

<b>STN</b>	<b>Spojovacie súčiastky Ryhované kolíky s polgul'ovou hlavou s diamantovým ryhovaním na celej dĺžke (ISO 8746: 2025)</b>	<b>STN EN ISO 8746</b>  02 2190
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Fasteners - Grooved pins with round head - Full-length diamond grooves (ISO 8746:2025)

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

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Supersedes EN ISO 8746:1997

English Version

**Fasteners - Grooved pins with round head - Full-length  
diamond grooves (ISO 8746:2025)**Fixations - Clous cannelés à tête ronde - Cannelures  
diamant sur toute la longueur (ISO 8746:2025)Verbindungselemente - Halbrundkerbnägel (ISO  
8746:2025)

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**EN ISO 8746:2025 (E)**

<b>Contents</b>	<b>Page</b>
<b>European foreword.....</b>	<b>3</b>

## **European foreword**

This document (EN ISO 8746:2025) 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of an identical text or by endorsement, at the latest by September 2025, and conflicting national standards shall be withdrawn at the latest by September 2025.

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## **Endorsement notice**

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# International Standard

**ISO 8746**

## **Fasteners — Grooved pins with round head — Full-length diamond grooves**

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

**Third edition  
2025-02**

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**ISO 8746:2025(en)****Contents**

Page

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

**ISO 8746:2025(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](http://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).

This third edition cancels and replaces the second edition (ISO 8746:1997) 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 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](#).

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](http://www.iso.org/members.html).

# Fasteners — Grooved pins with round head — Full-length diamond grooves

## 1 Scope

This document specifies the characteristics of grooved pins with round head, full-length diamond grooves and pilot point or chamfered 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**