



SLOVENSKI STANDARD

SIST EN ISO 8746:2001

01-julij-2001

Nadomešča:
SIST EN 28746:1996

Zasekani zatiči s polokroglo glavo in brazdami enake dolžine po vsej dolžini (ISO 8746:1997)

Grooved pins with round head (ISO 8746:1997)

Halbrundkerbnägel (ISO 8746:1997)

Clous cannelés à tête ronde (ISO 8746:1994)

Ta slovenski standard je istoveten z: EN ISO 8746:1997

ICS:

21.060.50 Zatiči, žebli

Pins, nails

SIST EN ISO 8746:2001

en

iTeh STANDARD PREVIEW
(standards.iteh.ai)

SIST EN ISO 8746:2001

<https://standards.iteh.ai/catalog/standards/sist/8f2bb472-9a00-4071-a9e9-6e1615ea6876/sist-en-iso-8746-2001>

EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

EN ISO 8746

November 1997

ICS 21.060.50

Supersedes EN 28746:1992

Descriptors: see ISO document

English version

Grooved pins with round head (ISO 8746:1997)

Clous cannelés à tête ronde (ISO 8746:1997)

Halbrundkerbnägel (ISO 8746:1997)

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.

STANDARD PREVIEW
(standards.iteh.ai)
<https://standards.iteh.ai/catalog/standards/sist/8f2bb472-9a00-4071-a9e9-6e1615ea6876/sist-en-iso-8746-2001>



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

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

Page 2
EN ISO 8746:1997

Foreword

The text of the International Standard ISO 8746:1997 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 28746:1992.

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 8746:1997 has been approved by CEN as a European Standard without any modifications.

(standards.iteh.ai)

SIST EN ISO 8746:2001

<https://standards.iteh.ai/catalog/standards/sist/8f2bb472-9a00-4071-a9e9-6e1615ea6876/sist-en-iso-8746-2001>

INTERNATIONAL STANDARD

ISO
8746

Second edition
1997-11-15

Grooved pins with round head

Clous cannelés à tête ronde

iTeh STANDARD PREVIEW
(standards.iteh.ai)

[SIST EN ISO 8746:2001](https://standards.iteh.ai/catalog/standards/sist/8f2bb472-9a00-4071-a9e9-6e1615ea6876/sist-en-iso-8746-2001)

<https://standards.iteh.ai/catalog/standards/sist/8f2bb472-9a00-4071-a9e9-6e1615ea6876/sist-en-iso-8746-2001>



Reference number
ISO 8746:1997(E)

ISO 8746:1997(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 8746 was prepared by Technical Committee ISO/TC 2, *Fasteners*.

This second edition cancels and replaces the first edition (ISO 8746:1986), which has been technically revised.

STANDARD PREVIEW
(standards.iteh.ai)
SIST EN ISO 8746:2001
<https://standards.iteh.ai/catalog/standards/sist/8f2bb472-9a00-4071-a9e9-6e1615ea6876/sist-en-iso-8746-2001>

© ISO 1997

All rights reserved. Unless otherwise specified, no part of this publication may be reproduced or utilized in any form or by any means, electronic or mechanical, including photocopying and microfilm, without permission in writing from the publisher.

International Organization for Standardization
 Case postale 56 • CH-1211 Genève 20 • Switzerland
 Internet central@iso.ch
 X.400 c=ch; a=400net; p=iso; o=isocs; s=central

Printed in Switzerland

Grooved pins with round head

1 Scope

This International Standard specifies the characteristics of round head grooved pins which have three equally spaced grooves impressed longitudinally on their exterior surface, with nominal diameter, d_1 , from 1,4 mm 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 non-positive locking fit when these grooved pins are forced into a drilled hole equal to the nominal diameter d_1 (see clause 4).

iTeh STANDARD PREVIEW (standards.iteh.ai)

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

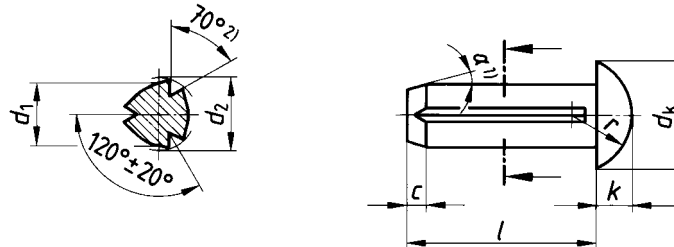
ISO 9717:1990, *Phosphate conversion coatings for metals – Method of specifying requirements*.

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

3 Dimensions

See figure 1 and table 1.

NOTE — Types A and B are left to the discretion of the supplier, or specifically ordered by the customer.



- 1) $\alpha = 15^\circ$ to 30°
- 2) The grooving angle 70° applies only to grooved pins made from steel as shown in clause 5. The grooving angle may be modified depending on resilience of material.

Type A: Pin with chamfered end

iTeh STANDARD PREVIEW
(standards.iteh.ai)

<https://standards.iteh.ai/catalog/standards/sist/8f2bb472-9a00-4071-a9e9-6e1615ca6876/sist-en-iso-8746-2001>



NOTE — For other dimensions, see type A.

Type B: Pin with pilot end

Figure 1

Table 1 — Dimensions

Dimensions in millimetres

	nom.	1,4	1,6	2	2,5	3	4	5	6	8	10	12	16	20
d_1	max.	1,40	1,60	2,00	2,500	3,000	4,0	5,0	6,0	8,00	10,00	12,0	16,0	20,0
	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	16,0	19,0	25,0	32,0
	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	10,0	13,0
r	\approx	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
$l^{1)}$		Expanded diameter, $d_2^{2), 3)}$												
nom.	min.	max.	+0,05 0			$\pm 0,05$						$\pm 0,1$		
3	2,8	3,2	1,5	1,7	2,15	2,7	3,2	4,25	5,25	6,3	8,3	10,35	12,35	16,4
4	3,7	4,3												
5	4,7	5,3												
6	5,7	6,3	1,5	1,7	2,15	2,7	3,2	4,25	5,25	6,3	8,3	10,35	12,35	16,4
8	7,7	8,3												
10	9,7	10,3												
12	11,6	12,4	1,5	1,7	2,15	2,7	3,2	4,25	5,25	6,3	8,3	10,35	12,35	16,4
16	15,6	16,4												
20	19,5	20,5												
25	24,5	25,5	1,5	1,7	2,15	2,7	3,2	4,25	5,25	6,3	8,3	10,35	12,35	16,4
30	29,5	30,5												
35	34,5	35,5												
40	39,5	40,5	1,5	1,7	2,15	2,7	3,2	4,25	5,25	6,3	8,3	10,35	12,35	16,4

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

2) The expanded diameter d_2 applies only to pins made from 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.

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

4 Application

The diameter of the hole into which the grooved pin is to be inserted shall be equal to the nominal diameter, d_1 , of the mating pin and to tolerance class H11.