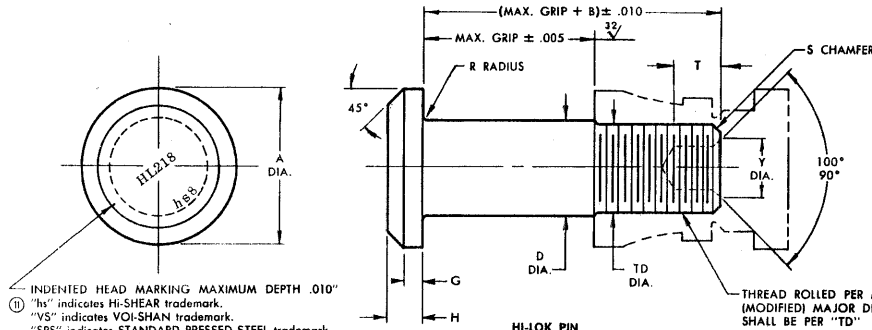


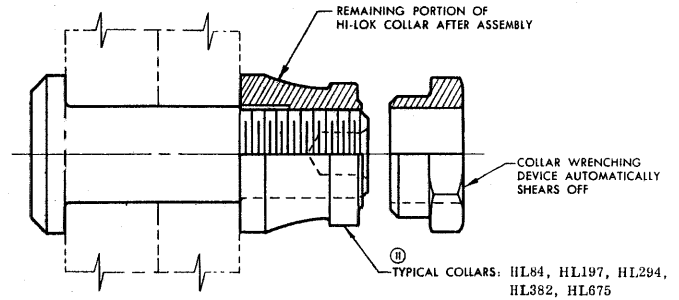
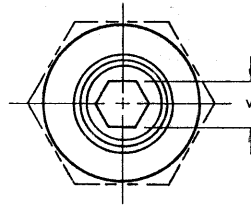
**STANDARDS COMMITTEE
FOR HI-LOK® PRODUCTS**
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

HI-SHEAR CORPORATION (Patent Holder) — Federal Code Ident. No. 73197
VOI-SHAN DIV., VSI CORP. (Licensee) — Federal Code Ident. No. 92215
STANDARD PRESSED STEEL CO. (Licensee) — Federal Code Ident. No. 56878

**STANDARDS
MANUAL**



⑪ INDENTED HEAD MARKING MAXIMUM DEPTH .010"
"hs" indicates HI-SHEAR trademark.
"VS" indicates VOI-SHAN trademark.
"SPS" indicates STANDARD PRESSED STEEL trademark.
The number or numbers following the trademark indicate first dash number. Arrangement optional.



HI-LOK PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.	TD DIA.	G REF.	H	R RAD.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
											W HEX.	T DEPTH	Y DIA.		
-5	13/64														
NOTE: Use HL62-6															
-6	7/32	.315 .295	.325	.2182 .2172	.1840 .1810	.025	.055 .045	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	7,100	2,500
-8	9/32	.412 .387	.395	.2807 .2797	.2440 .2410	.030	.069 .059	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0987 .0947	.150 .130	.142 .122	11,800	4,300
-10	11/32	.505 .475	.500	.3432 .3422	.3060 .3020	.035	.078 .068	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	17,600	6,300
-12	13/32	.600 .565	.545	.4057 .4047	.3680 .3640	.040	.088 .078	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	24,600	8,700
-14	15/32	.676 .641	.635	.4682 .4672	.4310 .4260	.045	.105 .093	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	32,700	12,100
-16	17/32	.770 .735	.685	.5307 .5297	.4930 .4880	.050	.115 .103	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	42,000	15,300
-18	19/32	.864 .829	.770	.5927 .5917	.5550 .5500	.055	.127 .112	.040 .025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.290 .270	.326 .306	52,400	19,000
-20	21/32	.953 .918	.825	.6552 .6542	.6180 .6120	.060	.137 .122	.040 .025	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.330 .305	.326 .306	64,100	23,000
-24	25/32	1.108 1.066	1.050	.7802 .7792	.7430 .7370	.070	.151 .136	.045 .030	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.395 .365	.398 .378	90,900	30,700
-28	29/32	1.285 1.241	1.210	.9052 .9042	.8680 .8610	.090	.187 .172	.050 .035	5/64" x 45°	7/8-14UNJF-3A Modified	.3820 .3780	.455 .425	.471 .451	122,000	45,000
-32	1-1/32	1.468 1.424	1.390	1.0302 1.0292	.9930 .9860	.110	.218 .203	.060 .045	5/64" x 45°	1-12UNJF-3A Modified	.5100 .5040	.580 .550	.618 .598	158,000	60,900

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

- GENERAL NOTES:
1. Concentricity: "A" to "D" diameter within .010 FIR.
 2. Dimensions to be met after plating.
 3. Surface texture per ANSI B46.1. ⑪
 4. Hole preparation per NAS618.
 5. Use HL202 for oversize replacement.

MATERIAL: Alloy steel per Spec. MIL-S-5000, MIL-S-5626 or MIL-S-6049.

HEAT TREAT: 95,000 psi shear minimum (160,000–180,000 psi tensile per Spec. MIL-H-6875).

FINISH: HL218-()-() = Cadmium plate per Spec. QQ-P-416, Type II, Class 2, color bronze, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL218A-()-() = Cadmium plate per AMS2400-3 and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lok Product Spec. 342.

CODE: First dash number indicates nominal diameter in 1/32nds which HL218 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths. See "Finish" note for explanation of code letters.

HOW TO ORDER EXAMPLES:

Pin Part Number Only
HL218-8-8
8/16 or 1/2 Maximum Grip Length
Replaces 8/32 or 1/4 Nominal Diameter Pin
Pin Part Number with Type II Cadmium Plate

Pin and Collar Assembly Part Number Combination
HL21884-8-8
Size and Grip Length, See Above Example
Collar Part Number
Pin Part Number

** The double shear values shown are based on cross section area for nominal diameter pin.

U.S. patents 2,882,773; 2,927,491; 2,940,495; 3,027,789; 3,138,987; design patent 191,883; other U.S. and Foreign patents granted and pending; property of Hi-Shear Corporation. "Hi-Lok" and "HL" are Registered Trademarks of Hi-Shear Corporation.

DRAWN	DATE	hi-lok PIN PROTRUDING SHEAF HEAD ALLOY STEEL 1/16" GRIP VARIATION - 1/32" OVERSIZE HL218
Brlej	3-11-64	
APPROVED	DATE	
Cessna	3-11-64	
REVISION	DATE	
⑪	9-11-74	

HL218