

Grooved Pins:

Solid pins with three swaged grooves at 120° pitch along all / part of the length

Overview Of Grooved Pins

Technifast supply grooved pins with parallel or tapered grooves, to DIN and ISO standards in mild steel or stainless steel A2.

Grooved pins are solid pins with three swaged grooves at 120° pitch along all or part of their length. When the pin is driven into a drilled hole of suitable diameter, the material displaced by the grooving process is forced back, to partially close up the grooves and lock the pin into place.

Advantages Of Grooved Pins

- They do not need a precision reamed hole.
- They can have parallel grooves or tapered grooves. Parallel grooves give the pin high resistance to vibration, but need more force to insert.
- They can be grooved on only part of the length, so that where the pin has to be firmly fixed in one part of an assembly, but be a clearance fit on the other, both parts can be drilled to the same diameter.

Grooved Pin Standards

Standard	Description
DIN 1471	Full Length Taper Grooves
DIN 1472	Half Length Taper Grooves
DIN 1473	Full Length Parallel Grooves
DIN 1474	Half Length Reverse Taper Grooves
DIN 1475	Third Length Centre Grooves
BS 7047	Equivalent To DIN 1474
BS 7049	Equivalent To DIN 1475 But With Half Length Centre Grooves
BS 7050	Equivalent to DIN 1471
BS 7053	Headed Grooved Pin
DIN 1469	Similar To DIN 1474 With Parallel Grooves & Circlip Slot
DIN 1470	Similar To DIN 1473 But With Reduced Diameter At One End
DIN 1476	Headed Grooved Pin (Round Head)
DIN 1477	Headed Grooved Pin (Countersunk Head)
GP5	Equivalent To DIN 1475 But With Half Length Centre Grooves
ISO 8739	Similar to DIN 1473 But With Reduced Diameter At One End
ISO 8743	Similar To DIN 1475 But With Half Length Centre Grooves
ISO 8746	Headed Grooved Pin (Round Head)
ISO 8747	Headed Grooved Pin (Countersunk Head)



Materials:

- Mild steel
- Stainless Steel A2 (WS 1.4305)

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TECHNIFAST

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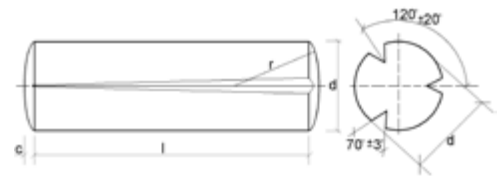
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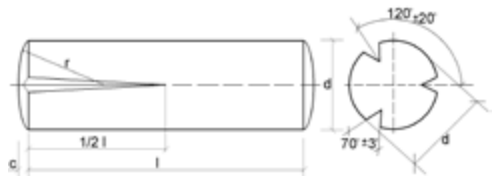
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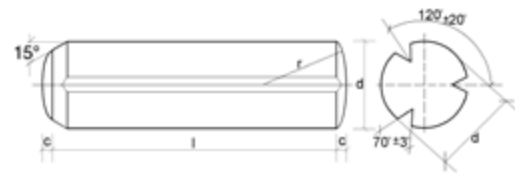
Nominal Diameter	1*	1.2*	1.5	2	2.5	3	4	5	6	8	10	12
Dimension C**	0.14	0.16	0.2	0.25	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.6
Diameter Over Grooves	1.05	1.25	1.60	2.15	2.65	3.20	4.25	5.25	6.30	8.30	10.35	12.35
Tolerance On Groove Dia	+ 0.05, -0			± 0.05					± 0.1			
Hole Size Max	1.025	1.225	1.525	2.025	2.525	3.025	4.075	5.075	6.075	8.090	10.09	12.11
Hole Size Min	1.000	1.200	1.500	2.000	2.500	3.000	4.000	5.000	6.000	8.000	10.00	12.00
Double Shear Strengths - Tested To ISO 8749, kN												
	0.7	1.0	1.6	2.85	4.25	6.15	10.6	16.5	22.8	40.5	63.2	91.0
Lengths In mm												
4mm												
5mm												
6mm												
8mm												
10mm												
12mm												
14mm												
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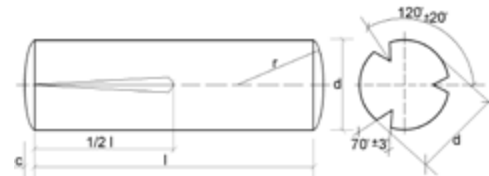
DIN 1471 / GP1 / Similar To ISO 8744



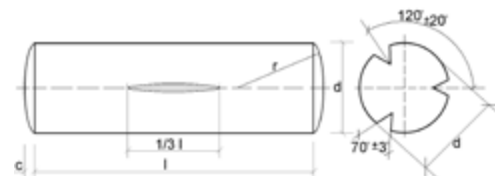
DIN 1472 / GP2 / Similar To ISO 8745



DIN 1473 / GP3 / Similar To ISO 8740



DIN 1474 / GP4 / Similar To ISO 8741



DIN 1475 / GP5 / Similar To ISO 8742



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Please Note: The groove diameter must be measured using ring gauges. The groove diameter figures are valid for steel only. Stainless grooved pins have a slightly smaller diameter over the grooves.

Length tolerances to js 15.
*Only available in DIN 1473