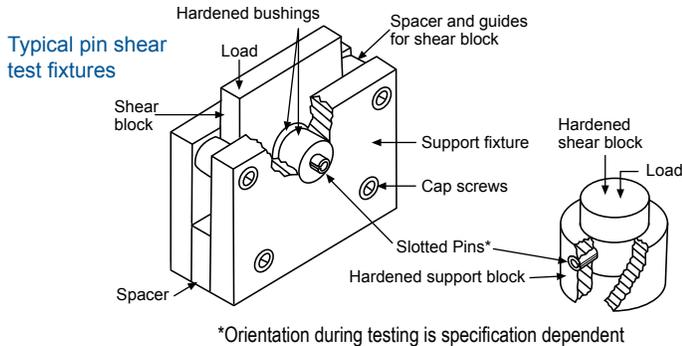


Shear Strength

The shear test procedure is set forth in ISO 8749, ASME B18.8.2, ASME B18.8.4M, SAE J496, and NASM 10971, which are nearly identical in substance.



Shear values specified will only be obtained under the conditions noted in the referenced standards. Of special note:

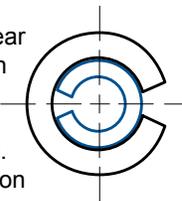
- The clearance at the shear plane cannot exceed 0.15mm or .005”.
- The hole has to be the nominal pin diameter (tolerance H6) with a hardness of not less than HV 700.
- The shear planes have to be at least one pin diameter from each end, and at least two diameters apart.
- ISO 8752 pins are shear tested with the slot up, aligned with the shear load.
- ASME B18.8.2, ASME B18.8.4M, NASM 10971, and SAE J496 pins are shear tested with the slot rotated 90° to the shear load.

Recommended Pin/Shaft Ratio

The recommended maximum ratio is 1 to 3; that is the pin diameter should never exceed 33.3% of the shaft diameter. If this limit is exceeded, the remaining material in the shaft is inadequate and the shaft will fail before the pin.

Double Pinning

In situations requiring exceptionally high shear strength, it is possible to use pins in combination by driving an inner pin into an already inserted outer pin. The gaps should be 180° opposed. The recommended hole needs to be increased. It is suggested you consult **SPIROL** Application Engineers in these situations.



Which Stainless?

Martensitic chrome stainless steel is hardened and has strength comparable to high carbon steel. It also withstands most common atmospheric and environmental conditions in the presence of free oxygen. Austenitic nickel stainless steel provides the best corrosion protection against normal environmental conditions in both oxygenating and non-oxygenating atmospheres. However, this material is not heat treated and therefore it is not as strong and does not have the fatigue resistance of chrome stainless steel. Austenitic stainless steel Slotted Pins are not recommended for dynamic applications as they will work harden under shock and vibration, and should never be installed into hardened holes.

Why Mechanical vs. Electroplated Zinc?

Slotted Spring Pins are particularly susceptible to hydrogen embrittlement due to the high stress area directly opposite the slot. Mechanical zinc plate eliminates the risk associated with hydrogen embrittlement often caused by the electroplating process.

Hole Preparation

Holes can be drilled, punched or cast with no need for additional reaming or sizing. Care should be taken to avoid undersized holes to eliminate potential pin damage during insertion. The following points are suggested for your consideration:

- Break or debur the edges, particularly in case of hardened holes.
- Countersinking is not recommended as it increases the clearance at the shear plane.
- In the case of cast or sintered metal holes, a lead-in radius should be specified.
- Whenever possible, punched holes should be punched in the same direction as the direction of pin insertion.
- Eliminate hole misalignment problems by drilling holes together.
- In the case of hardened collars or similar components, flatten the component at the entry of the hole to avoid two-point contact as the pin starts into the hole.
- *Note: The recommended hole sizes in this catalog may not be true for all applications. Components may require a different hole size to ensure the proper function of the assembly. For this reason, it is recommended that SPIROL be consulted on new designs.*

APPLICATIONS ENGINEERING

SPIROL offers complimentary Application Engineering to assist you in your new design, supported by state-of-the-art manufacturing centers and worldwide stocking facilities to simplify the logistics of delivering your product.

Through partnering with companies in the design stage, we not only help design the most appropriate Spring Pin for your application, but we also make the critical recommendations for the interface between our product and your assembly.

PIN INSTALLATION TECHNOLOGY

SPIROL offers a standard line of Pin Installation Equipment, from manual to fully automatic modules. This allows us to recommend and provide a total assembly solution that will lower your assembly costs while improving the quality of your end product.

SPECIALS

Should a standard Slotted Pin not work for your application, SPIROL will design a custom Spring Pin to meet your requirements. Examples of special Spring Pins include: Lengths, Diameters, Materials, Finishes, Tolerances and Packaging.

All special parts are subject to minimum order quantities.



SPIROL®

Innovative fastening solutions.
Lower assembly costs.



Technical Centers

Americas

SPIROL International Corporation
30 Rock Avenue
Danielson, Connecticut 06239 U.S.A.
Tel. +1 860 774 8571
Fax. +1 860 774 2048

SPIROL Shim Division
321 Remington Road
Stow, Ohio 44224 U.S.A.
Tel. +1 330 920 3655
Fax. +1 330 920 3659

SPIROL Canada
3103 St. Etienne Boulevard
Windsor, Ontario N8W 5B1 Canada
Tel. +1 519 974 3334
Fax. +1 519 974 6550

SPIROL Mexico
Avenida Avante #250
Parque Industrial Avante Apodaca
Apodaca, N.L. 66607 Mexico
Tel. +52 81 8385 4390
Fax. +52 81 8385 4391

SPIROL Brazil
Rua Mafalda Barnabé Soliane, 134
Comercial Vitória Martini, Distrito Industrial
CEP 13347-610, Indaiatuba, SP, Brazil
Tel. +55 19 3936 2701
Fax. +55 19 3936 7121

Europe

SPIROL France
Cité de l'Automobile ZAC Croix Blandin
18 Rue Léna Bernstein
51100 Reims, France
Tel. +33 3 26 36 31 42
Fax. +33 3 26 09 19 76

SPIROL United Kingdom
17 Princewood Road
Corby, Northants
NN17 4ET United Kingdom
Tel. +44 1536 444800
Fax. +44 1536 203415

SPIROL Germany
Ottostr. 4
80333 Munich, Germany
Tel. +49 89 4 111 905 71
Fax. +49 89 4 111 905 72

SPIROL Spain
08940 Cornellà de Llobregat
Barcelona, Spain
Tel. +34 93 669 31 78
Fax. +34 93 193 25 43

SPIROL Czech Republic
Sokola Tůmy 743/16
Ostrava-Mariánské Hory 70900
Czech Republic
Tel/Fax. +420 417 537 979

SPIROL Poland
ul. Solec 38 lok. 10
00-394, Warszawa, Poland
Tel. +48 510 039 345

Asia Pacific

SPIROL Asia Headquarters
1st Floor, Building 22, Plot D9, District D
No. 122 HeDan Road
Wai Gao Qiao Free Trade Zone
Shanghai, China 200131
Tel. +86 21 5046 1451
Fax. +86 21 5046 1540

SPIROL Korea
160-5 Seokchon-Dong
Songpa-gu, Seoul, 138-844, Korea
Tel. +86 (0) 21 5046-1451
Fax. +86 (0) 21 5046-1540

e-mail: info@spirol.com

SPIROL.com

Please refer to www.SPIROL.com for current specifications and standard product offerings.

SPIROL Application Engineers will review your application needs and work with you to recommend the optimum solution. One way to start the process is to visit our **Optimal Application Engineering** portal at **SPIROL.com**.