

STN	Spojovacie súčiastky Ryhované paralelné kolíky s vodiacim koncom s diamantovým ryhovaním na celej dĺžke (ISO 8739: 2025)	STN EN ISO 8739 02 2172
------------	---	---

Fasteners - Parallel grooved pins, with pilot point - Full-length diamond grooves (ISO 8739:2025)

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. 01/26

Obsahuje: EN ISO 8739:2025, ISO 8739:2025

Oznámením tejto normy sa ruší
STN EN ISO 8739 (02 2172) z decembra 2000

141661

Úrad pre normalizáciu, metrológiu a skúšobníctvo Slovenskej republiky, 2026
Slovenská technická norma a technická normalizačná informácia je chránená zákonom č. 60/2018 Z. z. o technickej normalizácii
v znení neskorších predpisov.

EUROPEAN STANDARD

EN ISO 8739

NORME EUROPÉENNE

EUROPÄISCHE NORM

October 2025

ICS 21.060.50

Supersedes EN ISO 8739:1997

English Version

Fasteners - Parallel grooved pins, with pilot point - Full-length diamond grooves (ISO 8739:2025)

Fixations - Goupilles cannelées constantes, à bout pilote - Cannelures diamant sur toute la longueur (ISO 8739:2025)

Verbindungselemente - Zylinderkerbstifte mit Einführende - Durchgehende Rautenuten (ISO 8739:2025)

This European Standard was approved by CEN on 2 June 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 8739:2025 (E)

Contents	Page
European foreword.....	3

European foreword

This document (EN ISO 8739:2025) 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 April 2026, and conflicting national standards shall be withdrawn at the latest by April 2026.

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 8739:1997.

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 8739:2025 has been approved by CEN as EN ISO 8739:2025 without any modification.



International Standard

ISO 8739

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

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

**Third edition
2025-10**

ISO 8739:2025(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 8739:2025(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 8739:2025(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 8739:1997) 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, 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;
- 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 7](#).

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 pilot point — Full-length diamond grooves

1 Scope

This document specifies the characteristics of parallel grooved pins with pilot point and full-length diamond grooves (with closed-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 function: locking together two or more parts, with the easiest installation (due to the pilot 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