

STN	Spojovacie súčiastky Ryhované kolíky so zapustenou hlavou s diamantovým ryhovaním na celej dĺžke (ISO 8747: 2025)	STN EN ISO 8747 02 2191
------------	--	---

Fasteners - Grooved pins with countersunk head - Full-length diamond grooves (ISO 8747:2025)

Táto norma obsahuje anglickú verziu európskej normy.
This standard includes the English version of the European Standard.

Táto norma bola oznámená vo Vestníku ÚNMS SR č. 05/25

Obsahuje: EN ISO 8747:2025, ISO 8747:2025

Oznámením tejto normy sa ruší
STN EN ISO 8747 (02 2191) z decembra 2000

140523

EUROPEAN STANDARD

EN ISO 8747

NORME EUROPÉENNE

EUROPÄISCHE NORM

March 2025

ICS 21.060.50

Supersedes EN ISO 8747:1997

English Version

Fasteners - Grooved pins with countersunk head - Full-length diamond grooves (ISO 8747:2025)Fixations - Clous cannelés à tête fraisée - Cannelures
diamant sur toute la longueur (ISO 8747:2025)Verbindungselemente - Senkernnägel - Durchgehende
Rautekerben (ISO 8747:2025)

This European Standard was approved by CEN on 2 March 2025.

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 CEN-CENELEC Management Centre 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 CEN-CENELEC Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Türkiye and United Kingdom.

EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG**CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels**

EN ISO 8747:2025 (E)

Contents	Page
European foreword.....	3

European foreword

This document (EN ISO 8747:2025) has been prepared by Technical Committee ISO/TC 2 "Fasteners" in collaboration with Technical Committee CEN/TC 185 "Fasteners" the secretariat of which is held by BSI.

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 September 2025, and conflicting national standards shall be withdrawn at the latest by September 2025.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN ISO 8747:1997.

Any feedback and questions on this document should be directed to the users' national standards body/national committee. A complete listing of these bodies can be found on the CEN website.

According to the CEN-CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Türkiye and the United Kingdom.

Endorsement notice

The text of ISO 8747:2025 has been approved by CEN as EN ISO 8747:2025 without any modification.



International Standard

ISO 8747

Fasteners — Grooved pins with countersunk head — Full-length diamond grooves

*Fixations — Clous cannelés à tête fraisée — Cannelures diamant
sur toute la longueur*

**Third edition
2025-02**

ISO 8747:2025(en)**COPYRIGHT PROTECTED DOCUMENT**

© ISO 2025

All rights reserved. Unless otherwise specified, or required in the context of its implementation, no part of this publication may be reproduced or utilized otherwise in any form or by any means, electronic or mechanical, including photocopying, or posting on the internet or an intranet, without prior written permission. Permission can be requested from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office
CP 401 • Ch. de Blandonnet 8
CH-1214 Vernier, Geneva
Phone: +41 22 749 01 11
Email: copyright@iso.org
Website: www.iso.org

Published in Switzerland

ISO 8747:2025(en)**Contents**

Page

Foreword	iv
1 Scope	1
2 Normative references	1
3 Terms and definitions	1
4 Principles of grooved pins and assembly	1
5 Dimensions	2
6 Requirements and reference International Standards	5
7 Labelling on package	5
8 Designation	6
Bibliography	7

ISO 8747:2025(en)**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.

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).

ISO draws attention to the possibility that the implementation of this document may involve the use of (a) patent(s). ISO takes no position concerning the evidence, validity or applicability of any claimed patent rights in respect thereof. As of the date of publication of this document, ISO had not received notice of (a) patent(s) which may be required to implement this document. However, implementers are cautioned that this may not represent the latest information, which may be obtained from the patent database available at www.iso.org/patents. ISO shall not be held responsible for identifying any or all such patent rights.

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see www.iso.org/iso/foreword.html.

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).

This third edition cancels and replaces the second edition (ISO 8747:1997) which has been technically revised.

The main changes are as follows:

- terms and definitions, principles for grooved pins and assembly (including hole dimensions), control of the expanded diameter d_2 and pin straightness, mechanical and physical properties (including shear resistance and hardness) and inspection which are common for all grooved pins (product standards ISO 8739 to ISO 8747, ISO 13670 and ISO 13672) have been specified in the new reference standard ISO 13669 dealing with general requirements;
- nominal sizes 1,4 mm and 1,6 mm have been deleted;
- the symbols for the pilot point (PL instead of B) and optional chamfer point (CH instead of A) have been amended analogously to ISO 4753; the length of the points has been specified as a minimum value;
- the head diameters d_k have been recalculated and rounded to the nearest 0,05 mm for pins with nominal sizes up to 8 mm; $d_{k,max}$ has been recalculated for pins with nominal sizes 16 mm and 20 mm;
- the head height k has been added as a reference dimension;
- the maximum distance between the underhead bearing surface and the beginning of the grooves l_k has been added;
- stainless steel grades A2, A4, C1 and F1 have been added;
- other materials (such as hardened steels, brass, aluminium) are by agreement (see [Table 3](#));
- specifications for labelling have been added as [Clause 8](#).

ISO 8747:2025(en)

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.

Fasteners — Grooved pins with countersunk head — Full-length diamond grooves

1 Scope

This document specifies the characteristics of grooved pins with countersunk head and full-length diamond grooves and pilot or chamfer point, in steel and stainless steel, and with nominal diameter 2 mm to 20 mm.

These grooved pins are designed to fulfil the main following function: locking together two or more parts, with the easiest installation (due to the pilot or chamfer point) and a highest 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 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*

koniec náhľadu – text ďalej pokračuje v platenej verzii STN