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FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	
												W HEX	T DEPTH	Y DIA			
5	7/32			NOTE: Use HL255-6													
6	15/64	.3536 .3486	.360	.2339 .2329	.1840 .1810	.005	.0502 .0481	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	8,160	2,590	
8	19/64	.4732 .4682	.430	.2963 .2953	.2440 .2410	.006	.0742 .0721	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	13,100	4,760	
10	23/64	.5619 .5569	.530	.3589 .3579	.3060 .3020	.007	.0852 .0831	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	19,200	7,100	
12	27/64	.6912 .6862	.575	.4214 .4204	.3680 .3640	.008	.1132 .1111	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	26,500	10,600	
14	31/64	.8041 .7969	.660	.4839 .4829	.4310 .4260	.009	.1343 .1313	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	34,900	14,450	
16	35/64	.9166 .9095	.710	.5464 .5454	.4930 .4880	.010	.1553 .1523	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	44,600	19,550	

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 are in inches and to be met after plating.
 - Surface texture per ASME B46.1.
 - Hole preparation per NAS618.
 - Curved or flat edge manufacturer's option.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL207 oversize pin replace.
 Second dash number indicates maximum grip in 1/16ths.

HOW TO ORDER
EXAMPLE:

Pin Part Number
 HL207-8-8
 8/16 or 1/2 Maximum Grip Length
 8/32 or 1/4 Nominal Diameter Pin
 Pin Basic Part Number with Type II Cadmium Plate

****** The Double Shear values shown are based on cross sectional area for nominal diameter pin.

MATERIAL: 5 Alloy steel per Spec. AMS6415, AMS6349 or AMS6322

HEAT TREAT: 5 95,000 psi shear minimum (160,000-180,000 psi tensile per Spec. AMS-H-6875).

FINISH: 5 HL207-()-() = Cadmium plate per Spec. AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LOK™ Product Specification 342.

Pin and Collar Assembly Part Number Combination
 HL207279-8-8
 Size and Grip Length - See Above Example
 Collar Part Number
 Pin Part Number

"HI-LOK", "HL", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY BRLEJ	DATE 1964-03-20	TITLE HI-LOK™ PIN 100° FLUSH CLOSE TOLERANCE AN426 HEAD ALLOY STEEL 1/16 GRIP VARIATION - 3/64 OVERSIZE	
APPROVED CESSNA	DATE 1964-03-20		
REVISION 5	DATE K. TRAN 2017-11-09	DRAWING NUMBER HL207	