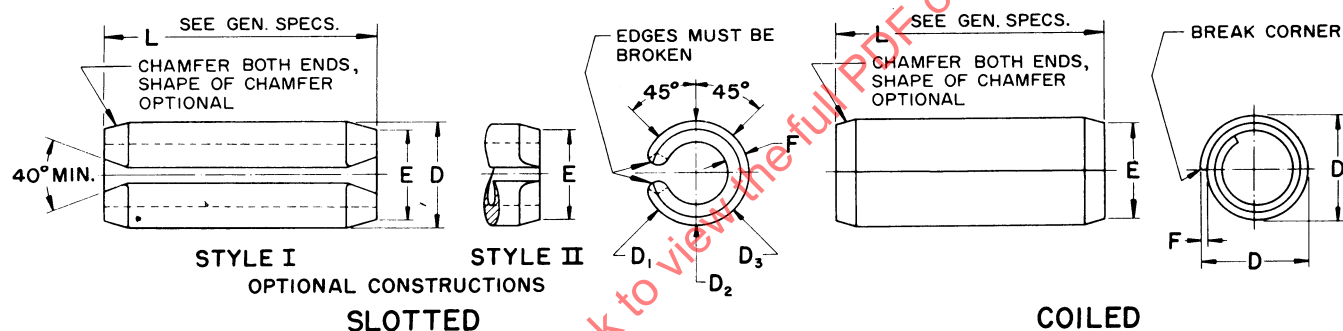


SPRING TYPE STRAIGHT PINS

Foreword—This Document has also changed to comply with the new SAE Technical Standards Board format.

1. Scope

2. References—There are no referenced publications specified herein.



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TABLE 1—PIN DIMENSIONS

Nominal Pin Size	D ^a								E	F						Double Shear Strength (lb) ^e			Recommended Hole Size			
	Slotted		Coiled						Slotted and Coiled	Slotted			Coiled			Slotted and Coiled			Slotted		Coiled	
	Series A ^b and B ^b		Series A		Series B		Series C		Series A, B, and C	Series A	Series B		Series A	Series B	Series C	Series A	Series B	Series C	Series A and B	Series A, B, and C		
Max	Min ^c	Max	Min	Max	Min	Max	Min	Max	Nominal	Style I Nominal	Style II Nominal	Nominal	Nominal	Nominal	Min	Min	Min	Max	Min	Max	Min	
1/32	—	—	—	—	0.035	0.033	—	—	0.029 ^d	—	—	—	—	0.003	—	75	—	—	—	0.0325	0.0310	
3/64	—	—	—	—	0.052	0.049	—	—	0.045 ^d	—	—	—	—	0.004	—	170	—	—	—	0.0485	0.0470	
0.052	—	—	—	—	0.057	0.054	—	—	0.050 ^d	—	—	—	—	0.004	—	230	—	—	—	0.0535	0.0520	
1/16	0.069	0.066	0.070	0.066	0.071	0.067	0.072	0.067	0.059	0.012	—	0.006	0.007	0.005	0.003	425	300	160	0.065	0.062	0.065	
5/64	0.086	0.083	0.086	0.082	0.087	0.083	0.088	0.083	0.075	0.018	—	0.008	0.008	0.007	0.005	650	480	260	0.081	0.078	0.081	
3/32	0.103	0.099	0.103	0.098	0.104	0.099	0.105	0.099	0.091	0.022	0.012	0.012	0.010	0.007	0.005	1000	690	370	0.097	0.094	0.097	
7/64	0.118	0.113	0.118	0.113	0.119	0.114	0.120	0.114	0.106	0.022	—	0.018	0.010	0.007	0.005	1410	940	510	0.112	0.109	0.112	
1/8	0.135	0.131	0.136	0.130	0.137	0.131	0.138	0.131	0.122	0.028	0.012	0.018	0.014	0.010	0.007	1840	1000	660	0.129	0.125	0.129	
9/64	0.149	0.145	0.151	0.145	0.152	0.146	0.153	0.146	0.136	0.028	—	0.022	0.014	0.010	0.007	2200	1350	830	0.141	0.140	0.144	
5/32	0.167	0.162	0.168	0.161	0.170	0.163	0.171	0.163	0.152	0.032	0.018	0.022	0.017	0.011	0.007	2880	1750	1040	0.160	0.156	0.160	
3/16	0.199	0.194	0.202	0.194	0.204	0.196	0.206	0.196	0.182	0.040	0.022	0.028	0.020	0.015	0.010	4140	2500	1500	0.192	0.187	0.192	
7/32	0.232	0.226	0.235	0.226	0.238	0.229	0.240	0.229	0.214	0.048	0.028	0.032	0.024	0.017	0.011	5640	3760	2040	0.224	0.219	0.224	
1/4	0.264	0.258	0.268	0.258	0.270	0.260	0.272	0.260	0.245	0.048	0.028	0.032	0.028	0.020	0.015	7360	4600	2660	0.256	0.250	0.256	
5/16	0.328	0.321	0.340	0.327	0.341	0.327	0.342	0.327	0.306	0.062	—	0.040	0.032	0.024	0.017	11500	7670	4160	0.318	0.312	0.318	
3/8	0.392	0.385	0.407	0.391	0.408	0.391	0.409	0.391	0.368	0.077	—	0.048	0.040	0.028	0.020	16580	10400	6000	0.382	0.375	0.382	
7/16	0.456	0.448	0.475	0.457	0.476	0.457	0.478	0.457	0.430	0.077	—	0.048	0.047	0.036	0.024	20000	15020	8160	0.445	0.437	0.445	
1/2	0.521	0.513	0.542	0.522	0.543	0.522	0.545	0.522	0.490	0.094	—	0.062	0.055	0.040	0.028	25800	19600	10640	0.510	0.500	0.510	

^a Maximum D shall be checked by a "GO" ring gage.

^b Series designation applies to stock thickness, A being heaviest.

^c Minimum D shall be the average of the D₁, D₂, and D₃ diameters.

^d Series B coiled.

^e Applies to pins made from SAE 1070 to 1095 steel and SAE 51410 or AISI 420 corrosion resistant steel. SAE 30302 stainless steel has a minimum shear strength equal to 85% of values shown for coiled pins.

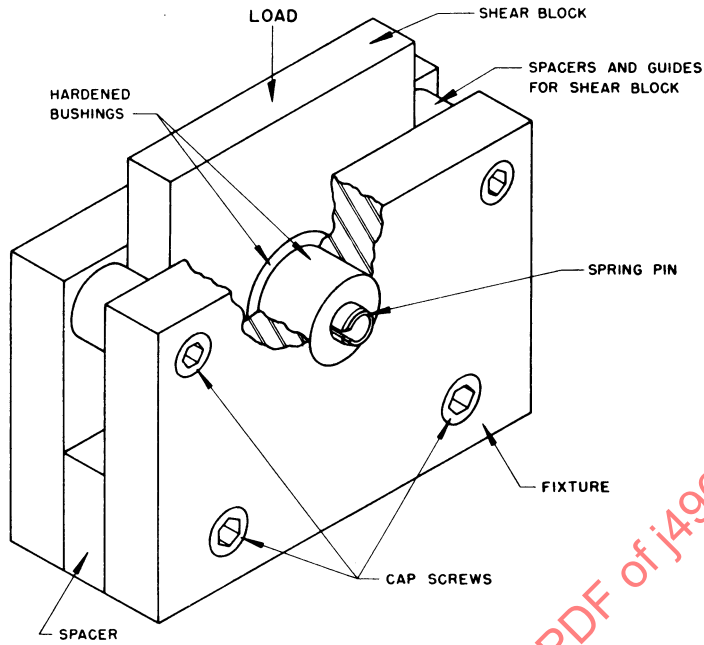
3. **Length and Availability**—Table 3, Practical Length Increments and Ranges, indicates spring pin sizes. Information on availability of individual lengths in the various types, weights, and materials may be obtained from suppliers.

The tolerance on length for coiled type spring pins shall be ± 0.010 in. for sizes up to and including 5/16 in.; and ± 0.015 in. for sizes larger than 5/16 in.

The tolerance on length for slotted type spring pins shall be in accordance with the following tabulation:

Length Range	3/16 to 1 Incl	Over 1 To 2 Incl	Over 2 To 3 Incl	Over 3 to 4 Incl	Over 4 in
Tolerance On Length	± 0.015	± 0.020	± 0.025	± 0.030	± 0.035

4. **Surface Treatment**—Where corrosion preventive treatment applied to carbon steel spring pins is such that it might produce hydrogen embrittlement, the spring pins shall be baked or treated in such a manner as to obviate such embrittlement.
5. **Material and Hardness**—Hardness shall be tested in the following manner: For slotted pins the readings shall be taken near the center of a longitudinal flat ground on the pin at right angles to the slot. Coiled pins shall be ground or cut in half along the longitudinal axis and the hardness readings shall be taken on the inside surface of the outer half coil. Table 2 designates materials and the proper Rockwell scale to be used for the various wall thickness ranges.



TYPICAL SPRING PIN SHEAR TEST FIXTURE

Wall Thickness Range		Over 0.001 to 0.010	Over 0.010 to 0.025	Over 0.025 to 0.050	Over 0.050 to 0.094
Rockwell Scale		Dph ^a - Tukon	15N	A	C
Pin Type	Material	Hardness Reading			
Slotted	SAE 1070-1095 Steel AISI 420 Corrosion Resistant Steel	458-562	83.6-87	73.6-78	46-53
		413-545	82-86.6	72-77	43-52
Coiled	SAE 1070 Steel	393-515	80.4-85.5	70.4-75.9	40-50
	SAE 51410 or AISI 420 Corrosion Resistant Steel	393-515	80.4-85.5	70.4-75.9	40-50
	SAE 30302 Stainless Steel	—	—	—	—

^a Diamond pyramidal hardness.

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Length	Nominal Diameter																
	1/32*	3/64*	0.052*	1/16	5/64	3/32	7/64	1/8	9/64	5/32	3/16	7/32	1/4	5/16	3/8	7/16	1/2
1/8																	
3/16																	
1/4																	
5/16																	
3/8																	
7/16																	
1/2																	
9/16																	
5/8																	
11/16																	
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3																	
3-1/4																	
3-1/2																	
3-3/4																	
4																	

* Coiled type only.

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