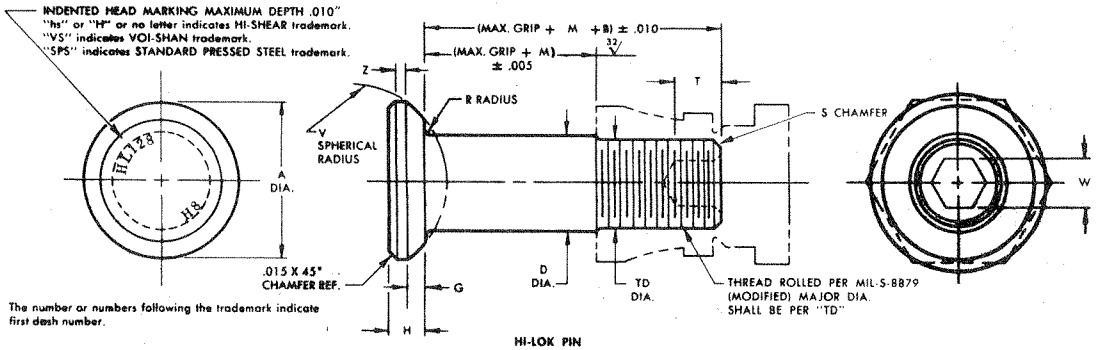
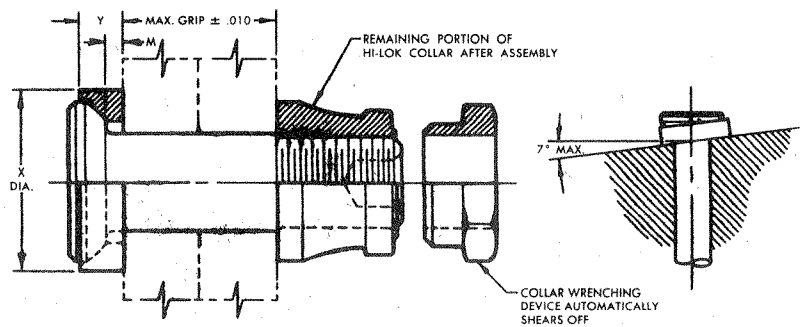
STANDARDS COMMITTEE
FOR HI-LOK® PRODUCTS
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

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



HI-LOK PIN



HI-LOK PIN, WASHER AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA. [5] WITHOUT PLATING OR SOLID FILM LUBE	D DIA. [5] WITH PLATING OR SOLID FILM LUBE	TD DIA.	G REF.	H	M REF.	R RAD.	X	Y	V SPHER. RAD. (REF.)	Z	S CHAMFER REF.	THREAD	SOCKET W HEX.	SOCKET T DEPTH
-6	3/16	.347 .337	.325	.1895 .1890	.1895 .1885	.1840 .1810	.040	.075 .065	.066	.025 .015	.365 .355	.095 .085	.200	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115
-8	1/4	.450 .440	.395	.2495 .2490	.2495 .2485	.2440 .2410	.050	.090 .080	.070	.025 .015	.475 .465	.120 .110	.265	.030 .020	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130
-10	5/16	.560 .550	.500	.3120 .3115	.3120 .3110	.3060 .3020	.065	.112 .102	.075	.030 .020	.620 .600	.130 .120	.344	.035 .025	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150
-12	3/8	.620 .610	.545	.3745 .3740	.3745 .3735	.3680 .3640	.085	.170 .160	.070	.030 .020	.685 .675	.140 .135	.385	.070 .060	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180

DOUBLE SHEAR POUNDS MINIMUM	STEEL AND TITANIUM COLLARS * HL75 HL86 HL198 HL274 — TENSION LBS. MIN.		
5,380	2,750		
9,300	5,000		
14,600	8,300		
21,000	12,700		

GENERAL NOTES: ① 1. Concentricity: "A" to "D" diameter within .010 FIR.
2. Surface texture per USAS B46.1.
3. Hole preparation per NAS618.
4. For use on sloped surfaces up to 7° maximum.
[5]. Maximum "D" diameter may be increased by .0002 to allow for solid film application.

MATERIAL: Pin — 6Al-4V titanium alloy per Spec. AMS4928 or AMS4967.
Washer — 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.

HEAT TREAT: Pin — 160,000 psi tensile minimum (95,000 psi shear minimum).
Washer — Age 17-4PH to H-1025 condition, age 17-7PH and 15-7Mo to TH1050.

FINISH: Pin — HL128A-( )-( ) = Cetyl alcohol lube per Hi-Shear Spec. 305.
HL128APB-( )-( ) = Cadmium plate per QQ-P-416, Type II, Class 3, plus cetyl alcohol lube per Hi-Shear Spec. 305.
HL128ARA-( )-( ) = Phosphate fluoride treatment plus cetyl alcohol lube.
HL128ADU-( )-( ) = Solid film lube per MIL-L-8937.
Washer — HL128WU-( ) = Passivate per Hi-Shear Spec. 258.

SPECIFICATION: Hi-Lok Product Spec. 340, Section 4.

* See reference collar standards page for detail dimensions.

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.

To prevent seizing and galling, the following combinations are recommended.

RECOMMENDED COLLARS
HL75K, HL75V, HL86D, HL198, HL198V, HL274
HL75K, HL75V, HL86D, HL198, HL198V, HL274
HL75K, HL75V, HL86D, HL198V, HL198PB, HL274
HL75K, HL75V, HL86D, HL198, HL198V, HL274

HOW TO ORDER EXAMPLES:

Pin and Washer Part Number Only
HL128AWU-8-8
- 8/16 or 1/2 Maximum Grip Length
- 8/32 or 1/4 Nominal Diameter Pin
- Pin and Washer Part Number

Pin, Washer and Collar Assembly Part Number Combination
HL128AWU86-8-8
- Size and Grip Length, See Above Example
- Collar Part Number
- Assembly of Pin and Washer

U.S. Patents 2,940,495; 3,138,987; Design 191,883. Other U.S. and Foreign Patents granted and pending. "HL" is registered in United States Patent Office.

DRAWN	DATE	
Van	4-29-69	hi-lok® PIN
APPROVED	DATE	SELF-ALIGNING TENSION HEAD TITANIUM 1/16" GRIP VARIATION
J. MILLER	10-30-69	
REVISION (2)	DATE Van 3-19-70	DRAWING NUMBER HL128