card process	33

Foreword

This document (EN 6072:2010) 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of an identical text or by endorsement, at the latest by December 2010, and conflicting national standards shall be withdrawn at the latest by December 2010.

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1 Scope

This European Standard defines a method to determine constant amplitude fatigue data of metallic materials and the S-N curve (or Wöhler curve).

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.

ISO 286-1, *ISO system of limits and fits — Part 1: Bases of tolerances, deviations and fits*

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

ISO 1101, *Geometrical Product Specifications (GPS) — Geometrical tolerancing — Tolerances of form, orientation, location and run-out*

ASTM E 466, *Standard practice for conducting force controlled constant amplitude axial fatigue tests of metallic materials*¹⁾

ASTM E 1823, *Standard terminology relating to fatigue and fracture testing*¹⁾

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ASTM E 1823 and the following apply.

3.1 Direction of test samples

3.1.2

cylindrical specimens

the direction of the sample is identified by the following symbols:

- L : Long (grain flow direction);
- LT : Long Transverse;
- ST : Short Transverse.

The directions of semi-finished products of rectangular cross section for rolled or extruded products and forgings are identified on Figure 1.

The directions of semi-finished products of circular cross section for rolled products and forged rings are identified on Figure 2.

3.1.2

flat specimens

designation for direction of these specimens is identical to ASTM designation:

Two letters separated by a dash:

- First letter : direction of load
- Second letter : direction of crack propagation

The directions of semi-finished products of rectangular cross section for rolled or extruded products and hand forgings are identified on Figure 3.

¹⁾ Published by: American Society for Testing and Materials (ASTM), 1916 Race Street, Philadelphia, PA 19103, USA.

The directions of semi-finished products of circular cross section for drawn or extruded products and hand forgings are identified on Figure 4.

4 Principles of the method

See ASTM E 466.

5 Apparatus

See ASTM E 466 (calibrating to ISO 7500-1 is also acceptable).

6 Test specimens

6.1 General

Test specimens shall be prepared according to the requirements of the relevant Process or Material Standard.

6.2 Geometry

The geometry of test specimens is described in Annexes A to D.

6.3 Machining

6.3.1 Dimensional tolerances

Machining tolerances (according to ISO 286-1) on transverse dimensions: ISO js 12.

Form tolerances (according to ISO 1101) = ISO IT9.

Specimens shall be machined cold, without generating surface hardening nor appreciable heating of the metal.

Recommendations for machining procedure of specimens are given in Annex E for each type of specimen.

Final machining to comply with the tolerances and to obtain the surface finish required on the calibrated section (see Annexes A to D).

6.3.2 Specimens to be heat-treated

The heat treatment should preferably be applied to the specimen blanks to avoid distortion, which cannot be corrected by machining.

Final machining after heat treatment, in accordance with 6.3.1.

NOTE For steels treated to obtain a high UTS, it may be necessary to machine the specimens to the final dimensions in the as-delivered condition and then protect them before heat treatment.

In general, the surface of steel and aluminium alloys specimens shall be:

- either protected against corrosion by an appropriate product,
- or machined only shortly before carrying out the test.

6.3.3 Grinding

Grinding of steel and titanium specimens shall only be carried out when a process is available which guarantees no detrimental effects to the specimen surface, for example contamination.

6.4 Straightening

It is strictly forbidden to straighten a distorted specimen.

Such distortion can arise from heat treatment on specimens machined to their final dimensions.

The surface hardening generated by the mechanical equipment used to straighten the specimens affects the mechanical properties and gives unrepresentative results.

7 Procedure

7.1 Number of specimens

A minimum of 10 fatigue specimens with valid results is necessary to determine a Wöhler curve.

Upon request, a static loaded specimen shall be performed.

7.2 Measurements of specimen dimensions

The dimensions of the test specimens shall be measured before testing and the results reported in the test report (see Clause 9).

7.3 Test procedure

Load ratio R and K_t factor are given in the relevant Process or Material Standard.

The test frequency shall be not more than 170 Hz. For frequency greater than 50 Hz, it is advisable to carry dynamic calibrations on test work.

The choice of load levels shall be done in order that test results can be regularly positioned on the S-N curve between at least 10^4 and $3 \cdot 10^6$ cycles, so that a Wöhler curve can be raised. For qualification of materials, cycling must not be stopped before $3 \cdot 10^6$ cycles, unless other conditions are specified. In case of non-failure at $3 \cdot 10^6$ cycles (or more), specimen can be tested again at a higher load level that will lead to failure before 10^5 cycles. Test results must mention that specimen has been tested after a non-failure so that analysis can take it into account.

NOTE For load ratio $R < 0$, it is recommended to use anti buckling equipment.

The breaking near the grip and the associated number of cycles shall be mentioned in the test report (see Clause 9). In this case the specimen should be clamped again (if possible) and the test should be continued at the same load level.

In order to check the reproducibility and friability of test machine, an example of inspection card is given in Annex I.

8 Analysis of test results

8.1 Failure of specimens

After testing, specimens shall be examined. Failure type and sites shall be indicated (see Annex F).

8.2 Presentation of fatigue data

All the values measured and calculated from the specimens shall be reported in a table (see Annex G).

The cross section of the specimen, which has been used for calculation, shall be indicated.

8.3 Plot of the Wöhler curve

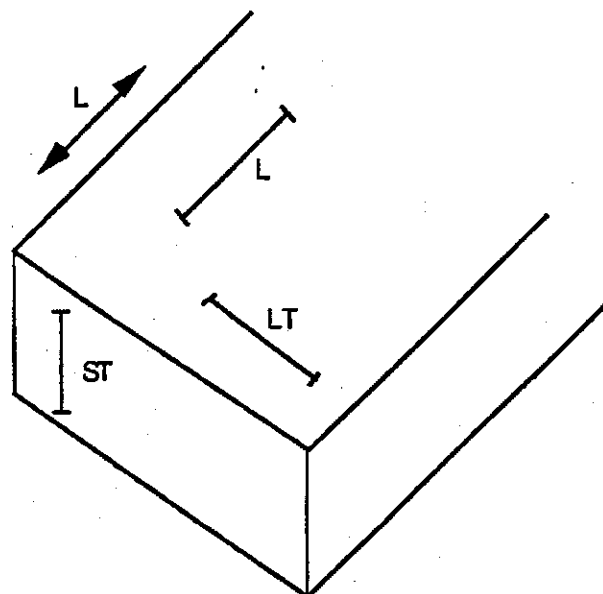
All the individual results shall be represented in a log (or semi-log) scale scheme: max. stress in MPa, σ , versus Fatigue life, number of cycles, N (see Annex H).

The analysis of the test results shall generate a mean Wöhler curve with 50 % probability of failure, in addition two curves for minimum and for maximum probability of failure.

9 Test report

The test report shall refer to the test method and shall include the following:

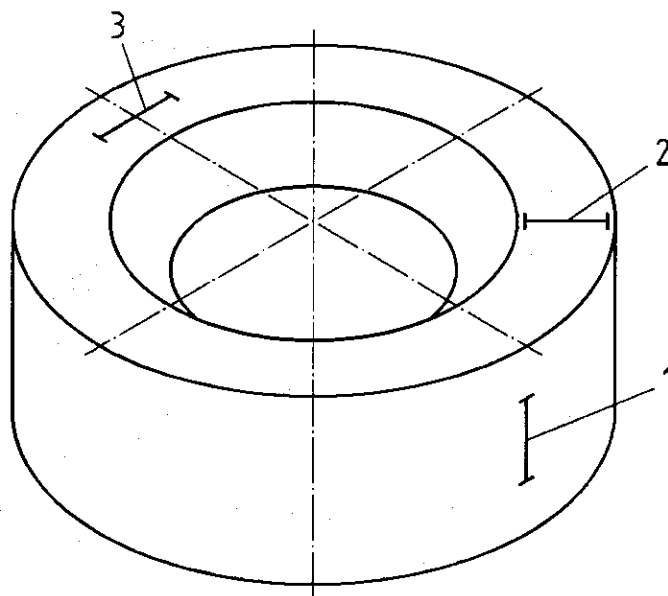
- Complete identification of the tested material including the manufacturers Name, Designation, and Batch Number.
- All details relating to the preparation of the specimens.
- All relevant dimensions of the specimens.
- Date of test and traceability to the individual performing the test work.
- Conditioning.
- Equipment used and test parameters (R ratio, test frequency, orientation ...).
- Recorded plots/graphs (with all the points).
- Individual test results and type of failure (see Annex F and Annex G).
- Any incident which may have affected the results, and any deviation from the test method.



Key

L : Long (grain flow direction)
LT : Long Transverse
ST : Short Transverse

Figure 1 — Cylindrical specimens - Direction of semi-finished products of rectangular cross section

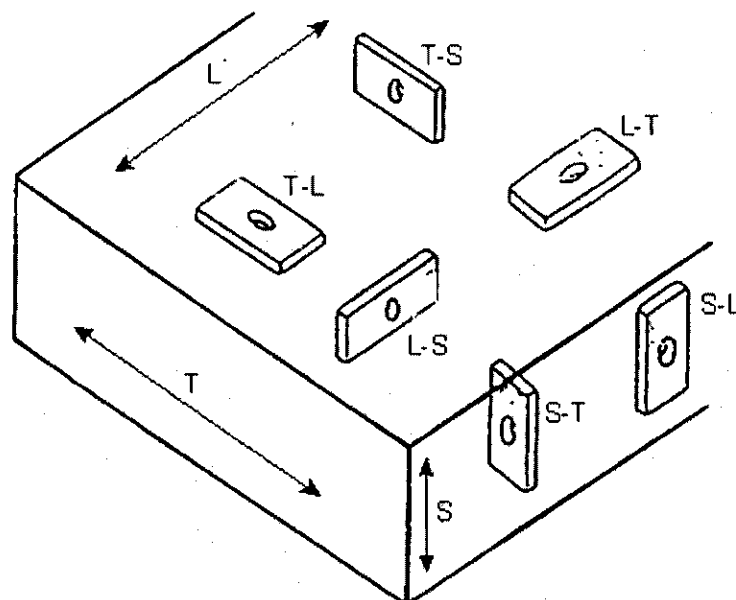


Key

- 1 Axial: corresponds to LT direction
- 2 Radial: corresponds to ST direction
- 3 Tangential: corresponds to L direction (grain flow direction)

Depending on the forging axis, the LT and ST directions can change.

Figure 2 — Cylindrical specimens - Direction of semi-finished products of circular cross section



Key

L : Long (grain flow direction)

LT : Long Transverse

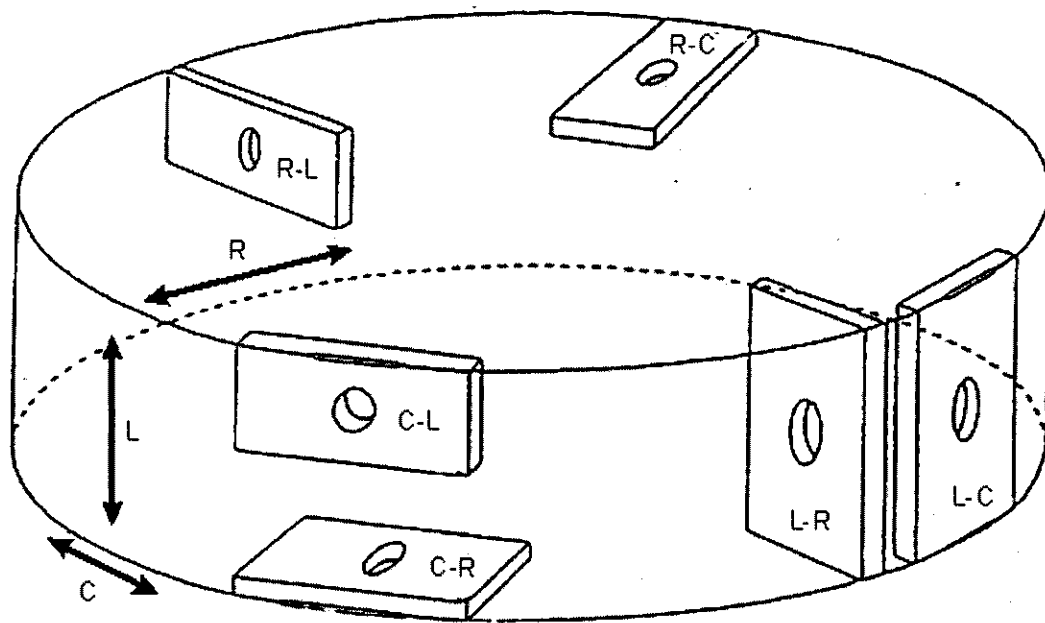
ST : Short Transverse

Two letters separated by a dash:

First letter : direction of load

Second letter : direction of crack propagation

Figure 3 — Flat specimens - Direction of semi-finished products of rectangular cross section



Key

- L: direction of grain flow
- R: radial direction
- C: circumferential direction

Figure 4 — Flat specimens - Direction of semi-finished products of circular cross section

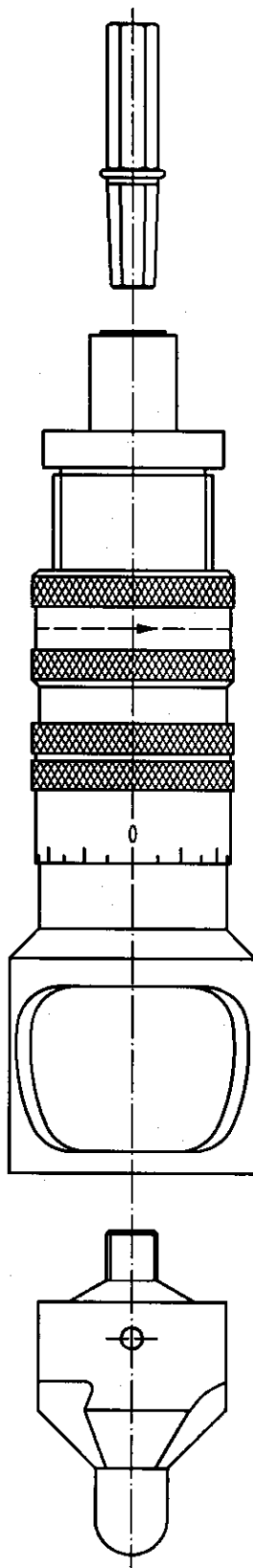
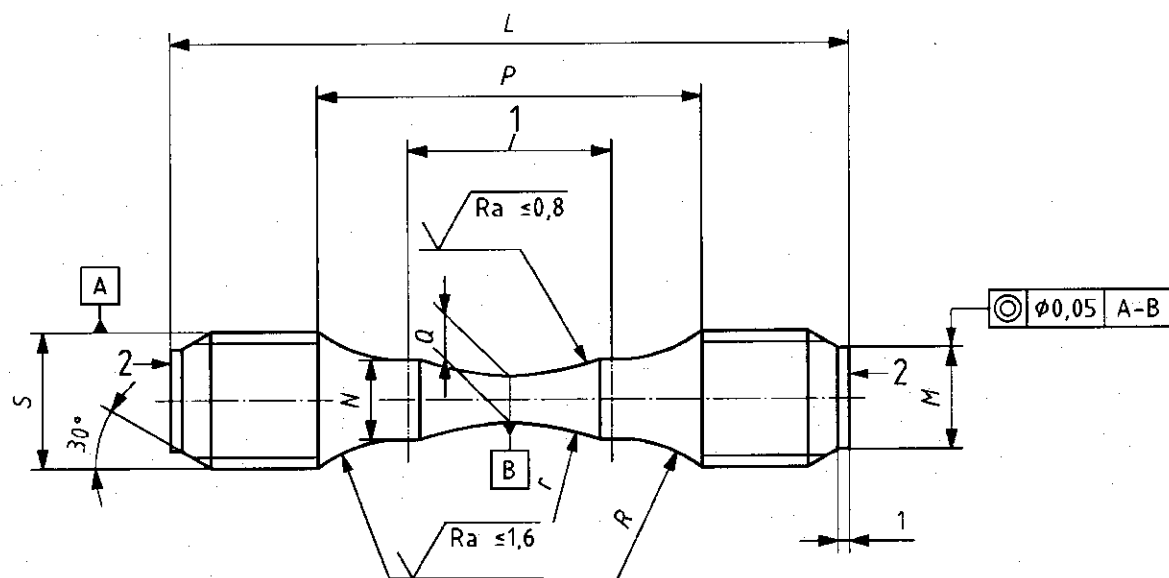


Figure 5 — Tool for chamfering
(can be ordered from Recoules Society or from Rexim Werkzeug GmbH)

Annex A (normative)

Axial Fatigue - Cylindrical specimen



Key

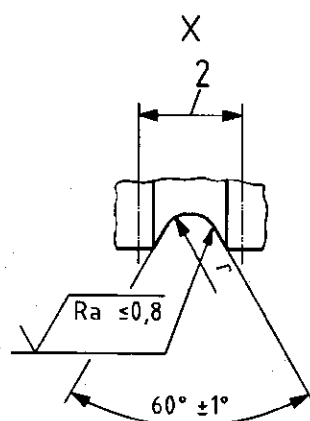
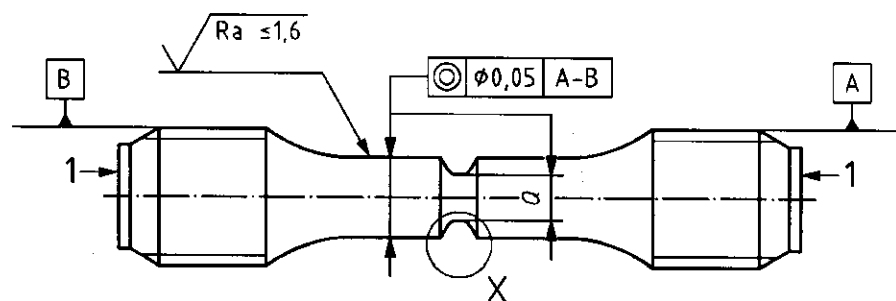
- 1 Calibrated section
- 2 Marking area

General tolerance = js 12

Form tolerance = IT 9

Thread tolerance = ISO 965-1 class 6g

Figure A.1 — Reference FCE type A



Detail X

Key

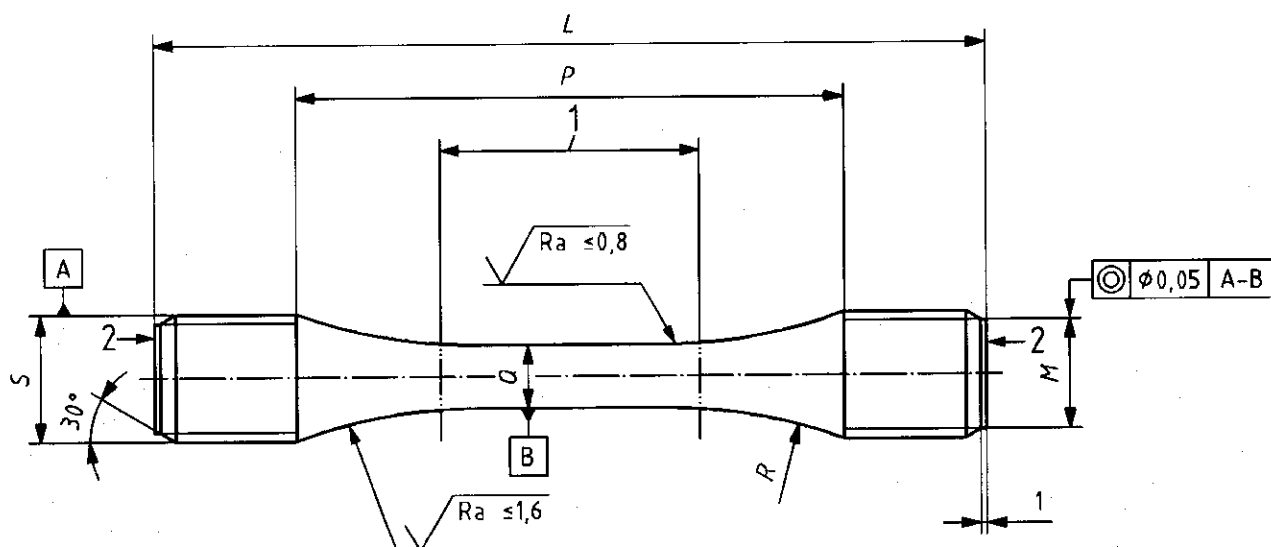
- 1 Marking area
- 2 Calibrated section

General tolerance = js 12

Form tolerance = IT 9

Thread tolerance = ISO 965-1 class 6g

Figure A.2 — Reference FCE type C to J



Key

- 1 Calibrated section
- 2 Marking area

General tolerance = js 12

Form tolerance = IT 9

Thread tolerance = ISO 965-1 class 6g

Figure A.3 — Reference FCE type B

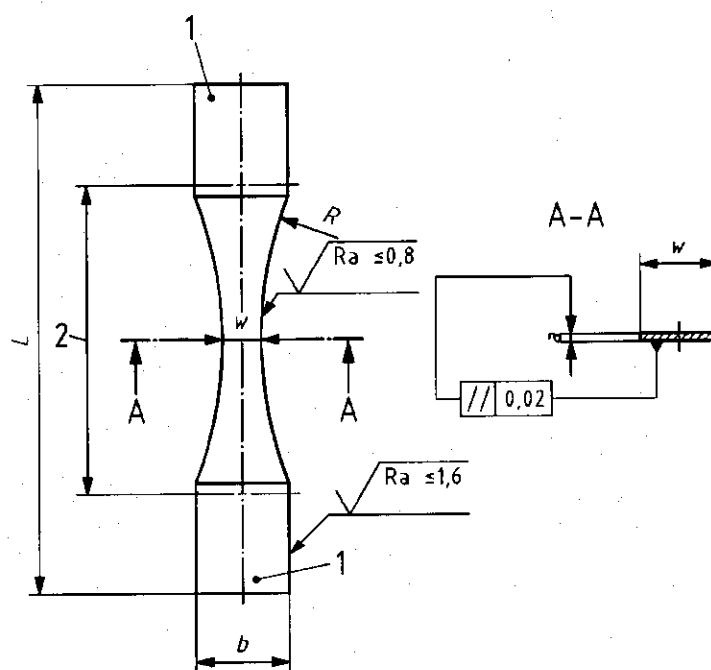
Table A.1 — Dimensions

Dimension in millimetres

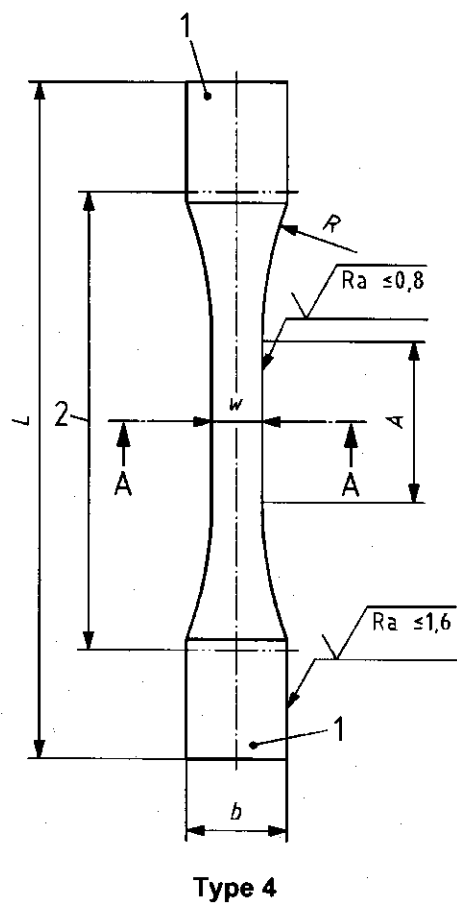
Reference cross section mm ²	L	M	N	P	Q	R	S	Type	K _t	r	Tolerance on r
12,5	60 ¹	9	7	34	3,99	13	M 12 Pitch 100	A ²	1,035	28	± 0,5
								C ²	1,7	1	± 0,02
								D ²	2,3	0,42	
								E ²	3,3	0,18	
								I	2,5	0,35	
								J	3	0,22	
25	80	13	10	48	5,64 ± 0,03	20	M 16 Pitch 100	A ²	1,035	40	± 1
								C ²	1,7	1,41	± 0,02
								D ²	2,3	0,60	
								E ²	3,3	0,25	
								I	2,5	0,49	
								J	3	0,31	
50	110	19	14	68	7,98 ± 0,04	31	M 22 Pitch 100	A ¹	1,035	56	± 1
								C ²	1,7	2	± 0,02
								D ²	2,3	0,84	
								E ²	3,3	0,36	
								I	2,5	0,7	
								J	3	0,44	
95	147	19	-	97	11	90	M 22 Pitch 100	B	1	Length of calibrated section = 35 mm	
¹ Can be lengthened to 80 mm											
² Recommended type											

Annex B (normative)

Axial Fatigue - Flat specimen ($K_t = 1,0$)



Type 1, 2, 3



- Key**
- 1 Marking area
 - 2 Calibrated section

General tolerances = js12

Form tolerances = IT9

Figure B.1 — Types 1 to 4 ($K_t = 1,0$)

Table B.1 — Dimensions

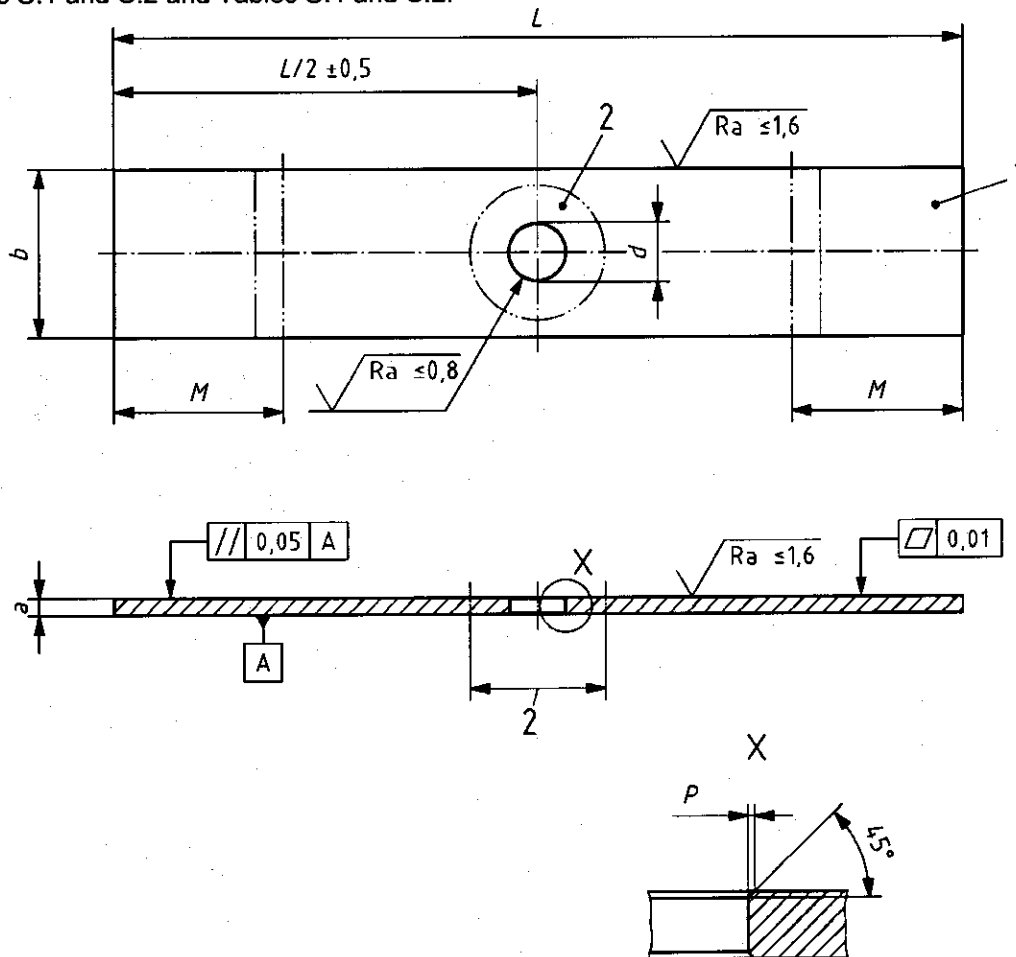
Dimensions in millimetres

Reference cross section mm ²	Type	<i>R</i>	Tolerance on <i>R</i>	<i>L</i>	<i>b</i>	<i>w</i>	<i>A</i>
<i>w</i> × <i>a</i>	Type 1	100	± 1	130	24	10	—
	Type 2	100	± 1	300	40	16	—
	Type 3	50	± 1	200	80	50	—
	Type 4	97	± 1	169	25,4	12,7	40

Annex C (normative)

Axial Fatigue - Flat specimen - "T-Type" and mini "T-Type" specimen ($K_t = 2,3$)

See Figures C.1 and C.2 and Tables C.1 and C.2.



Key

- 1 Marking area
- 2 Calibrated section

Figure C.1 — "T-Type" and "Mini T-Type" ($K_t = 2,3$)

M: area for clamping

Table C.1 — Dimensions

Dimensions in millimetres

Specimen	<i>L</i>	<i>b</i>	Ø	<i>M</i>
T-type	150	30	10	25-35
Mini T-type	100	20	6,35	15-25

Table C.2 — Dimensions

Dimensions in millimetres

Thickness a ¹	Tolerance \varnothing bore		Depth P	Concentricity between bore and chamfer
	Others materials ²	Aluminium alloys		
$3 \begin{smallmatrix} 0 \\ -0,05 \end{smallmatrix}$	$\varnothing \pm 0,1$	$\varnothing \begin{smallmatrix} 0 \\ -0,04 \end{smallmatrix}$	$0,30 \pm 0,05$	$\leq 0,03$
$1 \leq a < 3$	$\varnothing \pm 0,1$	$\varnothing \begin{smallmatrix} 0 \\ -0,04 \end{smallmatrix}$	$0,15 \pm 0,05$	$\leq 0,03$
¹ Specimens with thicknesses above 3 mm can be used on request.				
² Specimen in titanium alloys, steels, nickel alloys...				

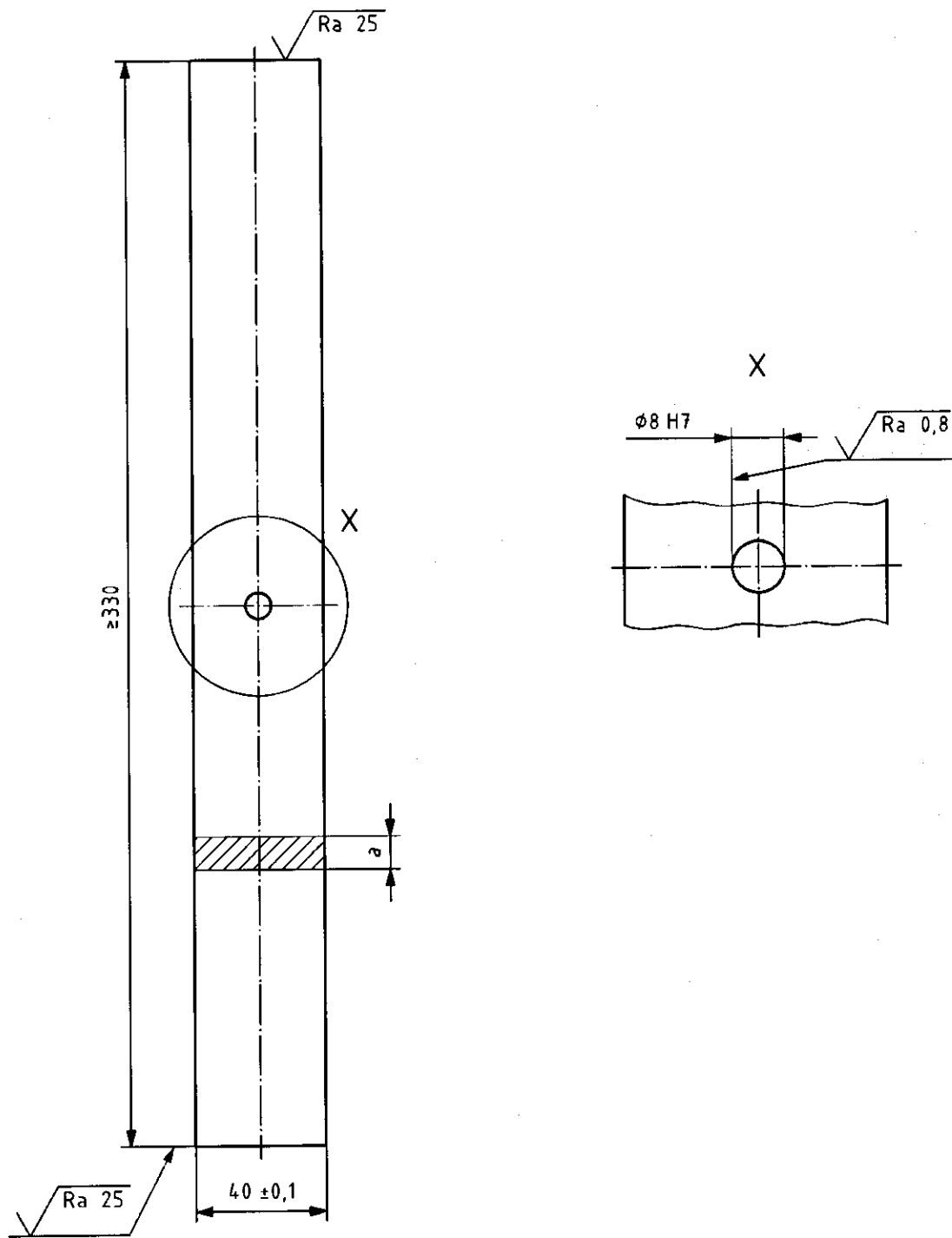
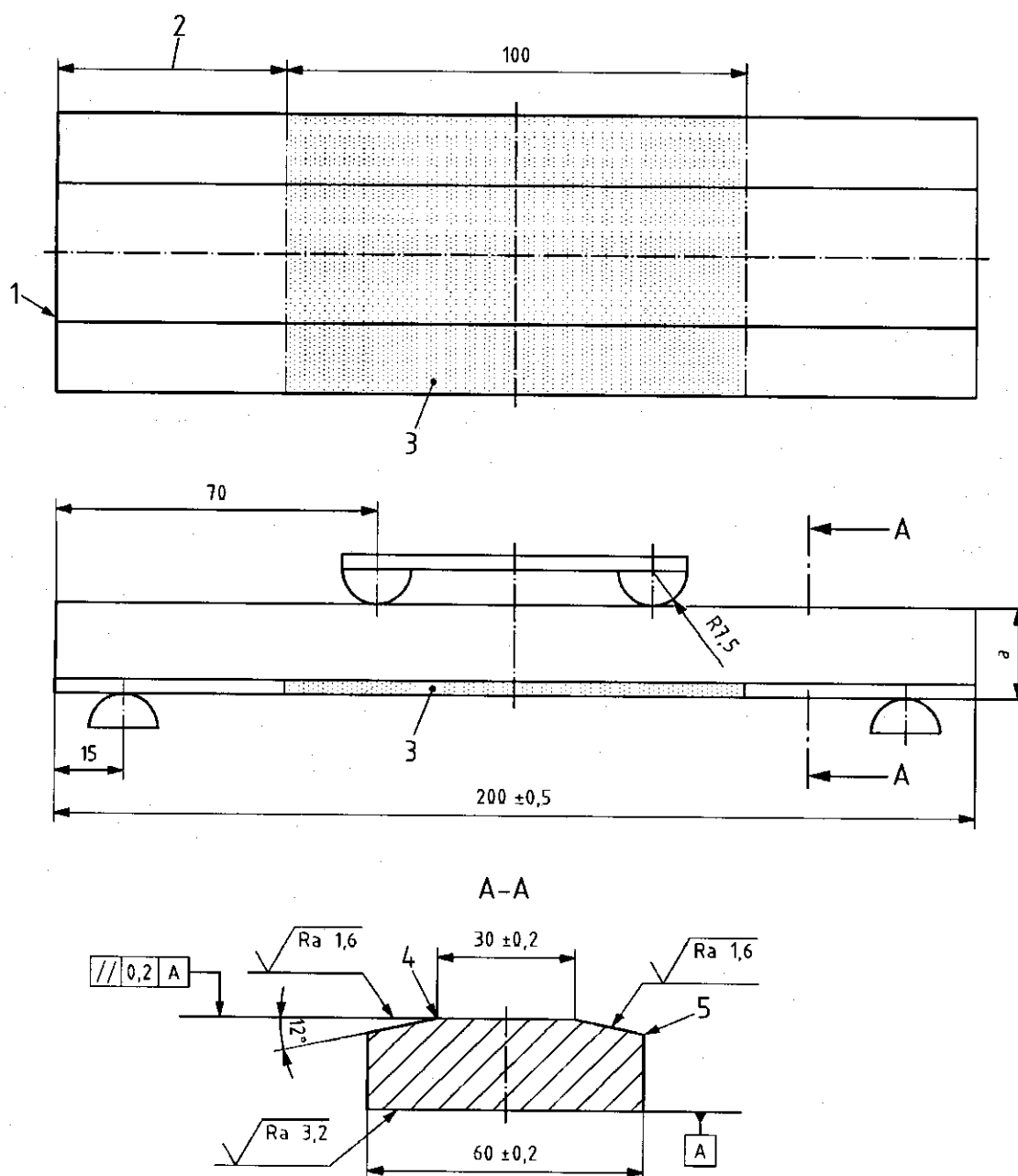


Figure C.2 — "T-Type" ($K_t = 2,5$)

Annex D (normative)

Bending Fatigue - Flat specimen

Dimensions in millimetres



Key

- | | |
|------------------------------|---|
| 1 Marking area (on the edge) | 4 Break sharp edge (abrasive cloth) |
| 2 Long. direction | 5 Break sharp edge (file + abrasive cloth $R = 2 \pm 0,5$) |
| 3 Calibrated section | |

Figure D.1 — Flat specimen

Table D.1 — Thicknesses

	Aluminium alloys	Steel	Titanium and titanium alloys
<i>a</i> mm	20	10	10

Annex E (normative)

Recommendations for machining procedure of specimen

E.1 Cylindrical specimens

E.1.1 Location

According to sampling drawing.

E.1.2 Cutting

Abundant lubrication should be used to ensure that heating is limited during cutting.

E.1.3 Identification of the blank specimens

Individual marking of identification with electric scribe.

E.1.4 Turning

E.1.4.1 Main methods to be used for machining

See Table E.1.

Table E.1 — Main methods to be used for machining

	Cylindrical part	Thread	Groove	
			Rough machining	Finishing
Aluminium and aluminium alloys	Turning	Turning	Turning	Turning
Titanium and titanium alloys	Turning	Turning	Turning	Turning
Steels	Turning	Turning	Turning	Grinding
Nickel & nickel alloys	Turning	Turning	Turning	Grinding

E.1.4.2 Rough machining

- Production of centre holes to comply with concentricity tolerances.
- Lubrication mandatory during each phase; the cutting fluid must be suitable for the machined material.
- Rough machining of outside diameter: depth of pass $\leq 2,5$ mm on radius.

E.1.4.3 Finishing of calibrated section

See Table E.2.

- Machining of calibrated section with a good surface finish.
- Abundant lubrication.
- Sharpening of tool every 15 specimens recommended for notch cylindrical specimens.

Table E.2 — Machining parameters of calibrated section

	Aluminium alloys		Titanium and titanium alloys		Steels		Nickel and nickel alloys	
	Cutting speed m/min	Feed mm/turn	Cutting speed m/min	Feed mm/turn	Cutting speed m/min	Feed mm/turn	Cutting speed m/min	Feed mm/turn
Rough machining	≤ 40	0,3	≤ 30	0,1	40-60	0,15	20	0,2
Finishing	40	0,1	30	0,05	40	0,05-0,10	25	0,1

For other materials, conduct adjustment tests.

E.1.4.4 Machining of groove**E.1.4.4.1 Plunge-cutting**

See Table E.3.

- Applicable for all radius in bottom of groove (r).
- Form tool in steel bar ground to 60°.
- Abundant lubrication.
- Sharpening of tool every 15 specimens is recommended.

Table E.3 — Machining parameters of groove by plunge-cutting

	Aluminium alloys		Titanium and titanium alloys		Steels	
	Cutting speed m/min	Feed mm/turn	Cutting speed m/min	Feed mm/turn	Cutting speed m/min	Feed mm/turn
Rough machining	40	0,05	30	0,05	40	0,15
Finishing	20	0,05	20	0,03	40	0,01 ¹

¹ Temporisation before stop: 2,5 s

E.1.4.4.2 Convoluted-cutting

See Table E.4.

- Applicable for radius in bottom of groove $r \geq 0,8$ mm.
- Lozenge tip tool (for example: VBMT 16 04 04 - F2)
 - in P15/K15 for aluminium alloys
 - in P 40/K40 for titanium and steels.
- Abundant lubrication (water + soluble oil at 3,5 %).
- Sharpening of tool every 15 specimens is recommended.

Table E.4 — Machining parameter of groove by convoluted-cutting

	Aluminium alloys, titanium and titanium alloys			Steels		
	Cutting speed m/min	Feed mm/turn	Depth mm	Cutting speed m/min	Feed mm/turn	Depth mm
Rough machining	150	0,04	0,2	100	0,04	0,2
Finishing	150	0,01	0,2	100	0,01	0,2

E.1.5 Identification of test specimens

Individual marking of identification with electric scriber in zone reserved for this purpose. Provide trimming of marked face with grit 300 cloths to avoid oversize of this face needed for support.

E.1.6 Inspection

E.1.6.1 Procedure

- Geometrical tolerances of each test specimen.
- Visual inspection (binoculars magnification $\times 10$) to check for good surface finish in bottom of groove.
- Shadowgraph shall be used for checking the geometry of the groove.

Machining marks must be fine and homogeneous (even in rough machining phase), if not, the tool shall be resharpener.

E.1.6.2 Inspection report

The operator machining the test specimen must provide the person performing the test with a report giving the results of the inspections carried out in compliance with E.1.6.1.

E.2 Flat specimens

E.2.1 $K_t = 1,0$ Specimen and Flat Bending Fatigue Specimen

E.2.1.1 General

This process is applicable for these types of test specimens.

Calibrated section of $K_t = 1,0$ Specimen shall be produced using a form milling cutter (carbon-tipped edge mill).

E.2.1.2 Location

According to sampling drawing.

E.2.1.3 Cutting

Abundant lubrication should be used to ensure that heating is limited during cutting.

E.2.1.4 Identification of the blank specimens

Individual marking of identification with electric scribe in zone reserved for this purpose.

E.2.1.5 Milling of calibrated section

- When machining is required, to ensure flatness of the specimen to an oversize of 0,25 mm, material shall be rough machined symmetrically from each face (see Table E.4).
- The final finishing pass shall be 0,125 mm max. on each face.
- Lubrication mandatory during each pass; the cutting fluid must be suitable for the machined material.
- The edges in the calibrated section shall be finished by longitudinal polishing with fine emery cloth (grade 220) and then, if it is necessary, final polishing with grade 600 emery paper. The corners have to be rounded with a minimum radius of 0,5 mm and to be polished.

Table E.5 — Machining parameters

Material	Aluminium alloys	Titanium and titanium alloys	Steels (UTS < 1 400 MPa)
Feed (mm/tooth)	0,1	0,1	0,1
Cutting speed (m/min)	300	50	100

For other alloys, conduct adjustments tests.

E.2.1.6 Identification of test specimens

Transfer initial markings to test specimen zones reserved for this purpose.

E.2.2 T-type and mini T-type specimen ($K_t = 2,3$) and T-type specimen ($K_t = 2,5$)

E.2.2.1 General

This process is applicable for all T-types of test specimens.

E.2.2.2 Location

According to sampling drawing.

E.2.2.3 Cutting

Abundant lubrication should be used to ensure that heating is limited during cutting.

E.2.2.4 Identification of the blank specimens

Individual marking of identification with electric scriber in zone reserved for this purpose.

E.2.2.5 Milling

- All milling will be made with carbide mills.
- When machining is required, to ensure flatness and residual stresses level of the specimen, to an oversize of 0,25 mm, material shall be rough machined symmetrically from each face. The final finishing pass shall be 0,125 mm maximum on each face.
- Diameter of milling cutter: 50 mm-80 mm
- Score orientation / load direction: perpendicular to the load
- Lubrication mandatory during each pass; the cutting fluid must be suitable for the machined material.

Table E.6 — Machining parameters

Material	Aluminium alloys	Titanium and titanium alloys	Steels (UTS ≤ 1 400 MPa)
Feed (mm/tooth)	0,02	0,1	0,1
Cutting speed (m/min)	400	50	40

For other alloys, conduct adjustments tests.

E.2.2.6 Identification of test specimens

Transfer initial markings to test specimen zones reserved for this purpose.

E.2.2.7 Drilling-reaming

E.2.2.7.1 T-type and mini T-type specimen ($K_t = 2,3$)

- Clamping on back plate
- Drilling of a pilot hole to 7 mm (T-type) or 5 mm (mini T-type) diameter with a standard drill, only for aluminium alloys.
- Drilling and reaming of the final diameter mm

Table E.7 — Drilling-reaming

Material	Aluminium alloys	Titanium and titanium alloys	Steels (UTS ≤ 1 400 MPa)
Tool	Ø mm dia. finishing drill	Ø mm dia. carbide-tipped drill	Ø mm dia. carbide-tipped drill
Feed (mm/min)	100	60	90
Cutting speed (m/min)	20	30	40
Change of tool	Every 500 holes	Every 50 holes	Every 25 holes

Continuous lubrication with cutting fluid qualified for the machined material.

For other alloys, conduct adjustments tests.

E.2.2.7.2 T-type specimen ($K_t = 2,5$)

- To avoid burring of the holes, use cover plates on both sides of the specimen. Take great care that the sharpening of the drill is sufficient. A large burr on the outgoing side shows that the sharpness is not sufficient. Specimens with large burr must not be used for testing, depending on hardening of the hole by the drilling process.
- Predrilling shall be done using a twist drill of HSS material (full carbide drill for titanium can be used) and with oil emulsion cutting fluid. The hole diameter shall be 7,7 mm. The drill speed shall be 600 rpm for aluminium alloys and steel, and 300 rpm for titanium and titanium alloys.
- The reaming of the hole shall be carried out using spiral groove reamer of HSS material (full carbide reamer for steel and titanium can be used) at a feed rate of 0,1 mm/turn and with oil emulsion cutting fluid.
A new reamer shall be used after preparation of 10 holes (50 holes if using a full carbide tool) for titanium, titanium alloys and steel and after 50 holes for aluminium alloys. The reaming speed shall be 90 rpm for titanium and titanium alloys, 100 rpm for steel and 400 rpm for aluminium alloys.
- Great care is to be taken during deburring of the hole and edges to avoid chamfering. Deburring by using a chamfering tool is not allowed.
- Grinding in longitudinal direction of the specimen with very fine paper is preferred.
- For grinding of titanium, titanium alloys and steel see 6.3.3.

E.2.2.8 Chamfering of T-type and mini T-type specimen ($K_t = 2,3$)

- To be carried out on a hand-controlled pillar drill with a micrometer stop and a milling cutter with a smooth pilot tip, Ø 21 mm, speed 250 rpm. See Figure E.1.
- Preliminary tests shall be carried out to adjust the milling depth (i.e. the stop).

E.2.3 Inspection

E.2.3.1 Procedure

- Geometrical tolerances of each test specimen
- Visual inspection (binoculars magnification × 10) of the hole and chamfer area to check for good surface finish and identify score marks.

E.2.3.2 Inspection report

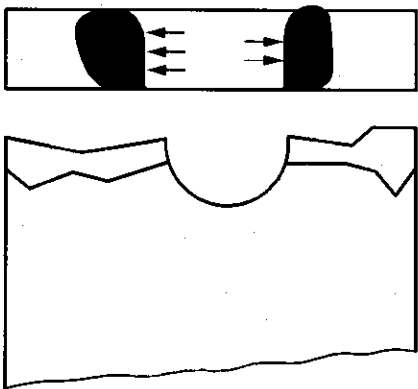
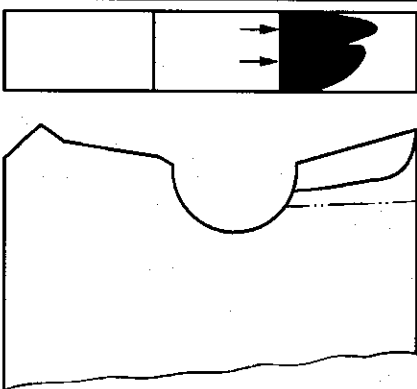
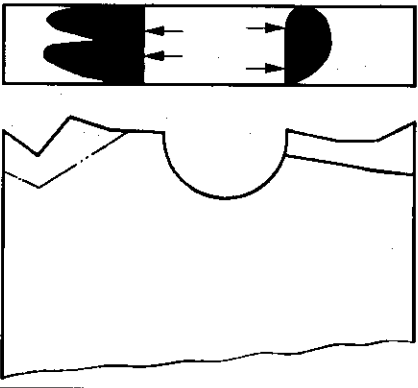
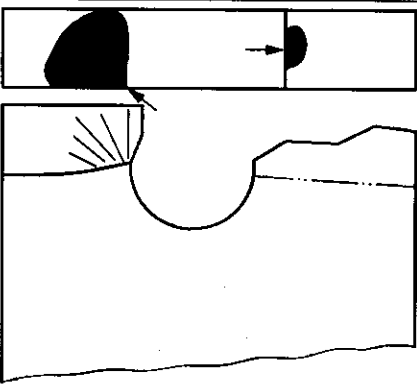
The operator machining the test specimen must provide the person performing the test with a report giving the results of the inspections carried out in compliance with E.2.3.1.

Annex F
(normative)

Indication of failure sites

See Table F.1.

Table F.1 — Example

"T-Type" Specimen	
Material:	
Nett cross-section:	
	
Specimen nb. = XXX - 1 $s_{max} = 220 \text{ MPa}$ Number of cycles = 53 000	Specimen nb = XXX - 2 $s_{max} = 220 \text{ MPa}$ Number of cycles = 99 000
	
Specimen nb = XXX - 3 $s_{max} = 220 \text{ MPa}$ Number of cycles = 31 600	Specimen nb = XXX - 4 $s_{max} = 180 \text{ MPa}$ Number of cycles = 241 400

Annex G (normative)

Table of fatigue test results

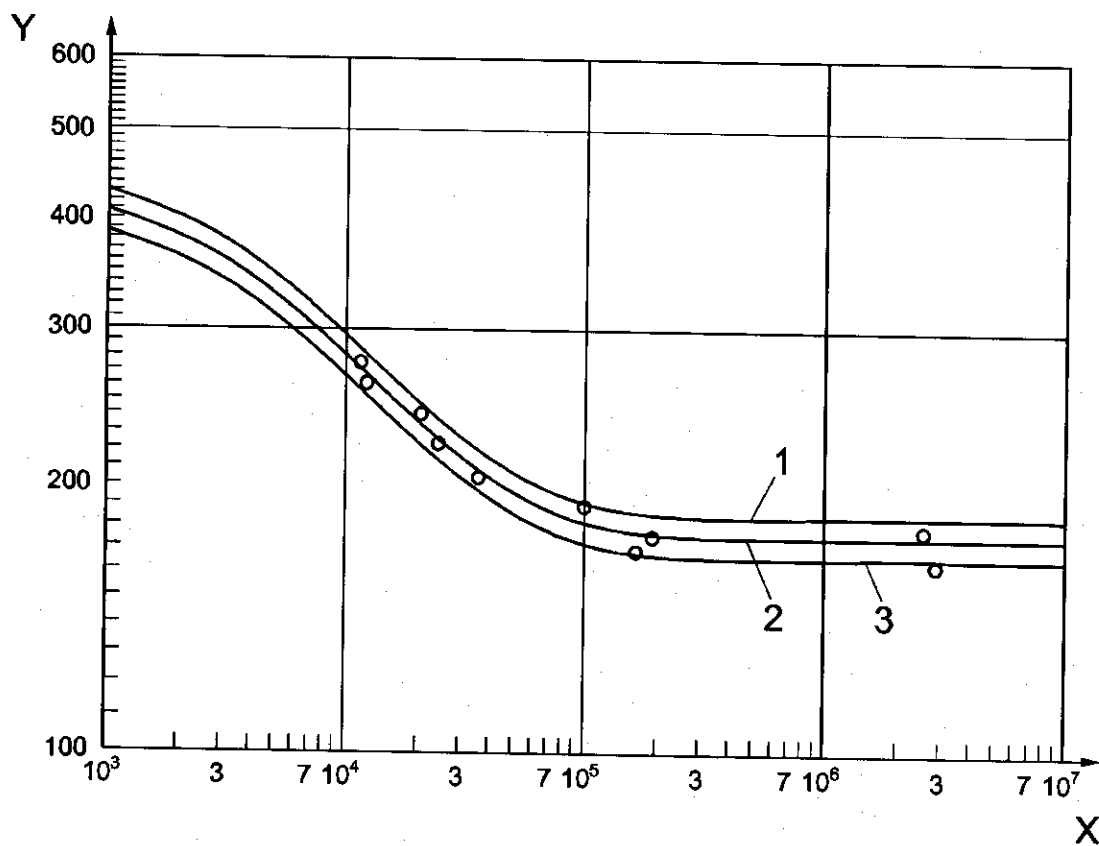
See Table G.1.

Table G.1 — Example

Specimen	Thick- ness	Width	Hole	Cross section	Max. load	Min. load	Stress amplit.	Stress max. net.	Nb of cycles	Comments
N_o	a mm	b mm	d mm	mm ²	P_o N	P_u N	σ_a MPa	$\sigma_{max.}$ MPa	N	
XXX - 1	2,10	40,20	8,00	67,6	13 000	1 300	86,5	192	9 870	D A
XXX - 2	2,00	40,20	8,00	64,4	8 000	800	55,9	124	98 020	
XXX - 3	2,00	40,10	8,00	64,2	9 300	930	65,2	145	39 650	
XXX - 4	2,00	40,00	8,00	64,0	5 700	570	40,1	89	3 000 000	
XXX - 5	2,00	40,00	8,00	64,0	7 500	750	52,7	117	89 760	
XXX - 6	2,00	40,10	8,00	67,4	7 100	710	47,4	105	31 2100	
XXX - 7	2,00	40,00	8,00	64,0	6 700	670	47,1	108	831 300	B
XXX - 8	2,00	40,10	8,00	64,2	6 400	640	44,9	100	3 000 000	
XXX - 9	2,00	40,20	8,00	64,4	7 300	730	51,0	113	185 660	C
XXX - 4	2,00	40,00	8,00	64,0	11 500	1 150	80,9	180	17 000	
XXX - 8	2,00	40,10	8,00	64,2	10 000	1 000	70,1	156	7850	D
<p>A = No failure, increased to $P_o = 11\,500\text{ N}$</p> <p>B = No failure, increased to $P_o = 10\,000\text{ N}$</p> <p>C = Failure initiation not at the hole</p> <p>D = Not taken into account for analysis</p>										

Annex H (normative)

Representation of fatigue data



Key

- 1 $P_u = 10\%$
- 2 $P_u = 50\%$
- 3 $P_u = 90\%$
- X Cycles to Failure
- Y Net Stress Amplitude δ_a (MPa)

Figure H.1 — Example

Annex I **(informative)**

Example of inspection card process

It is recommended to use an inspection card, or whatever similar system, to check the reproducibility of the process (mainly the machining of samples). This can be done as following:

- supply one plate in aluminium (or other material) long enough to enable machining samples during some years.
- testing of 20 or 25 samples machined from this plate, according to this EN: this will be the reference.
- for each campaign of machining samples, add 3 or 4 samples from this plate and test all of them for comparing results with the reference.

By this kind of method, any deviation in the process of machining or machine testing will be pointed out.

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