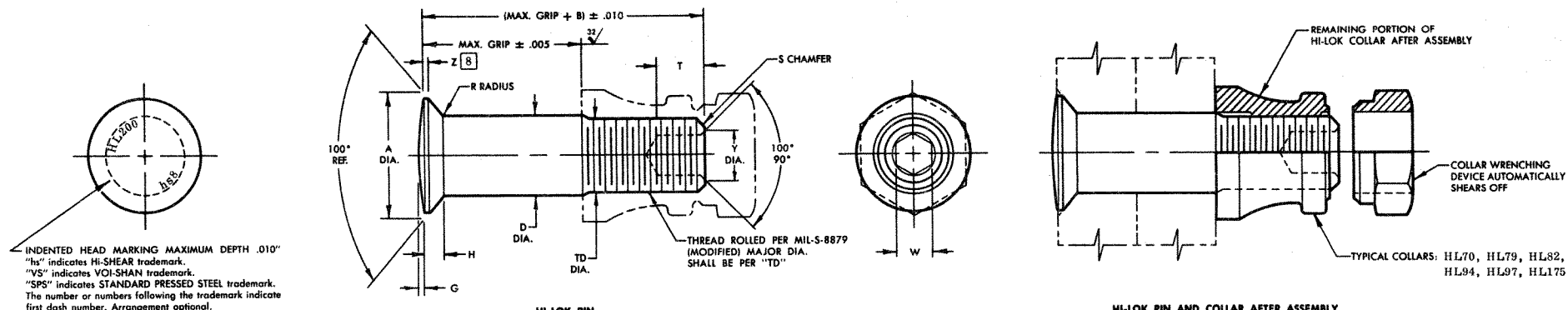


**STANDARDS COMMITTEE
FOR HI-LOK® PRODUCTS**
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

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



HI-LOK PIN

HI-LOK PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.	TD DIA.	F	G	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
													W HEX.	T DEPTH	Y DIA.		
-5	5/32	.2612	.312	.1635	.1595	.004	.010	.0410	.025	.015	1/32" x 45°	8-32UNJC-3A Modified	.0801	.100	.119	4,100	1,290
		.2564		.1625	.1570		.005	.0390	.015				.0791	.080			
-6	3/16	.3016	.325	.1895	.1840	.005	.010	.0470	.030	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806	.100	.104	5,380	2,000
		.2966		.1885	.1810		.005	.0449	.020				.0791	.080			
-8	1/4	.3948	.395	.2495	.2440	.006	.012	.0610	.030	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967	.110	.142	9,300	3,700
		.3898		.2485	.2410		.007	.0589	.020				.0947	.090			
-10	5/16	.4739	.500	.3120	.3060	.007	.015	.0680	.040	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295	.130	.180	14,600	5,000
		.4689		.3110	.3020		.010	.0659	.030				.1270	.110			
-12	3/8	.5604	.545	.3745	.3680	.008	.015	.0780	.040	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617	.160	.217	21,000	7,200
		.5554		.3735	.3640		.010	.0759	.030				.1582	.140			
-14	7/16	.6680	.635	.4370	.4310	.009	.015	.0969	.050	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930	.190	.253	28,600	10,000
		.6620		.4360	.4260		.010	.0944	.040				.1895	.170			
-16	1/2	.7540	.685	.4995	.4930	.010	.015	.1068	.050	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242	.220	.289	37,300	13,500
		.7480		.4985	.4880		.010	.1043	.040				.2207	.200			
① -18	9/16	.8380	.770	.5615	.5550	.010	.015	.1160	.050	.022	1/16" x 45°	9/16-18UNJF-3A Modified	.2555	.260	.326	47,200	17,000
		.8310		.5605	.5500		.010	.1130	.040				.2520	.240			
① -20	5/8	.9250	.825	.6240	.6180	.010	.015	.1260	.050	.022	1/16" x 45°	5/8-18UNJF-3A Modified	.2555	.260	.326	58,300	21,000
		.9180		.6230	.6120		.010	.1230	.040				.2520	.240			
① -24	3/4	1.0970	1.050	.7490	.7430	.012	.015	.1460	.050	.022	1/16" x 45°	3/4-16UNJF-3A Modified	.3185	.330	.398	83,900	30,700
		1.0850		.7480	.7370		.010	.1410	.040				.3150	.300			

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

GENERAL NOTES:

1. Head edge out of roundness shall not exceed ".F."
2. Concentricity: Conical surface of head to "D" diameter within .005 FIR.
3. "H" dimensioned from maximum "D" diameter.
4. Dimensions to be met after finish.
5. Surface texture per ANSI B46.1.
6. Hole preparation per NAS618.
7. Evidence of broken edge across points.
8. Curved or flat edge manufacturer's option.

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

HEAT TREAT: 95,000 psi shear minimum (160,000-180,000 psi tensile) per MIL-H-8875.

FINISH: HL200-() = Cadmium plating per QQ-P-416, Type II, Class 2 and cetyl alcohol lube per HI-Shear Spec. 305.

SPECIFICATION: HI-Lok Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds.
Second dash number indicates maximum grip in 1/16ths.

HOW TO ORDER EXAMPLES:

Pin Part Number Only
HL200-8-8
8/16 or 1/2 Maximum Grip Length
8/32 or 1/4 Nominal Diameter Pin
Pin Part Number

Pin and Collar Assembly Part Number Combination
HL20094-8-8
Size and Grip Length, See Above Example
Collar Part Number
Pin Part Number

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 D. Brlej	DATE 11-9-66
APPROVED J.M.	DATE 11-9-66
REVISION ②	DATE D.P.S. 9-16-76
hi-lok® PIN 100° FLUSH CROWN SHEAR HEAD ALLOY STEEL 1/16" GRIP VARIATION DRAWING NUMBER HL200	