



SLOVENSKI STANDARD
SIST EN ISO 8734:2001
01-julij-2001

Valjasti zatiči, kaljeni ali iz martenzitnega nerjavnega jekla (ISO 8734:1997)

Parallel pins, or hardened steel or martensitic stainless steel (Dowel pins) (ISO 8734:1997)

Zylinderstifte aus gehärtetem Stahl und martensitischem nichtrostendem Stahl (ISO 8734:1997)

Goupilles cylindriques en acier trempé et en acier inoxydable martensitique (ISO 8734:1997)

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Ta slovenski standard je istoveten z: EN ISO 8734:1997

ICS:

21.060.50 Zatiči, žebli Pins, nails

SIST EN ISO 8734:2001 **en**

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EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

EN ISO 8734

November 1997

ICS 21.060

Supersedes EN 28734:1992

Descriptors: see ISO document

English version

Parallel pins, of hardened steel or martensitic stainless steel
(Dowel pins) (ISO 8734:1997)

Goupilles cylindriques en acier trempé et en acier
inoxydable martensitique (ISO 8734:1997)

This European Standard was approved by CEN on 23 October 1997.

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.

This European Standard exists 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, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

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

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EN ISO 8734:1997

Foreword

The text of the International Standard ISO 8734:1997 has been prepared by Technical Committee ISO/TC 2 "Fasteners" in collaboration with Technical Committee CEN/TC 185 "Threaded and non-threaded mechanical fasteners and accessories", the secretariat of which is held by DIN.

This European Standard supersedes EN 28734:1992.

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 1998, and conflicting national standards shall be withdrawn at the latest by May 1998.

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

Endorsement notice

The text of the International Standard ISO 8734:1997 has been approved by CEN as a European Standard without any modifications.

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INTERNATIONAL STANDARD

ISO
8734

Second edition
1997-11-15

Parallel pins, of hardened steel and martensitic stainless steel (Dowel pins)

Goupilles cylindriques en acier trempé et en acier inoxydable martensitique

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Reference number
ISO 8734:1997(E)

ISO 8734:1997(E)

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. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

International Standard ISO 8734 was prepared by Technical Committee ISO/TC 2, *Fasteners*.

This second edition cancels and replaces the first edition (ISO 8734:1987), which has been technically revised.

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Printed in Switzerland

Parallel pins of hardened steel and martensitic stainless steel (Dowel pins)

1 Scope

This International Standard specifies the characteristics of parallel pins (dowel pins) of steel, through hardened or case hardened and martensitic stainless steel with nominal diameters, d , from 1 mm to 20 mm inclusive.

2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this International Standard. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this International Standard are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 3269:1988, *Fasteners – Acceptance inspection*.

ISO 3506-1:1997, *Corrosion-resistant stainless steel fasteners – Part 1: Bolts, screws and studs*.

ISO 4042:¹⁾, *Fasteners – Electroplated coatings*.

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3 Dimensions

See figure 1 and table 1.

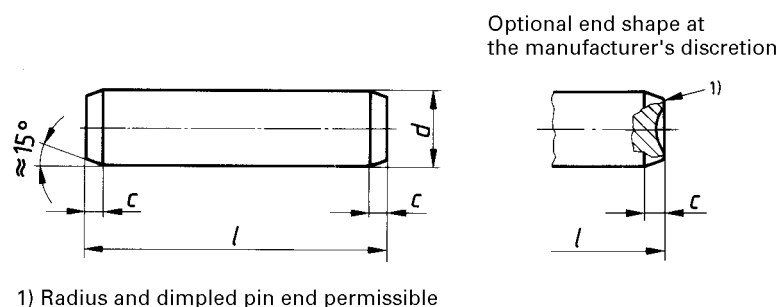


Figure 1

1) To be published. (Revision of ISO 4042:1989)

Table 1 — Dimensions

d			Dimensions in millimetres												
			1	1,5	2	2,5	3	4	5	6	8	10	12	16	20
c			0,2	0,3	0,35	0,4	0,5	0,63	0,8	1,2	1,6	2	2,5	3	3,5
$l^{2)}$															
nom.	min.	max.													
3	2,75	3,25													
4	3,75	4,25													
5	4,75	5,25													
6	5,75	6,25													
8	7,75	8,25													
10	9,75	10,25													
12	11,5	12,5													
14	13,5	14,5													
16	15,5	16,5													
18	17,5	18,5													
20	19,5	20,5													
22	21,5	22,5													
24	23,5	24,5													
26	25,5	26,5													
28	27,5	28,5													
30	29,5	30,5													
32	31,5	32,5													
35	34,5	35,5													
40	39,5	40,5													
45	44,5	45,5													
50	49,5	50,5													
55	54,25	55,75													
60	59,25	60,75													
65	64,25	65,75													
70	69,25	70,75													
75	74,25	75,75													
80	79,25	80,75													
85	84,25	85,75													
90	89,25	90,75													
95	94,25	95,75													
100	99,25	100,75													

1) Other tolerances as agreed between customer and supplier.

2) For nominal lengths above 100 mm, steps of 20 mm.

4 Requirements and reference International Standards

See table 2.

Table 2 — Requirements and reference International Standards

Material ¹⁾	Steel		Martensitic stainless steel
	St		C1 in accordance with ISO 3506-1
	Type A pin through hardened	Type B pin case hardened	hardened and tempered to a hardness of 460 HV30 to 560 HV30
	Chemical composition limits (check analysis) %		
		either	
C 0,95 to 1,1 Si 0,15 to 0,35 Mn 0,25 to 0,4 P 0,03 max. S 0,025 max. Cr 1,35 to 1,65	C 0,06 to 0,13 Si 0,1 to 0,4 Mn 0,25 to 0,6 P 0,025 max. S 0,05 max.	C 0,15 max. Si 0,10 max. Mn 0,9 to 1,3 P 0,07 max. S 0,15 to 0,35 Pb 0,15 to 0,35	
Hardness: 550 HV30 to 650 HV30		Surface hardness: 600 HV1 to 700 HV1 Hardness at case depth 0,25 to 0,4 mm: 550 HV1 min.	
Surface	Plain, i.e. pins to be supplied in natural finish, treated with a protective lubricant, unless otherwise specified by agreement between customer and supplier.		
	If pins are surface coated appropriate plating or coating processes should be employed to avoid hydrogen embrittlement. When pins are electroplated or phosphate-coated, they shall be suitably treated immediately after plating or coating to obviate detrimental hydrogen embrittlement, although freedom from hydrogen embrittlement is not absolutely guaranteed (see ISO 4042). All tolerances shall apply prior to the application of a plating or coating.		
Surface roughness	$R_a \leq 0,8 \mu\text{m}$		
Workmanship	Pins shall be free of irregularities or detrimental defects. No burrs shall appear on any part of the pin.		
Acceptability	The acceptance procedure is covered in ISO 3269.		
1) Other materials as agreed between customer and supplier.			