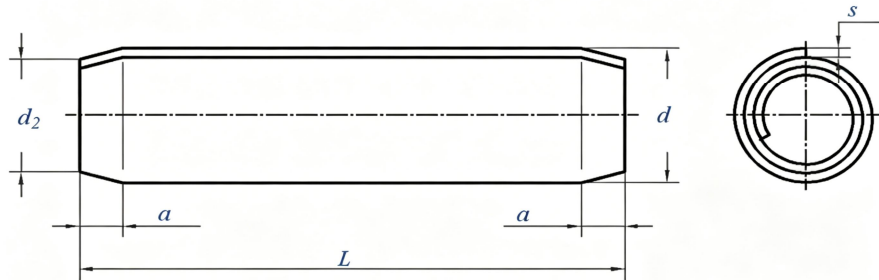


DIN EN ISO 8748-2007
弹性圆柱销 卷制 重型
Spring-type straight pins - Coiled, heavy duty

Amendant record:
DIN 7344:1969-04
DIN EN ISO 8748:1991-04
DIN EN 28748:1992-10
DIN EN 8748:1998-03



Both ends need to be chamfered by pressing.

Table 1 — Dimensions

nominal diameter d		$\phi 1.5$	$\phi 2$	$\phi 2.5$	$\phi 3$	$\phi 3.5$	$\phi 4$	$\phi 5$	$\phi 6$	$\phi 8$	$\phi 10$	$\phi 12$	$\phi 14$	$\phi 16$	$\phi 20$
d	Max (before mounting)	1.71	2.21	2.73	3.25	3.79	4.3	5.35	6.4	8.55	10.65	12.75	14.85	16.9	21
	min (before mounting)	1.61	2.11	2.62	3.12	3.64	4.15	5.15	6.18	8.25	10.3	12.35	14.4	16.4	20.4
d_2	Max (before mounting)	1.4	1.9	2.4	2.9	3.4	3.9	4.85	5.85	7.8	9.75	11.7	13.6	15.6	19.6
a	$\approx$	0.5	0.7	0.7	0.9	1	1.1	1.3	1.5	2	2.5	3	3.5	4	4.5
s		0.17	0.22	0.28	0.33	0.39	0.45	0.56	0.67	0.9	1.1	1.3	1.6	1.8	2.2
Minum sheear strength, double, kN ①	1)	1.9	3.5	5.5	7.6	10	13.5	20	30	53	84	120	165	210	340
	2)	1.45	2.5	3.8	5.7	7.6	10	15.5	23	41	64	91	—	—	—

①, 1) Applies to steel and martensitic corrosion resistant steel products.
2) Applies to austenitic stainless steel products.
● length tolerance $L \leq 10 = \pm 0.25$ $10 < L \leq 50 = \pm 0.5$ $50 < L \leq 200 = \pm 0.75$
Length options are detailed in ISO8748. Customized non-standard products

Table 2 — Requirements and reference International Standards

Material ②	steel	Austenitic stainless steel	Martensitic stainless steel
	St (Selected by the manufacturer)	A	C
	Chemical composition limits (check analysis)%		
	All pin diameters	Alternative for pin diameters $d_1 > 12\text{mm}$	
	C ≥ 0.64 Mn ≥ 0.6 Si ≥ 1.50 Cr ③ P ≤ 0.04 S ≤ 0.05	C ≥ 0.38 Mn ≥ 0.70 Si ≥ 0.2 Cr ≥ 0.80 V ≥ 0.15 P ≤ 0.035 S ≤ 0.04	C ≤ 0.15 Mn ≤ 2.00 Si ≤ 1.50 Cr: 16~20 Ni: 6~12 P ≤ 0.045 S ≤ 0.03 Mo ≤ 0.8 Cold worked
	Hardened and tempered to a Vickers hardness of: 420 HV to 545 HV		C ≥ 0.15 Mn ≤ 1.00 Si ≤ 1.00 Cr: 11.5~14 Ni ≤ 1.00 P ≤ 0.04 S ≤ 0.03 Hardened and tempered to a Vickers hardness of: 460HV~560HV
Surface condition	Plain, i.e. pins to be supplied in natural finish, treated with a protective lubricant, unless otherwise specified by agreement between customer and supplier. If pins are surface coated appropriate plating or coating processes should be employed to avoid hydrogen embrittlement. When pins are electroplated or phosphate-coated, they shall be suitably treated immediately after plating or coating to obviate detrimental hydrogen embrittlement although freedom from hydrogen embrittlement is not absolutely guaranteed (see ISO 4042). All tolerances shall apply prior to the application of a plating or coating.		Plain, i.e. pins to be supplied in natural finish.
Application	The diameter of the hole into which the spring pin is to be inserted shall be equal to the nominal diameter d , of the mating pin and to tolerance class H12.		
Shear strength test	The test shall be in accordance with ISO 8749		

② Other materials as agreed between customer and supplier;
③ Use of Cr is optional.