

ISO 8642:2025-07 (E)

Aerospace - Self-locking nuts with maximum operating temperature greater than 425 °C - Test methods

Contents		Page
Foreword		iv
1	Scope	1
2	Normative references	1
3	Terms and definitions	1
4	Inspections and tests	1
4.1	Hardness test	1
4.1.1	Procedure	1
4.1.2	Method	2
4.2	Bearing surface squareness test	2
4.2.1	Test device	2
4.2.2	Method	3
4.3	Axial load test	4
4.3.1	Test device	4
4.3.2	Method	4
4.4	Wrenching feature test	5
4.4.1	General	5
4.4.2	Test device	5
4.4.3	Method	6
4.5	Torque-out test	6
4.5.1	General	6
4.5.2	Test device	7
4.5.3	Method	7
4.6	Test of no rotation of the captive washer	8
4.6.1	General	8
4.6.2	Test device	8
4.6.3	Method	8
4.7	Push-out test	8
4.7.1	General	8
4.7.2	Test device	9
4.7.3	Method	9
4.8	Self-locking torque at ambient temperature	10
4.8.1	Test device	10
4.8.2	Method	11
4.9	Self-locking torque at ambient temperature after heat soak at maximum operating temperature	12
4.9.1	Test device	12
4.9.2	Method	14
4.10	Permanent set test	15
4.10.1	General	15
4.10.2	Test device	15
4.10.3	Method	16
4.11	Vibration test	17
4.11.1	General	17
4.11.2	Test device	17
4.11.3	Method	19
4.12	Swaging test	20
4.12.1	General	20

4.12.2 Visual examination	20
Bibliography	21