



**International
Standard**

ISO 13672

**Fasteners — Parallel grooved pins
— Half-length diamond grooves**

*Fixations — Goupilles cannelées constantes — Cannelures
diamant sur la moitié de la longueur*

**First edition
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Foreword

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The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO document should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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This document was prepared by Technical Committee ISO/TC 2, *Fasteners*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 185 *Fasteners*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

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Fasteners — Parallel grooved pins — Half-length diamond grooves

1 Scope

This document specifies the characteristics of parallel grooved pins with half-length diamond grooves (with closed ends), in steel and stainless steel, and with nominal diameters 1 mm to 25 mm.

These grooved pins are designed to fulfil the main following functions:

- positioning or guiding, and
- relative rotation of the assembled parts,

with a more significant insertion force (due to its shape) and a high level of pull-out resistance (due to the elastic fit behaviour of the pin).

The general requirements (including functional principles for grooved pins and assembly) are specified in ISO 13669.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 1891-4, *Fasteners — Vocabulary — Part 4: Control, inspection, delivery, acceptance and quality*

ISO 3269, *Fasteners — Acceptance inspection* [ISO 13672:2025](https://standards.iteh.ai/catalog/standards/iso/691645e1-1729-409e-8303-f7169d933cda/iso-13672-2025)

ISO 3506-6, *Fasteners — Mechanical properties of corrosion-resistant stainless steel fasteners — Part 6: General rules for the selection of stainless steels and nickel alloys for fasteners*

ISO 4042, *Fasteners — Electroplated coating systems*

ISO 9717, *Metallic and other inorganic coatings — Phosphate conversion coating of metals*

ISO 10683, *Fasteners — Non-electrolytically applied zinc flake coating systems*

ISO 13669, *Fasteners — Grooved pins — General requirements*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 13669 apply.

ISO and IEC maintain terminology databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <https://www.electropedia.org/>

4 Principles of grooved pins and assembly

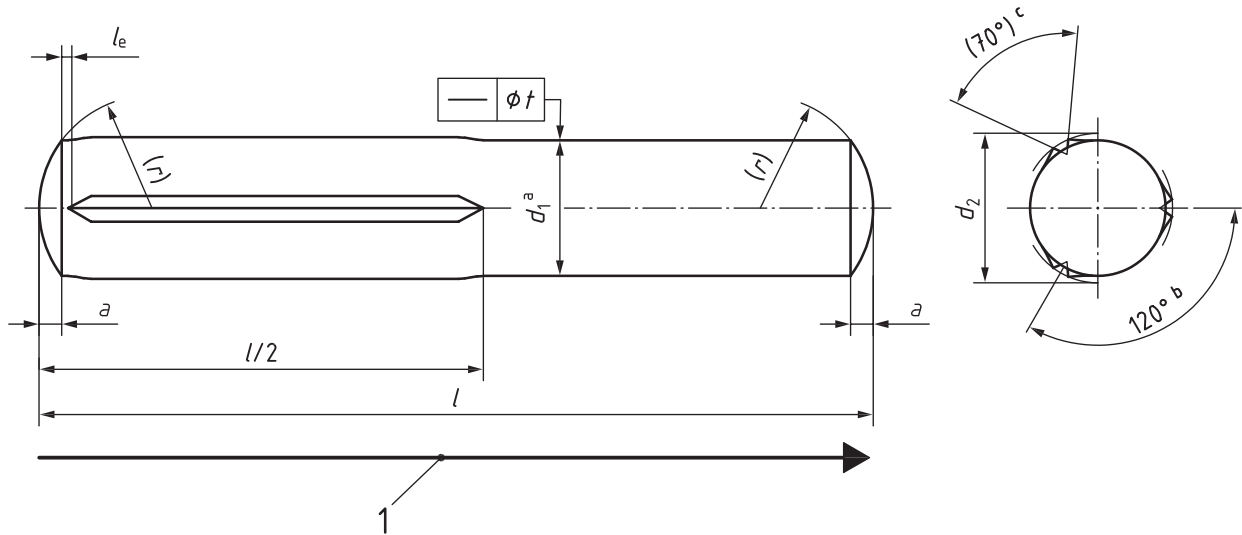
The principles of grooved pins and assembly specified in ISO 13669 shall apply.

5 Dimensions

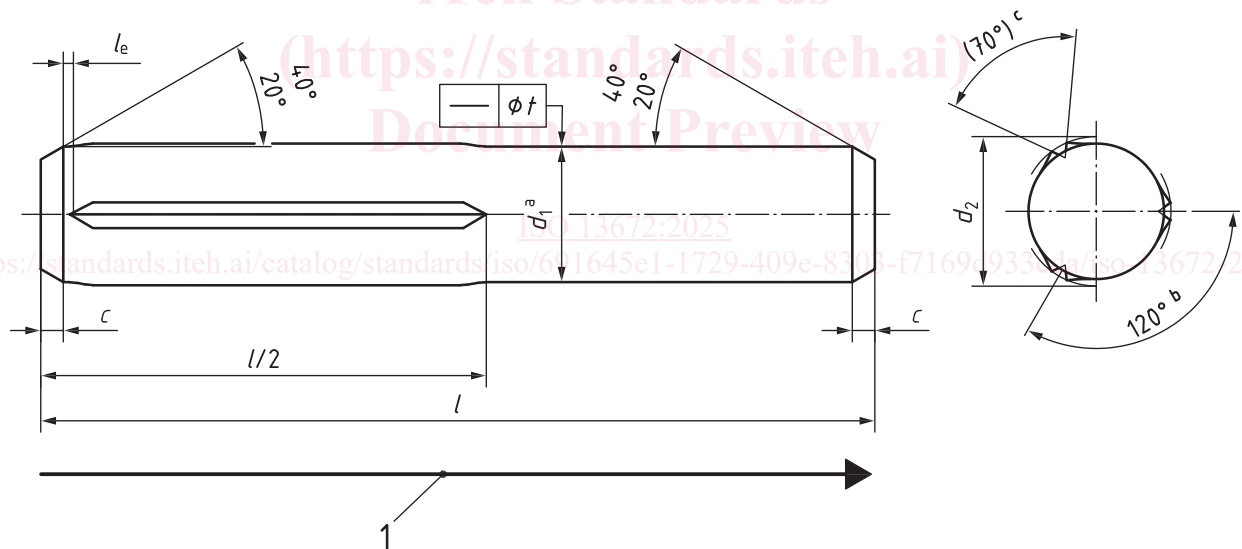
Dimensions shall be in accordance with [Figure 1](#) and with [Tables 1](#) and [2](#). The control of the expanded diameter d_2 and pin straightness t shall be as specified in ISO 13669.

For coated pins, dimensions and tolerances shall apply prior to coating.

Unless otherwise agreed at the time of the order, the pins are manufactured with rounded ends.



a) With pin rounded ends (RN)



b) With pin chamfered ends (CH)

Key

- 1 insertion side
- a The pin diameter d_1 is only applicable in areas where grooves are not present.
- b The angle of 120° between two grooves applies with a tolerance of $\pm 20^\circ$ (for the three grooves).
- c The groove angle of 70° (for the three grooves) is a reference dimension, see ISO 13669.

Figure 1 — Grooved pin with half-length diamond grooves