



HI-LOK PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.	TD DIA.	F	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
												W HEX.	T DEPTH	Y DIA.		
-5	13/64															
											NOTE: Use HL63-6					
-6	7/32	.3303 .3253	.325	.2182 .2172	.1840 .1810	.005	.0470 .0449	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	7,100	2,000
-8	9/32	.4260 .4210	.395	.2807 .2797	.2440 .2410	.006	.0610 .0589	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	11,800	3,700
-10	11/32	.5051 .5001	.500	.3432 .3422	.3060 .3020	.007	.0679 .0658	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .15	.180 .160	17,600	5,000
-12	13/32	.5916 .5866	.545	.4057 .4047	.3680 .3640	.008	.0780 .0759	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.20 .180	.217 .197	24,600	7,200
-14	15/32	.6992 .6932	.635	.4682 .4672	.4310 .4260	.009	.0969 .0944	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	32,700	10,000
-16	17/32	.7852 .7792	.685	.5307 .5297	.4930 .4880	.010	.1068 .1043	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	42,000	13,500
-18	19/32	.8692 .8622	.770	.5927 .5917	.5550 .5500	.010	.1160 .1131	.050 .040	.022	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.290 .270	.326 .306	52,400	17,000
-20	21/32	.9562 .9492	.825	.6552 .6542	.6180 .6120	.010	.1263 .1233	.050 .040	.022	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.330 .305	.326 .306	64,100	21,000
-24	25/32	1.1282 1.1162	1.050	.7802 .7792	.7430 .7370	.012	.1460 .1410	.050 .040	.022	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.395 .365	.398 .378	90,900	30,700
-28	29/32	1.3509 1.3342	1.210	.9052 .9042	.8680 .8610	.014	.1870 .1800	.050 .040	.022	5/64" x 45°	7/8-14UNJF-3A Modified	.3820 .3780	.455 .425	.471 .451	122,000	42,000
-32	1-1/32	1.5498 1.5307	1.390	1.0302 1.0292	.9930 .9860	.014	.2180 .2100	.050 .040	.022	5/64" x 45°	1-12UNJF-3A Modified	.5100 .5040	.580 .550	.618 .598	158,000	55,000

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

DRAWN	DATE	 PIN 100° FLUSH SHEAR HEAD ALLOY STEEL 1/16" GRIP VARIATION - 1/32" OVERSIZE
BrleJ	3-11-64	
APPROVED	DATE	
Cessna	3-11-64	
REVISION	DATE	
(12) Var	9-11-74	DRAWING NUMBER HL219

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CODE: First dash number indicates nominal diameter in 1/32nds which HL219 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
HL219-8-8
 — 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
HL21984-8-8
 Size and Grip Length, See Above Example
 Collar Part Number
 Pin Part Number

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: HL219-()-() = Cadmium plate per Spec. QQ-P-416, Type II, Class 2, color bronze, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL219A-()-() = Cadmium plate per AMS2400-3 and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lok Product Specification 342.

HL219