

<b>STN</b>	<b>Spojovacie súčiastky Ryhované kolíky s kuželovým progresívnym ryhovaním na polovičnej dĺžke (ISO 8745: 2025)</b>	<b>STN EN ISO 8745</b>  02 2171
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Fasteners - Taper grooved pins - Half-length progressive grooves (ISO 8745:2025)

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 8745:1997

English Version

**Fasteners - Taper grooved pins - Half-length progressive grooves (ISO 8745:2025)**

Fixations - Goupilles cannelées progressives -  
Cannelures progressives sur la moitié de la longueur  
(ISO 8745:2025)

Verbindungselemente - Passkerbstifte (ISO  
8745:2025)

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**EN ISO 8745:2025 (E)**

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## **European foreword**

This document (EN ISO 8745:2025) 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of an identical text or by endorsement, at the latest by September 2025, and conflicting national standards shall be withdrawn at the latest by September 2025.

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The text of ISO 8745:2025 has been approved by CEN as EN ISO 8745:2025 without any modification.



# International Standard

**ISO 8745**

## **Fasteners — Taper grooved pins — Half-length progressive grooves**

*Fixations — Goupilles cannelées progressives — Cannelures  
progressives sur la moitié de la longueur*

**Third edition  
2025-02**

## ISO 8745:2025(en)



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**ISO 8745:2025(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 8745:1997) 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;
- non-preferred diameters 1 mm, 3,5 mm, 7 mm, 9 mm, 14 mm and 18 mm have been added;
- values of expanded diameter  $d_2$  for steel pins have been slightly increased for the shortest length range, and have been added for stainless steel pins;
- tolerances for the rounded end and values for the chamfered end have been added;
- tolerances for the length of the grooves have 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 — Taper grooved pins — Half-length progressive grooves

## 1 Scope

This document specifies the characteristics of taper grooved pins with half-length progressive grooves (with close-end at the insertion side), in steel and stainless steel, and with nominal diameter 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 an easy installation (due to its shape) and a medium 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**