



BSI Standards Publication

**Pins, taper, split (inch series), corrosion
resisting steel and cadmium plated alloy
steel — Specification**

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Summary of pages

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Foreword

Publishing information

This British Standard is published by BSI Standards Limited, under licence from The British Standards Institution, and came into effect on 30 September 2021. It was prepared by Technical Committee ACE/12, *Aerospace fasteners and fastening*. A list of organizations represented on this committee can be obtained on request to its committee manager.

Supersession

This British Standard supersedes BS SP 31 & 32:1951, which is withdrawn.

Information about this document

This is a full revision of the standard, and introduces the following principal changes:

- Clarification of split end bend test acceptance pass requirements;
- The addition of a cadmium caution notice;
- Clarification of the BS Part No. designation.

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Hazard warnings

CAUTION. This British Standard features parts that have cadmium as a plating material which has been restricted and/or banned for use in many countries owing to environmental and health concerns; they should not be used in new product designs. Local officials should be consulted about any concerns on the use of cadmium plated parts.

Presentational conventions

The provisions of this standard are presented in roman (i.e. upright) type. Its requirements are expressed in sentences in which the principal auxiliary verb is “shall”.

Commentary, explanation and general informative material is presented in smaller italic type, and does not constitute a normative element.

Where words have alternative spellings, the preferred spelling of the Shorter Oxford English Dictionary is used (e.g. “organization” rather than “organisation”).

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1 Scope

This British Standard specifies the materials, dimensions and finish of split taper pins for aerospace use.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes provisions of this document. For dated references, only the edition cited applies.¹⁾ For undated references, the latest edition of the referenced document (including any amendments) applies.

BS S 80, *High chromium-nickel corrosion resisting steel forging stock, bars, forgings and parts (880 to 1080 MPa: limiting ruling section 100mm)*

BS S 154, *2 1/2 % nickel-chromium-molybdenum steel billets, bars, forgings and parts (880 to 1080 MPa: limiting ruling section 150 mm)*

BS EN 2133, *Aerospace series – Cadmium plating of steels with specified tensile strength ≤ 1450 MPa, copper, copper alloys and nickel alloys*

SAE AMS03-19, *Electro-Deposition of Cadmium*

3 Terms and definitions

No terms and definitions are listed in this document.

4 Materials and manufacture

The pins shall be manufactured from the appropriate material specified in [Table 1](#).

The pins shall have a smooth machine ground finish and shall be free from visible surface defects when viewed by the naked eye under good lighting conditions.

NOTE Pin outline end form options are shown in [Figure 1](#).

The large end of the pins shall be of a curved domed form but extending no further beyond length *B* than a full hemisphere.

The small end of the pins, though shown of domed form (see [Figure 1](#)), shall - at the option of the manufacturer - be of any suitable lead-in form, both for hole entry and to aid the end customer to prise the tang halves apart.

The pins shall be split and not sawn.

Table 1 — *Materials*

| BS Identifier | Description | Material specification |
|---------------|---------------------------|------------------------|
| SP32 | Alloy steel | BS S 154 ^{A)} |
| SP32 | Corrosion resisting steel | BS S 80 |

^{A)} BS S 114 and BS S 96 have been withdrawn but are included here for reference only for earlier-made pins, which might still be in service.

¹⁾ Documents that are referred to solely in an informative manner are listed in the Bibliography.