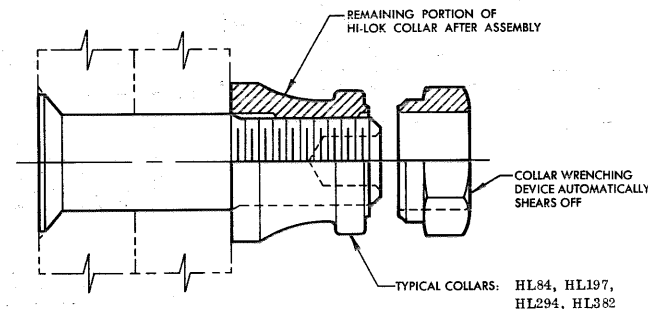
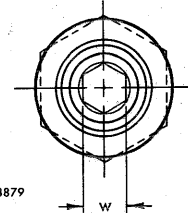
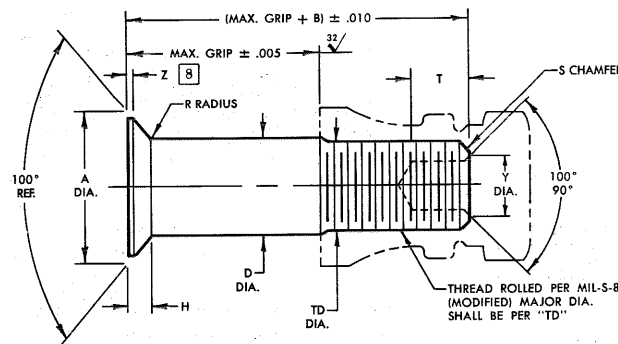
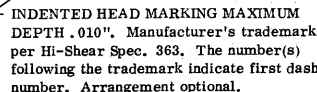


2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

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HI-LOK PIN

HI-LOK PIN AND COLLAR AFTER ASSEMBLY

[illegible]

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

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. Non-lubed pins must be used with wet sealant or with lubed collars.
6. Surface texture per ANSI B46.1.
7. Hole preparation per NAS618.
8. Curved or flat edge manufacturer's option.
9. Oversize pin for HL61 and HL53.

HEAT TREAT: 125,000 psi shear minimum

⑥ **FINISH:** HL459-(-)(-) = Cadmium plate per QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL459AP-(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL459KR-(-)(-) = Cadmium plate per QQ-P-416, Type II, Class 2, with red identification on top of head, and cetyl alcohol lube per Hi-Shear Spec. 305.
[5] HL459PN-(-)(-) = Cadmium plate per QQ-P-416, Type II, Class 2.
HL459TB-(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.

⑫ **CODE:** First dash number indicates nominal diameter in 1/32nds of the pin which HL459 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See "Finish" note for explanation of code letters.

Pin Part Number Only
HL459-8-8

- 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
HL45984-8-8

_____ Size and Grip Length, See Above Example
 _____ Collar Part Number
 _____ Pin Part Number

"Hi-Lok" and "HL" are internationally registered trademarks of Hi-Shear Corporation

hi-lok® PIPING

100° FLUSH SHEAR HEAD
TYPE 431 STAINLESS

1/16" GRIP VARIATION - 1/32" OVERSIZE

REVISION
 12
 DATE
 T. Crain
 2-15-93

DRAWING NUMBER

HL459

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