

**ASME B18.8.100M-2000**

**SPRING PINS: COILED TYPE,  
SPRING PINS: SLOTTED,  
MACHINE DOWEL PINS:  
HARDENED GROUND, AND  
GROOVED PINS (METRIC SERIES)**

**Incorporating ASME B18.8.3M, B18.8.4M, B18.8.5M, and B18.8.9M**

**A N A M E R I C A N N A T I O N A L S T A N D A R D**



**The American Society of  
Mechanical Engineers**



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Date of Issuance: May 10, 2001

The 2000 edition of this Standard is being issued with an automatic addenda subscription service. The use of an addenda allows revisions made in response to public review comments or committee actions to be published as necessary. The next edition of this Standard is scheduled for publication in 2003.

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## FOREWORD

The need for a standard covering machine pins was recognized by industry as far back as March, 1926, when the Sectional Committee on the Standardization of Machine Pins was organized under the procedure of the American Standards Association (later the United States of America Standards Institute and as of October 6, 1969, the American National Standards Institute, Inc.), with the Society of Automotive Engineers and the American Society of Mechanical Engineers as joint sponsors.

For the next year or two, an effort was made via correspondence to develop a basis on which a standard for straight, taper, split, and dowel pins might be established. This correspondence developed a distinct difference of opinion on the part of the manufacturers and users of taper machine pins, which fact seemed to discourage the members of the committee from attempting standardization on any of the types of pins within its scope. The sponsor organizations made frequent efforts to revive this project through letters and the distribution of technical literature on this general subject, without avail.

In December, 1941, in its periodic review of standards projects for which the Society is sponsor, the ASME Standardization Committee decided that there was little hope for reviving this project and voted, subject to acceptance by the sponsors, to suggest to the ASA the transfer of this project to Sectional Committee B5 on the Standardization of Small Tools and Machine Tool Elements. The sponsors agreed and on July 7, 1942, the ASA sanctioned this action and Sectional Committee B43 was discharged and the project was officially transferred to Sectional Committee B5.

At its meeting in December, 1942, Sectional Committee B5 voted to enlarge its scope to include machine pins. Technical Committee No. 23 was subsequently established and charged with the responsibility for technical content of standards covering machine pins. This group held its first meeting on November 30, 1943, at which time a Subgroup on Correlation and Recommendations was appointed and it was voted to include clevis pins in addition to the other pin types already under consideration. Several drafts were prepared by the subgroup, distributed for critical comment to users, manufacturers, and general interests, and revised and resubmitted for comments. This action finally resulted in acceptance by Technical Committee 23 of a draft dated November, 1945, which was duplicated in printer's proof form, under a date of October, 1946, and distributed to the members of Sectional Committee B5 for letter ballot approval. Subsequent to the approval of the Sectional Committee, the proposal was next approved by the sponsor bodies, and presented to the American Standards Association for approval as an American Standard. This designation was granted on July 7, 1947.

Following the issuance of the standard, it became apparent that the table on cotter pins needed revision. Accordingly, in 1953 a proposed revision was submitted to the Sectional Committee. After attaining Sectional Committee and sponsor approval, this revision was approved by the American Standards Association on July 9, 1954 as ASA B5.20-1954.

In 1956 and 1957, in response to requests from industry, extensive changes were incorporated into a proposed revision. These included revisions to chamfer values and tolerances on straight pins and unhardened ground dowel pins; revisions to under head to hole, pin end dimensions, and hole sizes tolerances on clevis pins; addition of chisel point to cotter pin end styles and the incorporation of coverage on grooved pins. Following

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