

---

---

**Grooved pins — Full-length parallel  
grooved, with chamfer**

*Goupilles cannelées à cannelures constantes sur toute la longueur  
débochantes, à chanfrein*



## 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 8740 was prepared by Technical Committee ISO/TC 2, *Fasteners*.

This second edition cancels and replaces the first edition (ISO 8740:1986), which has been technically revised.

© 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 — Full-length parallel grooved, with chamfer

## 1 Scope

This International Standard specifies the characteristics of full-length parallel grooved pins made of steel or austenitic stainless steel with chamfer which have three equally spaced grooves impressed longitudinally on their exterior surface and a pilot to facilitate insertion, with nominal diameter,  $d_1$ , from 1,5 mm to 25 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).

## 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*.

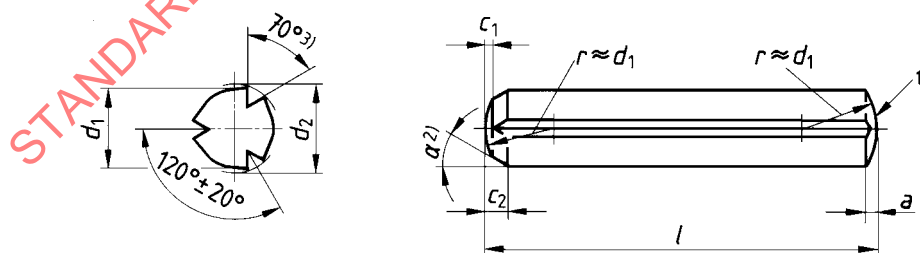
ISO 4042:–<sup>1)</sup>, *Fasteners – Electroplated coatings*.

ISO 8749:1986, *Pins and grooved pins – Shear test*.

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

## 3 Dimensions

See figure 1 and table 1.



1) Chamfer permissible

2)  $\alpha = 15^\circ$  to  $30^\circ$

3) 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.

Figure 1

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

Table 1 — Dimensions

Dimensions in millimetres

| $d_1$                                              |       |        | nom.                               | 1,5  | 2     | 2,5  | 3   | 4    | 5    | 6    | 8    | 10   | 12    | 16  | 20  | 25  |
|----------------------------------------------------|-------|--------|------------------------------------|------|-------|------|-----|------|------|------|------|------|-------|-----|-----|-----|
|                                                    |       |        | tol.                               | h9   |       |      |     | h11  |      |      |      |      |       |     |     |     |
| $c_1$                                              |       |        | ≈                                  | 0,12 | 0,18  | 0,25 | 0,3 | 0,4  | 0,5  | 0,6  | 0,8  | 1    | 1,2   | 1,6 | 2   | 2,5 |
| $c_2$                                              |       |        |                                    | 0,6  | 0,8   | 1    | 1,2 | 1,4  | 1,7  | 2,1  | 2,6  | 3    | 3,8   | 4,6 | 6   | 7,5 |
| $a$                                                |       |        | ≈                                  | 0,2  | 0,25  | 0,3  | 0,4 | 0,5  | 0,63 | 0,8  | 1    | 1,2  | 1,6   | 2   | 2,5 | 3   |
| Minimum shear strength, double <sup>1)</sup><br>kN |       |        |                                    | 1,6  | 2,84  | 4,4  | 6,4 | 11,3 | 17,6 | 25,4 | 45,2 | 70,4 | 101,8 | 181 | 283 | 444 |
| $l^{(2)}$                                          |       |        | Expanded diameter, $d_2^{(3), 4)}$ |      |       |      |     |      |      |      |      |      |       |     |     |     |
| nom.                                               | min.  | max.   | +0,05<br>0                         |      | ±0,05 |      |     |      |      |      | ±0,1 |      |       |     |     |     |
| 8                                                  | 7,75  | 8,25   | 1,6                                |      |       |      |     |      |      |      |      |      |       |     |     |     |
| 10                                                 | 9,75  | 10,25  |                                    |      |       |      |     |      |      |      |      |      |       |     |     |     |
| 12                                                 | 11,5  | 12,5   |                                    |      |       |      |     |      |      |      |      |      |       |     |     |     |
| 14                                                 | 13,5  | 14,5   |                                    |      |       |      |     |      |      |      |      |      |       |     |     |     |
| 16                                                 | 15,5  | 16,5   | 2,15                               |      |       |      |     |      |      |      |      |      |       |     |     |     |
| 18                                                 | 17,5  | 18,5   |                                    |      |       |      |     |      |      |      |      |      |       |     |     |     |
| 20                                                 | 19,5  | 20,5   |                                    |      |       |      |     |      |      |      |      |      |       |     |     |     |
| 22                                                 | 21,5  | 22,5   |                                    |      |       |      |     |      |      |      |      |      |       |     |     |     |
| 24                                                 | 23,5  | 24,5   | 2,65                               |      |       |      |     |      |      |      |      |      |       |     |     |     |
| 26                                                 | 25,5  | 26,5   |                                    |      |       |      |     |      |      |      |      |      |       |     |     |     |
| 28                                                 | 27,5  | 28,5   |                                    |      |       |      |     |      |      |      |      |      |       |     |     |     |
| 30                                                 | 29,5  | 30,5   |                                    |      |       |      |     |      |      |      |      |      |       |     |     |     |
| 32                                                 | 31,5  | 32,5   | 3,2                                |      |       |      |     |      |      |      |      |      |       |     |     |     |
| 35                                                 | 34,5  | 35,5   |                                    |      |       |      |     |      |      |      |      |      |       |     |     |     |
| 40                                                 | 39,5  | 40,5   |                                    |      |       |      |     |      |      |      |      |      |       |     |     |     |
| 45                                                 | 44,5  | 45,5   |                                    |      |       |      |     |      |      |      |      |      |       |     |     |     |
| 50                                                 | 49,5  | 50,5   | 4,25                               |      |       |      |     |      |      |      |      |      |       |     |     |     |
| 55                                                 | 54,25 | 55,75  |                                    |      |       |      |     |      |      |      |      |      |       |     |     |     |
| 60                                                 | 59,25 | 60,75  |                                    |      |       |      |     |      |      |      |      |      |       |     |     |     |
| 65                                                 | 64,25 | 65,75  |                                    |      |       |      |     |      |      |      |      |      |       |     |     |     |
| 70                                                 | 69,25 | 70,75  | 5,25                               |      |       |      |     |      |      |      |      |      |       |     |     |     |
| 75                                                 | 74,25 | 75,75  |                                    |      |       |      |     |      |      |      |      |      |       |     |     |     |
| 80                                                 | 79,25 | 80,75  |                                    |      |       |      |     |      |      |      |      |      |       |     |     |     |
| 85                                                 | 84,25 | 85,75  |                                    |      |       |      |     |      |      |      |      |      |       |     |     |     |
| 90                                                 | 89,25 | 90,75  | 6,3                                |      |       |      |     |      |      |      |      |      |       |     |     |     |
| 95                                                 | 94,25 | 95,75  |                                    |      |       |      |     |      |      |      |      |      |       |     |     |     |
| 100                                                | 99,25 | 100,75 |                                    |      |       |      |     |      |      |      |      |      |       |     |     |     |
|                                                    |       |        |                                    |      |       |      |     |      |      |      |      |      |       |     |     |     |

1) Applies only to grooved pins made from steel as shown in clause 5.

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

3) The expanded diameter,  $d_2$ , applies only to pins made from steel as shown in clause 5. 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.