



Non-Preferred Parts

Number:	JM-055
Date Issued:	A-DEC05

SLOTTED SPRING PINS IFI METRIC SERIES (Superseded)

This standard has been superseded by CNH Standard Parts, STPJ590 (87366823), Slotted Spring Pins - Metric - Non-Preferred.

The controlled versions of CNH specifications and standards are published on the CNH Intranet site.

The documents are also available on the CNH electronic viewing system (e.g. eViewer). Suppliers are able to access these documents on CSCN (CNH Supplier Communications Network).

The superseded standard remains available for viewing following this page if needed.

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GENERAL SPECIFICATIONS

GENERAL: This specification covers performance, dimensions, physical properties, and method of testing slotted spring pins. They shall conform essentially with IFI 512-S "metric spring pins."

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.

Table below designates materials and the proper Rockwell scales to be used for the various wall thickness ranges.

Wall Thickness Range	Up to 0.25 mm	Over 0.25 mm Up to 0.63 mm	Over 0.63 mm Up to 1.27 mm	Over 1.27 mm Up to 2.39 mm
Hardness Scale	DPH (10 kg)	Rockwell 15N	Rockwell A	Rockwell C
Material				
SAE -1070 - 1095 Carbon Steel	458 - 562	83.6 - 87	73.6 - 78	46 - 53

FINISHES: Spring pins shall be supplied plain or plated in accordance with Case Materials Specification and class listed below:

Plain (PLN)
Zinc Chromate (ZND) MS 201 Class 5B

High tensile strength steel components such as spring pins are more susceptible to embrittlement by hydrogen. Therefore, electroplating is not recommended for these products. However, if chemical or electrochemical surface coating cannot be avoided, the plated spring pins must be heated at a temperature sufficiently high and for a period sufficiently long to remove the hydrogen.

SLOT: Slot design shall be in accordance with the practice of the manufacturer, except that the slot width shall be narrow enough to prevent nesting or interlocking of pins and wide enough to permit satisfactory installation in a hole of the minimum diameter as recommended in the dimensional table.

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STRAIGHTNESS: Straightness of pins shall be within the limits necessary to permit pins to fall through a ring gage by their own weight. Ring gage dimensions shall be as specified below.

Dimensions in millimetres.

Pin Length	Gage Length		Gage Hole Diameter	
	Max	Min	Min	Max
to and incl 25	25.15	24.85	Specified Pin Dia, Max	Specified Pin Dia, Max Plus
over 25 to 50	50.15	49.85	Plus	0.21
over 50	75.15	74.85	0.20	0.42
			0.40	0.63
			0.60	

WORKMANSHIP: Spring pins shall be free from burrs, loose scale, seams, notches, sharp edges or other defects which might affect their serviceability.

PERFORMANCE: Pins shall be capable of withstanding the double shear loads specified in the dimensional table when tested per IFI 512-S.

Nominal Sizes, Length increment and tolerances:

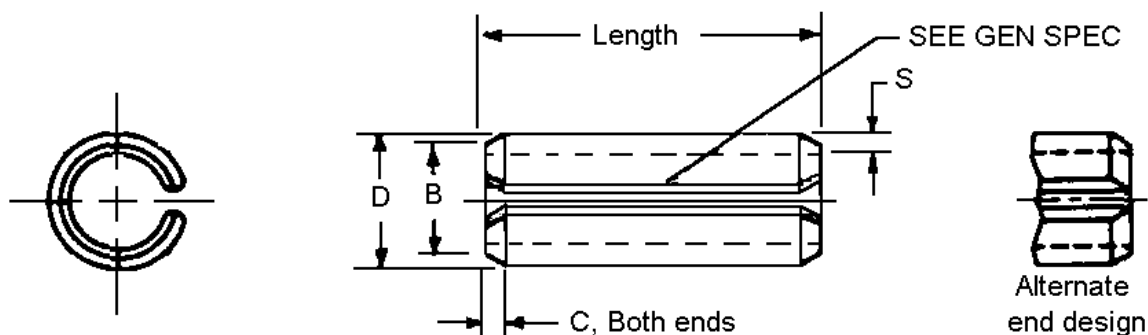
Nom Length	Length Tol	Nom Pin Size									
		1.5	2	2.5	3	4	5	6	8	10	12
4	0.40 For all lengths thru 25 mm	X	X								
5		X	X	X							
6		X	X	X	X						
8		X	X	X	X	X					
10		X	X	X	X	X	X				
12		X	X	X	X	X	X	X			
14		X	X	X	X	X	X	X			
16		X	X	X	X	X	X	X	X		
18		X	X	X	X	X	X	X	X		
20		X	X	X	X	X	X	X	X	X	
25		X	X	X	X	X	X	X	X	X	X
30	0.50 For all lengths over 25 mm thru 50 mm		X	X	X	X	X	X	X	X	X
35			X	X	X	X	X	X	X	X	X
40			X	X	X	X	X	X	X	X	X
45				X	X	X	X	X	X	X	X
50					X	X	X	X	X	X	X
55	0.60 For all lengths over 50mm thru 75 mm					X	X	X	X	X	X
60						X	X	X	X	X	X
65								X	X	X	X
70								X	X	X	X
75								X	X	X	X
80	0.75 For all lengths over 75 mm								X	X	X
90									X	X	X
									X	X	X
100									X	X	X

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Dimensions in millimetres.

Nom Pin Size	D		B	C		S	Recommended Hole Size *		Double Shear Load, kN
	Dia		Chamfer Dia	Chamfer Length		Stock Thickness			
	Max	Min	Max	Max	Min	Nom	Max	Min	Min
2	2.2	2.12	1.9	0.8	0.2	0.4	2.10	2.00	3
2.5	2.72	2.63	2.4	0.9	0.2	0.5	2.60	2.50	4.4
3	3.25	3.15	2.9	1.0	0.2	0.6	3.10	3.00	7.1
4	4.28	4.15	3.9	1.2	0.3	0.8	4.12	4.00	13.2
5	5.33	5.17	4.8	1.4	0.3	1.0	5.12	5.00	20.2
6	6.36	6.20	5.8	1.6	0.4	1.2	6.12	6.00	29.3
8	8.40	8.22	7.8	2.0	0.4	1.6	8.15	8.00	52.8
10	10.43	10.25	9.7	2.4	0.5	2.0	10.15	10.00	84
12	12.48	12.28	11.7	2.8	0.6	2.5	12.18	12.00	106

* Recommended hole sizes shown are North American industry practice and is published as a guide only. Because conditions differ widely, it may be necessary to modify the hole size to suit a particular application. The advisability and the extent of such modifications can best be determined by experiment in the particular assembly environment.