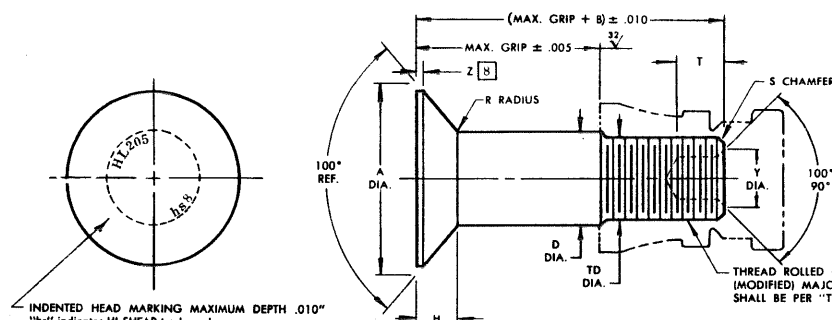
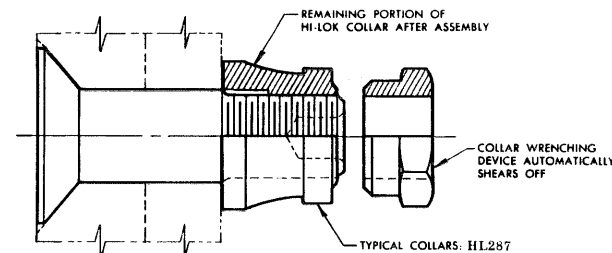
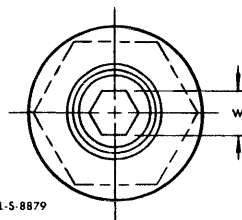


**STANDARDS COMMITTEE
FOR HI-LOK® PRODUCTS**
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) U.S. Federal Code No. 73197	HI-SHEAR FASTENERS EUROPE LTD, U.K. (Licensee)
Division of Hi-Shear Industries Inc., U.S.A.	Division of Hi-Shear Industries Inc., U.S.A.
AIR INDUSTRIES CO., INC. (Licensee - U.S. & Canada) U.S. Federal Code No. 06725	KAMAX-WERKE, Germany (Licensee - EEC Countries)
DEUTSCH FASTENER CO., INC. (Licensee) U.S. Federal Code No. 07828	Rudolph Kellerman GmbH & Co.
OPS TECHNOLOGIES, U.S.A. (Licensee) U.S. Federal Code No. 58876	ST. CHAMOND GRAMAT, S.A. France (Licensee - EEC Countries)
VOI-SHAN, Division of VSI Corp., U.S.A. (Licensee) U.S. Federal Code No. 92215	SIMMONDS, S.A. France (Licensee - EEC Countries)
WEST COAST AEROSPACE INC., U.S.A. (Licensee) U.S. Federal Code No. 60518	Collars
Plus & Steel Collars	TOKYO SCREW COMPANY, Japan (Licensee - Japan)



HI-LOK PIN



HI-LOK PIN AND COLLAR AFTER ASSEMBLY

INDENTED HEAD MARKING MAXIMUM DEPTH .010"
"hs" 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.

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	7/32										NOTE: Use HL221-6					
-6	15/64	.3813 .3765	.360	.2339 .2329	.1840 .1810	.005	.0618 .0598	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	8,160	3,180
-8	19/64	.5066 .5018	.430	.2963 .2953	.2440 .2410	.006	.0882 .0862	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	13,100	5,820
-10	23/64	.6335 .6287	.530	.3589 .3579	.3060 .3020	.007	.1152 .1132	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	19,200	9,200
-12	27/64	.7604 .7556	.575	.4214 .4204	.3680 .3640	.008	.1422 .1402	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	26,500	14,000
-14	31/64	.8884 .8812	.660	.4839 .4829	.4310 .4260	.009	.1697 .1667	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	34,900	18,900
-16	35/64	1.0139 1.0068	.710	.5464 .5454	.4930 .4880	.010	.1961 .1931	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	44,600	25,600
-18	39/64	1.1408 1.1337	.795	.6084 .6074	.5550 .5500	.010	.2234 .2204	.050 .040	.025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.290 .270	.326 .306	55,300	32,400
-20	43/64	1.2723 1.2651	.850	.6709 .6699	.6180 .6120	.010	.2523 .2493	.050 .040	.025	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.330 .305	.326 .306	67,200	41,000
-24	51/64	1.5308 1.5236	1.075	.7959 .7949	.7430 .7370	.012	.3083 .3053	.050 .040	.025	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.395 .365	.398 .378	94,500	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 FIR.
 - "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 NAS618.
 - Curved or flat edge manufacturer's option.

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

HEAT TREAT: 160,000–180,000 psi tensile per Spec. MIL-H-6875.

- FINISH:**
- HL205-()-() = Cadmium plate per Spec. QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL205A-()-() = Cadmium plate per AMS2400-3 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL205PN-()-() = Cadmium plate per QQ-P-416, Type II, Class 2.

SPECIFICATION: Hi-Lok Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL205 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

HL205-8-8
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

HL205287-8-8
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.

"Hi-Lok" and "HL" are internationally registered trademarks of Hi-Shear Corporation.	
DRAWN Brlej	DATE 3-20-64
100° FLUSH MS24694 TENSION HEAD ALLOY STEEL 1/16" GRIP VARIATION - 3/64" OVERSIZE	
APPROVED M. C.	DATE 3-20-64
REVISION 8	DATE D. P. S. 7-13-92
DRAWING NUMBER HL205	