



**SLOVENSKI STANDARD**  
**SIST EN 28746:1996**

**01-april-1996**

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**Zatiči s polokroglo glavo in zarezo po vsej dolžini**

Grooved pins with round head (ISO 8746:1986)

Halbrundkerbnägel (ISO 8746:1986)

Clous cannelés a tete ronde (ISO 8746:1986)

**Ta slovenski standard je istoveten z: EN 28746:1992**

[SIST EN 28746:1996](https://standards.iteh.ai/catalog/standards/sist/1af7e720-5262-45b9-a16c-e69637bd904b/sist-en-28746-1996)

<https://standards.iteh.ai/catalog/standards/sist/1af7e720-5262-45b9-a16c-e69637bd904b/sist-en-28746-1996>

**ICS:**

21.060.50      Zatiči, žablji      Pins, nails

**SIST EN 28746:1996**      **en**

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EUROPEAN STANDARD

EN 28746:1992

NORME EUROPÉENNE

EUROPÄISCHE NORM

July 1992

UDC 621.886.12

Descriptors: Fasteners, grooved nails, specifications, dimensions, designation

English version

## Grooved pins with round head (ISO 8746:1986)

Clous cannelés à tête ronde (ISO 8746:1986) Halbrundkerbnägel (ISO 8746:1986)

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This European Standard was approved by CEN on 1992-07-17. CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration.

Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

The European Standards exist in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

**CEN**

European Committee for Standardization  
Comité Européen de Normalisation  
Europäisches Komitee für Normung

Central Secretariat: rue de Stassart, 36 B-1050 Brussels

## FOREWORD

In 1992, CEN Technical Committee CEN/TC 185 "Threaded and non threaded mechanical fasteners and accessories" the secretariat of which is held by DIN decided to submit the International Standard

ISO 8746:1986 - "Grooved pins with round head"

to the formal vote procedure.

The result was positive.

In the countries bound to implement this European Standard a national standard identical to this European standard shall be published at the latest by 1993-01-31 and conflicting national standards shall be withdrawn at the latest by 1993-01-31.

### **iTeh STANDARD PREVIEW**

According to the CEN/CENELEC Common Rules the following countries are bound to implement this European Standard : Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Spain, Portugal, Sweden, Switzerland and United Kingdom.

<https://standards.itih.ai/catalog/standards/sist/1af7e720-5262-45b9-a16c-e69637bd904b/sist-en-28746-1996>

### Endorsement notice

The text of the International Standard ISO 8746:1986 was approved by CEN as a European Standard without any modification.

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International Standard



8746

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## Grooved pins with round head

*Clous cannelés à tête ronde*

First edition — 1986-11-01

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UDC 621.886.128

Ref. No. ISO 8746-1986 (E)

Descriptors : fasteners, pins (mechanics), grooved pins, specifications, dimensions, designation.

## Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work.

Draft International Standards adopted by the technical committees are circulated to the member bodies for approval before their acceptance as International Standards by the ISO Council. They are approved in accordance with ISO procedures requiring at least 75 % approval by the member bodies voting.

International Standard ISO 8746 was prepared by Technical Committee ISO/TC 2, *Fasteners*.

Users should note that all International Standards undergo revision from time to time and that any reference made herein to any other International Standard implies its latest edition, unless otherwise stated.

## Grooved pins with round head

### iTeh STANDARD PREVIEW (standards.iteh.ai)

#### 1 Scope and field of application

SIST EN 28746:1996

This International Standard specifies the characteristics of round head grooved pins which have three equally spaced grooves impressed longitudinally on their exterior surface, with metric dimensions and nominal diameter,  $d_1$ , from 1,4 to 20 mm inclusive.

The displaced material to each side of the grooves forming an expanded diameter  $d_2$  which is larger than the nominal diameter  $d_1$  will cause a positive locking fit when these grooved pins are forced into a drilled hole equal to the nominal diameter  $d_1$  (see clause 4).

#### 2 References

ISO 2081, *Metallic coatings — Electroplated coatings of zinc on iron or steel.*

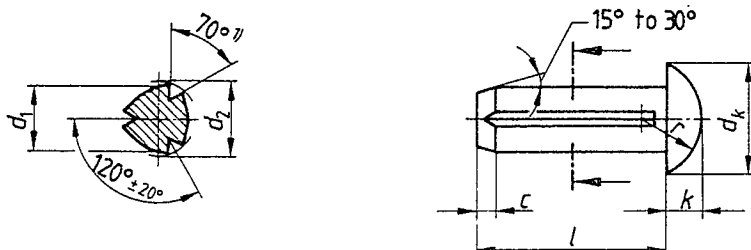
ISO 3269, *Fasteners — Acceptance inspection.*

ISO 4520, *Chromate conversion coatings on electroplated zinc and cadmium coatings.*

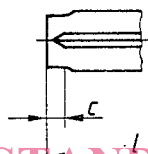
## ISO 8746-1986 (E)

## 3 Dimensions

Type A  
Pin with chamfered end



Type B  
Pin with pilot end  
(at the discretion of the supplier, or  
specifically ordered by the customer)



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NOTE — Other dimensions, see type A.

Dimensions in millimetres

$d_1$	nom.	1,4	1,6	2	2,5	3	4	5	6	8	10	12	16	20	
	max.	1,4	1,6	2	2,5	3	4	5	6	8	10	12	16	20	
	min.	1,35	1,55	1,95	2,425	2,925	3,9	4,9	5,9	7,85	9,85	11,8	15,8	19,8	
$d_k$	max.	2,6	3,0	3,7	4,6	5,45	7,25	9,1	10,8	14,4	16	19	25	32	
	min.	2,2	2,6	3,3	4,2	4,95	6,75	8,5	10,2	13,6	14,9	17,7	23,7	30,7	
$k$	max.	0,9	1,1	1,3	1,6	1,95	2,55	3,15	3,75	5,0	7,4	8,4	10,9	13,9	
	min.	0,7	0,9	1,1	1,4	1,65	2,25	2,85	3,45	4,6	6,5	7,5	10	13	
$r$	≈	1,4	1,6	1,9	2,4	2,8	3,8	4,6	5,7	7,5	8	9,5	13	16,5	
$c$		0,42	0,48	0,6	0,75	0,9	1,2	1,5	1,8	2,4	3,0	3,6	4,8	6	
nom.	$l^{2)}$		Expanded diameter, $d_2^{3),4)}$												
	min.	max.	+ 0,05 0			± 0,05						± 0,10			
3	2,8	3,2	1,50	1,70	2,15	2,70	3,20	4,25	5,25	6,30	8,30	10,35	12,35	16,40	20,50
4	3,7	4,3													
5	4,7	5,3													
6	5,7	6,3													
8	7,7	8,3													
10	9,7	10,3													
12	11,6	12,4													
16	15,6	16,4													
20	19,5	20,5													
25	24,5	25,5													
30	29,5	30,5													
35	34,5	35,5													
40	39,5	40,5													

1) The grooving angle  $70^\circ$  applies only to grooved pins made from steel as shown in clause 5. The grooving angle may be modified depending on resilience of material.

2) The range of commercial lengths is between the stepped lines.

3) The expanded diameter,  $d_2$ , applies only to pins made from free-cutting steel or cold-heading steel. For other materials, for example stainless steel, a reduction amount shall be subtracted from the given values and should be agreed between customer and supplier.

4) For testing  $d_2$ , a GO/NO GO ring gauge should be used.