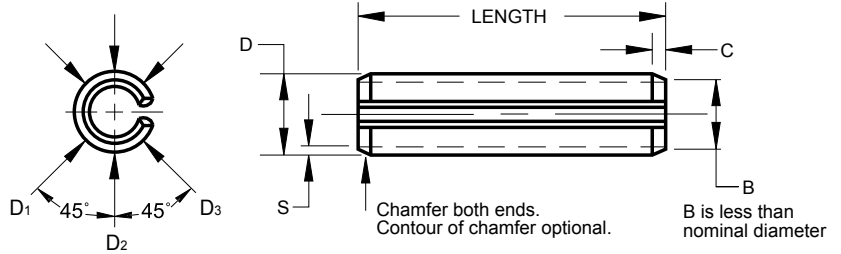


ASME B18.8.4M TYPE B (NON-INTERLOCKING)



PIN MATERIALS AND HARDNESS

B	High Carbon Steel	HV 458-560
C	Martensitic Stainless Steel	HV 423-544
D	Austenitic Stainless Steel	Work Hardened

PIN FINISHES

K	Plain
P	Passivated
T	Mechanical Zinc Plated

Plain carbon steel pins have a protective oil finish.

METRIC SPECIFICATIONS

NOMINAL PIN DIAMETER	PIN DIAMETER D		CHAMFER DIAMETER B	CHAMFER LENGTH C		WALL THICKNESS S	RECOMMENDED HOLE SIZE		MINIMUM DOUBLE SHEAR STRENGTH	
	MIN. ¹	MAX. ²	MAX.	MIN.	MAX.	NOMINAL	MIN.	MAX.	CARBON & MARTENSITIC SST	AUSTENITIC SST
	kN									
1.5	1.58	1.66	1.4	0.15	0.7	0.35	1.50	1.56	1.8	1.0
2	2.10	2.19	1.9	0.2	0.8	0.45	2.00	2.07	3.5	2.0
2.5	2.62	2.72	2.4	0.2	0.9	0.55	2.50	2.58	5.5	3.2
3	3.14	3.25	2.9	0.2	1.0	0.65	3.00	3.10	7.8	4.5
4	4.16	4.30	3.9	0.3	1.2	0.8	4.00	4.12	12.3	7.2
5	5.17	5.33	4.8	0.3	1.4	1.0	5.00	4.12	19.6	11.4
6	6.18	6.36	5.8	0.4	1.6	1.2	6.00	6.12	28.5	16.6
8	8.22	8.45	7.8	0.4	2.0	1.6	8.00	8.15	48.8	28.4
10	10.25	10.51	9.7	0.5	2.4	2	10.00	10.15	79.1	46.1
12	12.28	12.55	11.7	0.6	2.8	2.5	12.00	12.18	104.1	60.7

¹ Minimum diameter is the average of D1, D2 and D3.

² Maximum diameter measured with go-ring gage.

STANDARD METRIC SIZES

NOMINAL DIAMETER	1.5	2	2.5	3	4	5	6	8	10	12
4										
5										
6										
8		*		*						
10		*	*	*						
12		*	*	*	*					
14				*	*	*				
16				*	*	*	*			
18				*	*	*				
20		*	*	*	*	*	*	*		
22										
24					*	*	*	*		
26										
28					*					
30					*	*	*	*	*	
32										
35						*	*			
40					*	*	*	*	*	*
45						*	*			
50						*	*	*	*	*
55										
60							*	*	*	*
65										
70									*	*
75										
80									*	*
85										
90										
95										
100										

Nominal Pin Length	Length Tolerance
Up to 24mm incl.	±0.40mm
Over 24mm to 50mm incl.	±0.50mm
Over 50mm to 75mm incl.	±0.60mm
Over 75mm	±0.75mm

Straightness Gauge Specifications³

Nominal Pin Length	Gage Length	Gage Hole Diameter = Maximum Pin Diameter Plus:
Up to 24mm incl.	25mm ± 0.15mm	0.20mm - 0.22mm
24mm - 50mm	50mm ± 0.15mm	0.40mm - 0.43mm
Over 50mm	75mm ± 0.15mm	0.60mm - 0.64mm

³ The straightness over the length of the pins shall be such that the pin will pass freely through a ring gage of the length and diameter specified.

* Generally stocked size in carbon steel. All other sizes and materials are available to order.

Note: All dimensions apply prior to plating.



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 93 193 05 32
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 71 399 44 55

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

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