

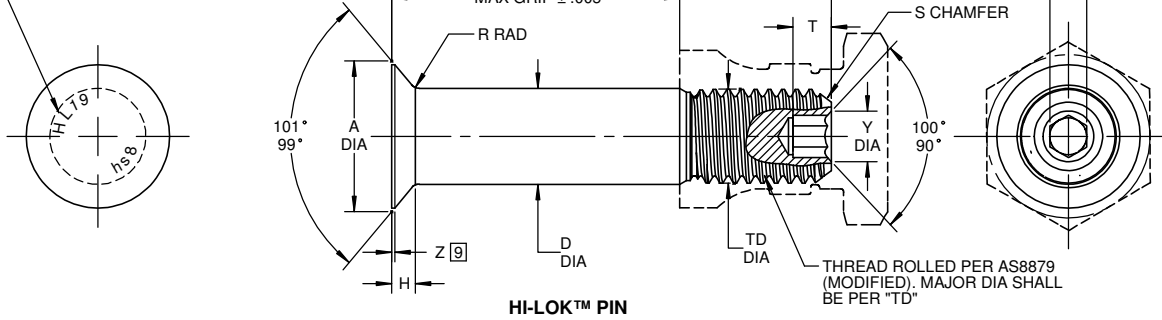


hi-shear corporation  
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

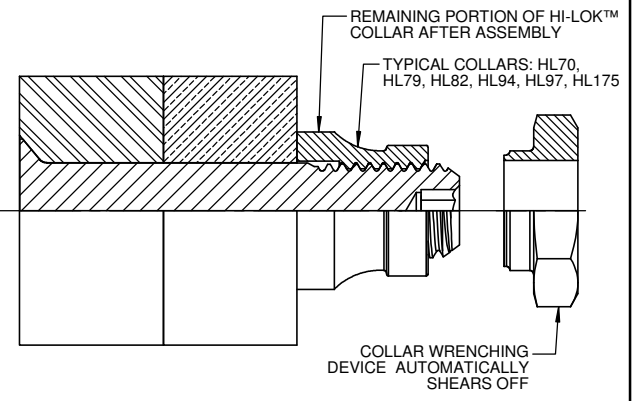
(29)

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INDENTED HEAD MARKING .010 MAX DEPTH.  
MANUFACTURER'S TRADEMARK "hs" PER  
SPEC. 363. THE NUMBER(S) FOLLOWING  
TRADEMARK INDICATES FIRST DASH. NO.  
ARRANGEMENT OPTIONAL.



HI-LOK™ PIN



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

SEE COLLAR STANDARDS  
FOR COLLAR STRENGTHS.  
LOWER STRENGTH (PIN OR  
COLLAR) DETERMINES  
SYSTEM STRENGTH

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	F REF	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
												W HEX	T DEPTH	Y DIA		
5	5/32	.2612 .2564	.312	.1635 .1625	.1595 .1570	.004	.0410 .0390	.025 .015	.010	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.135 .115	7	4,010	1,290
6	3/16	.3016 .2966	.325	.1895 .1885	.1840 .1810	.005	.0470 .0450	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	5,380	2,000
8	1/4	.3948 .3898	.395	.2495 .2485	.2440 .2410	.006	.0610 .0590	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	9,300	3,700
10	5/16	.4739 .4689	.500	.3120 .3110	.3060 .3020	.007	.0680 .0660	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	14,600	5,000
12	3/8	.5604 .5554	.545	.3745 .3735	.3680 .3640	.008	.0780 .0760	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	21,000	7,200
14	7/16	.6680 .6620	.635	.4370 .4360	.4310 .4260	.009	.0969 .0944	.040 .030	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	28,600	10,000
16	1/2	.7540 .7480	.685	.4995 .4985	.4930 .4880	.010	.1068 .1043	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	37,300	13,500
18	9/16	.8380 .8310	.770	.5615 .5605	.5550 .5500	.010	.1160 .1130	.050 .040	.022	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	47,200	17,000
20	5/8	.9250 .9180	.825	.6240 .6230	.6180 .6120	.010	.1260 .1230	.050 .040	.025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	58,300	21,000
24	3/4	1.0970 1.0850	1.050	.7490 .7480	.7430 .7370	.012	.1460 .1410	.050 .040	.030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	83,900	30,700
28	7/8	1.3197 1.3030	1.210	.8740 .8730	.8680 .8610	.014	.1870 .1800	.050 .040	.035	5/64 x 45°	.8750-14 UNJF-3A	.3820 .3780	.455 .425	.471 .451	114,000	42,000
32	1	1.5186 1.4995	1.390	.9990 .9980	.9930 .9860	.014	.2180 .2100	.050 .040	.035	5/64 x 45°	1.0000-12 UNJF-3A	.5100 .5040	.580 .550	.618 .598	149,000	55,000

"HI-LOK", "HL", and "HI-KOTE",  
are Trademarks of Hi-Shear Corporation

DRAWN BY J.F. Obispo J.C.S.	DATE 1-20-15 7-19-62	TITLE <b>HI-LOK™ PIN</b> 100° FLUSH SHEAR HEAD ALLOY STEEL 1/16 GRIP VARIATION
APPROVED Cessna	DATE 7.29-62	
REVISION (29)	DATE F.C. 1-15-16	DRAWING NUMBER <b>HL19</b>

HL19



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2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

- GENERAL NOTES:**
- 1] Head edge out of roundness shall not exceed "F".
  - 2. Concentricity: Conical surface of head to "D" diameter within .005 FIM.
  - 3. Dimensions to be met after finish.
  - 4. Surface texture per ANSI B46.1.
  - 5. Hole preparation per NAS618.
  - 6. "H" is dimensioned from maximum "D" diameter.
  - 7] Evidence of broken edge across points.
  - 8] Non-lubed pins must be used with lubed collars or wet sealant.
  - 9] Curved or flat edge manufacturer's option.
  - 10. Use HL63 for oversize replacement.

**MATERIAL:** Alloy steel per AMS6415, AMS6349 or AMS6382, AMS6322.

**HEAT TREAT:** 95,000 psi shear minimum (160,000 - 180,000 psi tensile per AMS-H-6875).

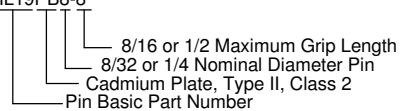
- FINISH:**
- HL19(-)(-) = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL19PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per per Hi-Shear Spec. 305.
  - 8] HL19PN(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
  - HL19TF(-)(-) = Cadmium plate per AMS-QQ-P-416, Type III, Class 2, and HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.

**SPECIFICATION:** HI-LOK™ Product Specification 342.

**CODE:** First dash number indicates nominal diameter in 1/32nds.  
Second dash number indicates maximum grip in 1/16ths.  
See Finish note for explanation of code letters.

**HOW TO ORDER**

**EXAMPLE:** Pin Part Number  
HL19PB8-8



HL19

DRAWING NUMBER

HL19