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**NORTH ATLANTIC TREATY ORGANIZATION
ORGANISATION DU TRAITE DE L'ATLANTIQUE NORD**

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MAS(AIR)407-ASP/3625

19 December 1995

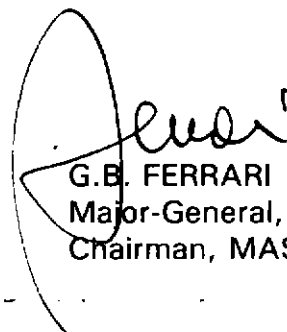
To : See Distribution List Air B

Subject : STANAG 3625 ASP (EDITION 4) - AIRCRAFT LOCKWIRE

Reference : MAS(AIR)98-ASP/3625 dated 23 March 1989 (Edition 3)

Enclosure : STANAG 3625 (Edition 4)

1. The enclosed NATO Standardization Agreement which has been ratified by nations as reflected in page iii is promulgated herewith.
2. The reference listed above is to be destroyed in accordance with local document destruction procedures.
3. AAP-4 should be amended to reflect the latest status of the STANAG.
4. The Air Board, MAS, considers this an editorial revision to the STANAG, previous ratifying references and implementation details are deemed to be valid.



G.B. FERRARI
Major-General, ITAF
Chairman, MAS

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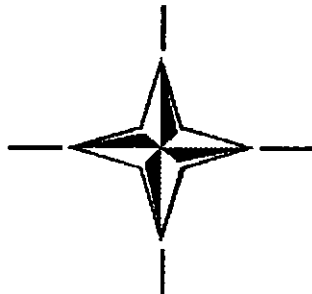
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STANAG No. 3625
(Edition 4)

**NORTH ATLANTIC TREATY ORGANIZATION
(NATO)**




**MILITARY AGENCY FOR STANDARDIZATION
(MAS)**

**STANDARDIZATION AGREEMENT
(STANAG)**

SUBJECT: AIRCRAFT LOCKWIRE

Promulgated on 19 December 1995


G.B. FERRARI
Major-General, ITAF
Chairman, MAS

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RECORD OF AMENDMENTS

No.	Reference/date of amendment	Date entered	Signature

EXPLANATORY NOTES

AGREEMENT

1. This NATO Standardization Agreement (STANAG) is promulgated by the Chairman MAS under the authority vested in him by the NATO Military Committee.
2. No departure may be made from the agreement without consultation with the tasking authority. Nations may propose changes at any time to the tasking authority where they will be processed in the same manner as the original agreement.
3. Ratifying nations have agreed that national orders, manuals and instructions implementing this STANAG will include a reference to the STANAG number for purposes of identification.

DEFINITIONS

4. Ratification is "In NATO Standardization, the fulfilment by which a member nation formally accepts, with or without reservation, the content of a Standardization Agreement" (AAP-6).
5. Implementation is "In NATO Standardization, the fulfilment by a member nation of its obligations as specified in a Standardization Agreement" (AAP-6).
6. Reservation is "In NATO Standardization, the stated qualification by a member nation that describes that part of a Standardization Agreement that it will not implement or will implement only with limitations" (AAP-6).

RATIFICATION, IMPLEMENTATION AND RESERVATIONS

7. Page iii gives the details of ratification and implementation of this agreement. If no details are shown it signifies that the nation has not yet notified the tasking authority of its intentions. Page iv (and subsequent) gives details of reservations and proprietary rights that have been stated.

Agreed English/French Texts

STANAG 3625
(Edition 4)

NAVY/ARMY/AIR

NATO STANDARDIZATION AGREEMENT
(STANAG)

AIRCRAFT LOCKWIRE

Related Document: ISO 245 - AIRCRAFT - LOCKWIRE

AIM

1. The aim of this agreement is to standardize materials, dimensions, and mechanical requirements of lockwire for aircraft.

AGREEMENT

2. Participating nations agree to the following:

- a. Material. Lockwire for aerospace purposes is to be made from one of the materials listed in Table I below:

TABLE I

CONDITION AND CHARACTERISTICS OF AIRCRAFT LOCKWIRE

Material	Condition	Minimum Tensile Strength		Limiting Temperature °C
		N/mm ²	lbf/in ²	
Corrosion resisting steel	Fully softened lightly drawn	550	80,000	600
Heat resisting nickel alloy	Fully softened and descaled	-	-	960

- b. Mechanical Requirements. At room temperature, test samples of the finished wire are to withstand the following tests without cracking:

- (1) Corrosion Resisting Steel Wire. The finished wire is to withstand bending through 180°, over a mandrel equal in diameter to the wire diameter, and closed flat.

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(2) Heat Resisting Nickel Alloy Wire

- (a) Bent three times through 180° and return over a mandrel equal in diameter to three times the wire diameter.
- (b) Wrapped nine complete turns, close coiled, round a mandrel equal in diameter to the wire diameter, and unwrapped eight turns.
- c. Dimensions. The range of lockwire diameters and the holes for which they are suitable are to be as given in Table II below. Not all lockwire sizes indicated in Table II must be made available.

TABLE II

DIAMETERS OF WIRE, TOLERANCES, AND HOLE DIMENSIONS

Wire diameter		Tolerance on wire diameter		Minimum hole diameter	
mm	in	mm	in	mm	in
0.50	0.020	± 0.04	± 0.0015	0.60	0.024
0.80	0.032	± 0.04	± 0.0015	0.90	0.035
1.00	0.040	± 0.05	± 0.002	1.1	0.043
1.25	0.050	± 0.05	± 0.002	1.4	0.055
2.00	0.079	± 0.08	± 0.003	2.2	0.087
2.30	0.091	± 0.08	± 0.003	2.5	0.098
2.5	0.100	± 0.08	± 0.003	2.7	0.106

IMPLEMENTATION OF THE AGREEMENT

3. This STANAG is implemented when a nation has issued instructions that all future equipment procured for its forces will be manufactured in accordance with the specifications detailed in this agreement.