

JIS

JAPANESE INDUSTRIAL STANDARD

Taper Pins with Split

JIS B 1353—1990

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In the event of any doubt arising,
the original Standard in Japanese is to be final authority.

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Taper Pins with Split

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1. Scope

This Japanese Industrial Standard specifies steel split taper pins and stainless steel split taper pins having the taper of $\frac{1}{50}$ for general use (hereafter respectively referred to as the "steel pins" and "stainless pins").

Further, when steel pins and stainless pins are generically called in this Standard, they shall simply be referred to as the "pins".

Remarks 1. The pins specified in the text of this Standard shall be in accordance with the taper pins class B specified in the text of JIS B 1352.

2. The pins which are not in accordance with the text in shape • dimensions, taper precision and surface roughness are specified in Annex as "taper pins with split of an old type".

2. Toughness of Split Part

When fixing a pin at the same section as the bottom of split as shown in Fig. 1 and opening the tip of split symmetrically by hitting, the pin shall not be broken at not larger than 60° in opening angle or cracks shall not be produced.

Applicable Standards:

JIS B 0031-Method of Indicating Surface Texture on Drawings

JIS B 0401-System of Limits and Fits

JIS B 0601-Definitions and Designation of Surface Roughness

JIS B 1071-Method of Verification for Size and Geometry of Threaded Fasteners

JIS B 1352-Taper Pins

JIS G 3123-Cold Finished Carbon and Alloy Steel Bars

JIS G 4051-Carbon Steels for Machine Structural Use

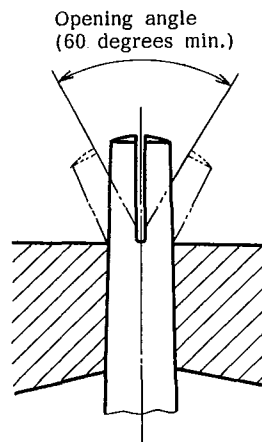
JIS G 4303-Stainless Steel Bars

JIS G 4804-Free Cutting Carbon Steels

JIS Z 2244-Method of Vickers Hardness Test

JIS Z 2245-Method of Rockwell and Rockwell Superficial Hardness Test

Fig. 1

3. Hardness

The hardness of the pins shall conform to Table 1.

Table 1

Division	Hardness	
	Vickers hardness	Rockwell hardness
Steel pin	HV 125 to 245	HRB 70 to HRC 21
Stainless pin	HV 208 to 280	HRB 93 to HRC 27

4. Shape and Dimensions

The shape and dimensions of pins shall conform to Attached Table.

5. Appearance

The pins shall be free from such harmful defects in use as cracks, flaws, burrs and rust, and the surface roughness of tapered portion shall be 3.2 a of JIS B 0601.

6. Materials

The materials of pins shall conform to Table 2, as a rule.

Table 2

Division	Materials
Steel pins	SUM 22 to SUM 24 L of JIS 4804 SGD 41-D of JIS G 3123 S 43 C ⁽¹⁾ to S 45 C ⁽¹⁾ of JIS G 4051
Stainless pin	SUS 303 of JIS G 4303

Note ⁽¹⁾ These materials shall be used after normalized.

7. Surface Treatment

The pins are not subjected to the surface treatment generally. Provided that the steel pins are applied with rust preventive oil at the supply time. Where plating or other surface treatment is required for the pins, the orderer shall give designation.

Furthermore, in the case where the pin has been subjected to electroplating, the brittleness removal treatment shall be conducted, as required.

8. Inspection

8.1 Toughness Inspection of Split Part The toughness inspection of the split part of pin shall meet the specifications of 2.

8.2 Hardness Inspection The hardness of pin shall be inspected in accordance with the test method specified in JIS Z 2244 or JIS Z 2245 and the end of pin or the hardness of taper part shall meet the specifications of 3.

Furthermore, the hardness of pin may be in accordance with any one of Vickers hardness or Rockwell hardness, but where the measured value is doubtful, the Vickers hardness shall be applied to determine acceptance or rejection.

8.3 Shape and Dimensions Inspection The shape and dimensions of pin shall be inspected by direct measurement, limit gauge or other methods and meet the specifications of 4.

8.4 Appearance Inspection The appearance of pin shall be inspected visually and meet the specifications of 5. Provided that the surface roughness of taper part shall be inspected by the measuring method of surface roughness specified in JIS B 1071 or an alternative method.

8.5 Delivery Inspection The sampling inspection plan of the lots at the delivery time shall be in accordance with the agreement between the parties to the delivery.