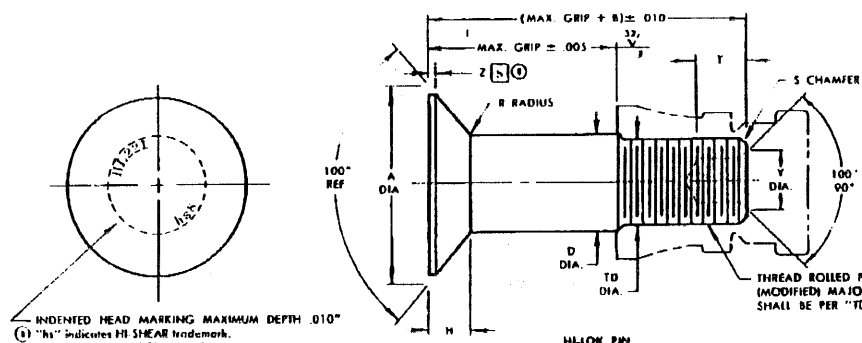


INDENTED HEAD MARKING MAXIMUM DEPTH .010"
(1) "h" indicates HI-SHEAR trademark.
"VS" indicates VOI-SHAN trademark.
"SPS" indicates STANDARD PRESSED STEEL trademark.
The number or numbers following the trademark indicate first dash number. Arrangement optional.

HI-LOK PIN

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.	Y DEPTH	Y DIA.		
-5	13/64															
NOTE: Use 4L65-6																
-6	7/32	.3513 .3765	.325	.2182 .2172	.1840 .1810	.005	.0684 .0664	.030 .020	.115	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	7,100	3,180
-8	9/32	.5066 .5018	.395	.2807 .2797	.2440 .2410	.006	.0948 .0928	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	11,800	5,820
-10	11/32	.6335 .6287	.500	.3432 .3422	.3060 .3020	.007	.1218 .1198	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.160 .160	17,600	9,200
-12	13/32	.7604 .7556	.545	.4057 .4047	.3680 .3640	.008	.1488 .1468	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	24,600	14,000
-14	15/32	.8884 .8812	.635	.4682 .4672	.4310 .4260	.009	.1763 .1733	.060 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	32,700	18,900
-16	17/32	1.0139 1.0068	.685	.5307 .5297	.4930 .4880	.010	.2027 .1997	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	42,000	25,600
-18	19/32	1.1408 1.1337	.770	.5927 .5917	.5550 .5500	.010	.2380 .2270	.050 .040	.025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.290 .270	.326 .306	52,400	32,400
-20	21/32	1.2723 1.2651	.825	.6552 .6542	.6180 .6120	.010	.2589 .2559	.050 .040	.025	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.330 .305	.326 .306	64,100	41,000
-24	25/32	1.5308 1.5236	1.050	.7802 .7792	.7430 .7370	.012	.3149 .3119	.050 .040	.025	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:

- Head edge out of roundness shall not exceed ".F."
- Concentricity: Conical surface of head to "D" diameter within .005 FTR.
- "H" dimensioned from maximum "D" diameter.
- Dimensions to be met after plating.
- Non-lubed pins must be used with wet sealant or with lubed collars.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS614.
- Curved or flat edge manufacturer's option.
- Use HL205 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 (100,000 - 140,000 psi tensile per Spec. MIL-S-6375).

FINISH: HL221-()-() - Cadmium plate per Spec. QQ-P-416, Type II, Class 2, and ethyl alcohol lube per HI-Shear Spec. 305.
HL221A-()-() - Cadmium plate per AMS2400-3 and ethyl alcohol lube per HI-Shear Spec. 305.
HL221PN-()-() - Cadmium plate per Spec. QQ-P-416, Type II, Class 2, (See Note 5.)

SPECIFICATION: HI-Lok Product Specification 342.

CODE:

First dash number indicates nominal diameter in 1/32nds which HL221 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

HL221-8-8

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

HL221A-8-8

Size and Grip Length, See Above Example

Collar Part Number

Pin Part Number

* * The Double Shear Values shown are based on cross sectional 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 191,683; 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 Hrlj	DATE 3-11-64
APPROVED M.C.	DATE 3-11-64
REVISION 8	DATE 4-24-70
hi-lok® PIN 100° FLUSH BREAKER TENSION HEAD ALLOY STEEL 1/16" GRIP VARIATION - 1/32" OVERSIZE HL221	