

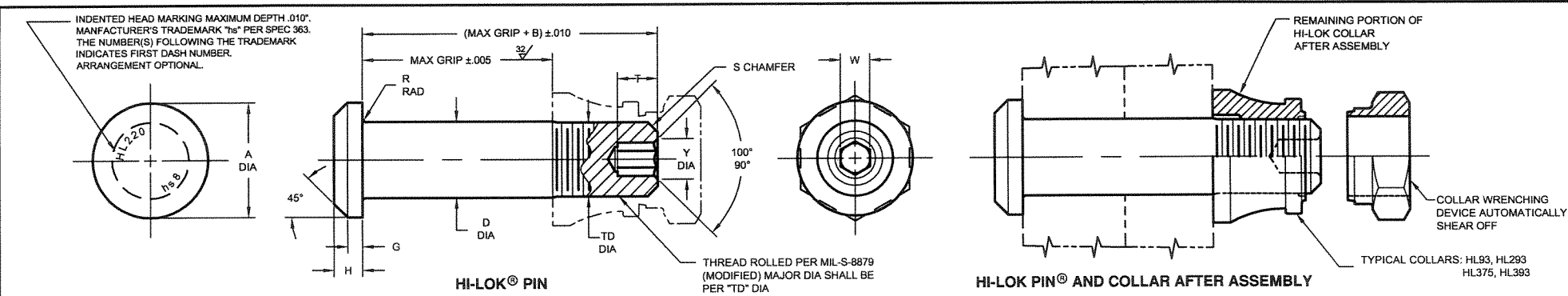
STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder)	CAGE No. 73197
a LISSI AEROSPACE Company	
AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A & Canada)	CAGE No. 06725
HUXO INTERNATIONAL, INC., U.S.A. (Licensee)	CAGE No. 97928
SPS TECHNOLOGIES, U.S.A. (Licensee)	CAGE No. 56878
FAIRCHILD Aerospace Fastener Division (Licensee)	CAGE No. 92215
WEST COAST AEROSPACE INC., U.S.A. (Licensee)	CAGE No. 60516

(Pins & Steel Collars)

BLANC AERO INDUSTRIES UK LIMITED (Licensee)	CAGE No. OLB68
a LISSI AEROSPACE Company	
HUCK S.A. France (Licensee - ECC Countries)	
BLANC AERO S.A. France (Licensee - ECC Countries)	
a LISSI AEROSPACE Company	
TOKYO SCREW COMPANY, Japan (Licensee - Japan)	



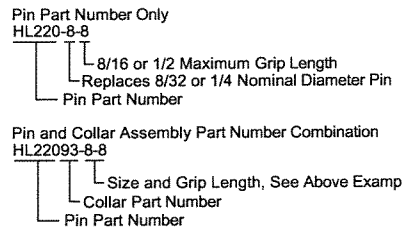
FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
											W HEX	T DEPTH	Y DIA		
5															
NOTE: USE HL64-6(-)															
6	7/32	.390 .370	.325	.2182 .2172	.1840 .1810	.035	.074 .064	.025 .015	1/32° x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	7,100	3,180
8	9/32	.460 .435	.395	.2807 .2797	.2440 .2410	.045	.090 .077	.025 .015	1/32° x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	11,800	5,820
10	11/32	.520 .490	.500	.3432 .3422	.3060 .3020	.055	.112 .102	.030 .020	3/64° x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	17,600	9,200
12	13/32	.585 .550	.545	.4057 .4047	.3680 .3640	.065	.140 .130	.030 .020	3/64° x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	24,600	14,000
14	15/32	.650 .615	.635	.4682 .4672	.4310 .4260	.075	.160 .150	.030 .020	3/64° x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	32,700	18,900
16	17/32	.775 .740	.685	.5307 .5297	.4930 .4880	.085	.188 .178	.030 .020	3/64° x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	42,000	25,600
18	19/32	.905 .870	.770	.5927 .5917	.5550 .5500	.125	.210 .200	.040 .025	1/16° x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.290 .270	.326 .306	52,400	32,400
20	21/32	.975 .940	.825	.6552 .6542	.6180 .6120	.140	.238 .228	.040 .025	1/16° x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.330 .305	.326 .306	64,100	41,000
24	25/32	1.185 1.145	1.050	.7802 .7792	.7430 .7370	.200	.335 .320	.045 .030	1/16° x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.395 .365	.398 .378	90,900	59,500

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

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 2. Dimensions to be met after plating.
 3. Surface texture per ANSI B46.1.
 4. Non-lubed pins must be used with wet sealant or with lubed collars.
 5. Hole preparation per NAS618.
 6. Use HL204 for oversize replacement.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL220 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER EXAMPLE:



- MATERIAL:** Alloy steel per AMS-S-6049, AMS6322; AMS6349, AMS6382; AMS6415.
- HEAT TREAT:** 95,000 psi shear minimum (160,000-180,000 psi tensile per AMS-H-6875).
- FINISH:** HL220(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL220A(-)(-) = Cadmium plate per AMS2400-3, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL220PN(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2. (See Note 4).
- SPECIFICATION:** Hi-Lok Product Specification 342.

DRAWN		DATE		TITLE	
Brfej		3-11-64		HI-LOK® PIN PROTRUDING TENSION HEAD ALLOY STEEL 1/16" GRIP VARIATION, 1/32" OVERSIZE	
APPROVED		DATE		DRAWING NUMBER	
M.C.		3-11-64		HL220	
REVISION		DATE		DRAWING NUMBER	
⑩		J.F.O. 5-1-2003		HL220	

HL220