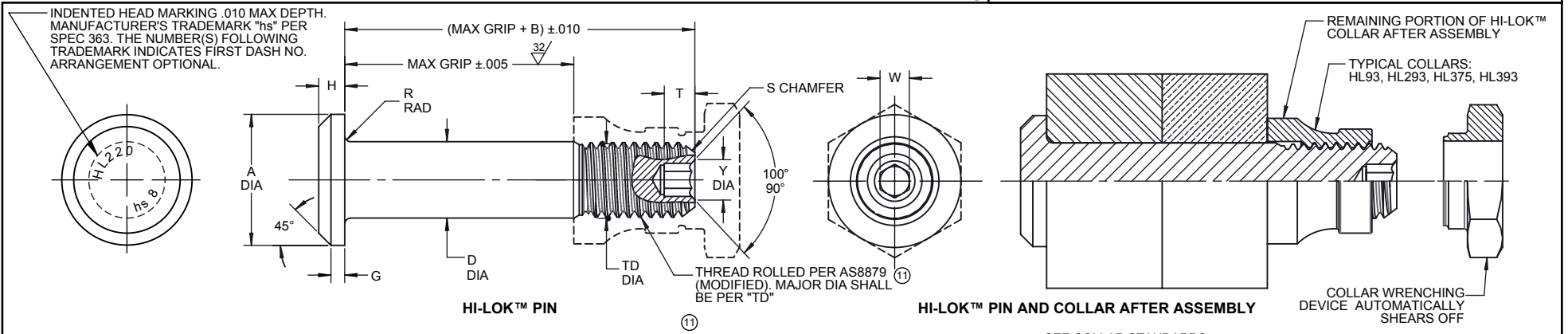




FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
											W HEX	T DEPTH	Y DIA		
5					NOTE: USE HL64-6-()										
6	7/32	.390 .370	.325	.2182 .2172	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	7,100	3,180
8	9/32	.460 .435	.395	.2807 .2797	.2440 .2410	.045	.090 .077	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	11,800	5,820
10	11/32	.520 .490	.500	.3432 .3422	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	17,600	9,200
12	13/32	.585 .550	.545	.4057 .4047	.3680 .3640	.065	.140 .130	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	24,600	14,000
14	15/32	.650 .615	.635	.4682 .4672	.4310 .4260	.075	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	32,700	18,900
16	17/32	.775 .740	.685	.5307 .5297	.4930 .4880	.085	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	42,000	25,600
18	19/32	.905 .870	.770	.5927 .5917	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	52,400	32,400
20	21/32	.975 .940	.825	.6552 .6542	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	64,100	41,000
24	25/32	1.185 1.145	1.050	.7802 .7792	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.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:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 2. Dimensions are in inches and to be met after plating.
 3. Surface texture per ASME B46.1.
 4. Non-lubed pins must be used with wet sealant or with lubed collars.
 5. Hole preparation per NAS618.
 6. Use HL204 for oversize replacement.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL220 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER
EXAMPLE:

Pin Part Number
HL220AH-8-8
└─ 8/16 or 1/2 Maximum Grip Length
└─ Replaces 8/32 or 1/4 Nominal Diameter Pin
└─ Finish Code
└─ Pin Basic Part Number

Pin and Collar Assembly Part Number Combination
HL22093-8-8
└─ 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 BRIEJ	DATE 1964-03-11	TITLE HI-LOK™ PIN PROTRUDING TENSION HEAD ALLOY STEEL 1/16 GRIP VARIATION, 1/32 OVERSIZE	
APPROVED M.C.	DATE 1964-03-11		
REVISION 11	DATE K. TRAN 2017-09-26	DRAWING NUMBER HL220	

SPECIFICATION: HI-LOK™ Product Specification 342.