

STN	Spojovacie súčiastky Ryhované paralelné kolíky so zrazeným koncom s diamantovým ryhovaním na celej dĺžke (ISO 8740: 2025)	STN EN ISO 8740 02 2173
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Fasteners - Parallel grooved pins, with chamfer point - Full-length diamond grooves (ISO 8740:2025)

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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EUROPEAN STANDARD

EN ISO 8740

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EUROPÄISCHE NORM

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Supersedes EN ISO 8740:1997

English Version

**Fasteners - Parallel grooved pins, with chamfer point -
Full-length diamond grooves (ISO 8740:2025)**

Fixations - Goupilles cannelées constantes, à bout
chanfreiné - Cannelures diamant sur toute la longueur
(ISO 8740:2025)

Verbindungselemente - Zylinderkerbstifte mit Fase -
Durchgehende Rautekerben (ISO 8740:2025)

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EUROPEAN COMMITTEE FOR STANDARDIZATION
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EUROPÄISCHES KOMITEE FÜR NORMUNG

CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

EN ISO 8740:2025 (E)

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European foreword

This document (EN ISO 8740:2025) 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of an identical text or by endorsement, at the latest by September 2025, and conflicting national standards shall be withdrawn at the latest by September 2025.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

The text of ISO 8740:2025 has been approved by CEN as EN ISO 8740:2025 without any modification.



International Standard

ISO 8740

Fasteners — Parallel grooved pins, with chamfer point — Full-length diamond grooves

*Fixations — Goupilles cannelées constantes, à bout chanfreiné —
Cannelures diamant sur toute la longueur*

**Third edition
2025-02**

ISO 8740:2025(en)



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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

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ISO 8740:2025(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).

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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 8740:1997) 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 have been added, and chamfer end option has been deleted;
- 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.

Fasteners — Parallel grooved pins, with chamfer point — Full-length diamond grooves

1 Scope

This document specifies the characteristics of parallel grooved pins with chamfer point and full-length diamond grooves (with open ends), in steel and stainless steel, and with nominal diameter 1 mm to 25 mm.

These grooved pins are designed to fulfil the main following function: locking together two or more parts, with an easy installation (due to the 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*

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