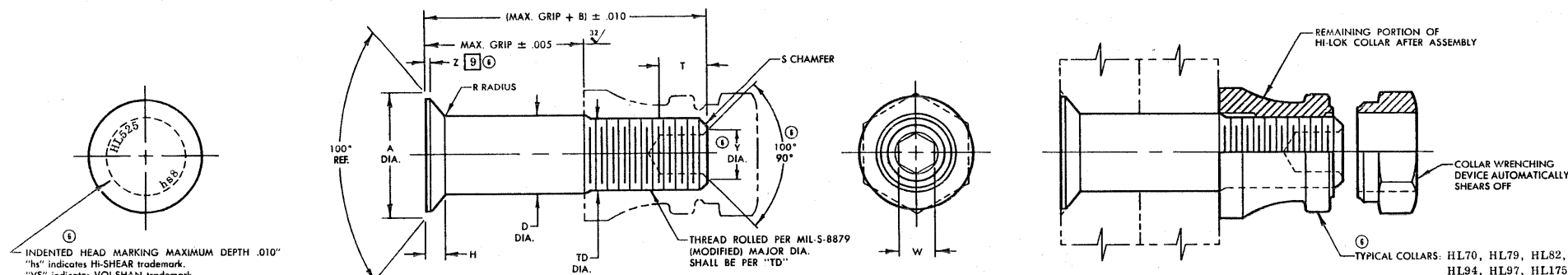


**STANDARD COMMITTEE  
FOR HI-LOK® PRODUCTS**  
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

HI-SHEAR CORPORATION (Patent Holder) — Federal Code Ident. No. 73197  
① 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    | H              | R RAD.       | Z MAX. | S CHAMFER REF. | THREAD                     | SOCKET         |              | DOUBLE SHEAR POUNDS MINIMUM | TENSION POUNDS MINIMUM |
|----------------|-----------|----------------|--------|----------------|----------------|------|----------------|--------------|--------|----------------|----------------------------|----------------|--------------|-----------------------------|------------------------|
|                |           |                |        |                |                |      |                |              |        |                |                            | W HEX.         | T DEPTH      |                             |                        |
| — 5            | 5/32      | .2922<br>.2874 | .312   | .1635<br>.1625 | .1595<br>.1570 | .004 | .0540<br>.0520 | .025<br>.015 | .010   | 1/32" x 45°    | 8-32UNJC-3A<br>Modified    | .0801<br>.0791 | .135<br>.115 | 4,010                       | 1,730                  |
| — 6            | 3/16      | .3536<br>.3486 | .325   | .1895<br>.1885 | .1840<br>.1810 | .005 | .0688<br>.0667 | .030<br>.020 | .015   | 1/32" x 45°    | 10-32UNJF-3A<br>Modified   | .0806<br>.0791 | .135<br>.115 | 5,380                       | 2,590                  |
| — 8            | 1/4       | .4732<br>.4682 | .395   | .2495<br>.2485 | .2440<br>.2410 | .006 | .0939<br>.0918 | .030<br>.020 | .015   | 1/32" x 45°    | 1/4-28UNJF-3A<br>Modified  | .0967<br>.0947 | .150<br>.130 | 9,300                       | 4,760                  |
| — 10           | 5/16      | .5619<br>.5569 | .500   | .3120<br>.3110 | .3060<br>.3020 | .007 | .1048<br>.1027 | .040<br>.030 | .015   | 3/64" x 45°    | 5/16-24UNJF-3A<br>Modified | .1295<br>.1270 | .170<br>.150 | 14,600                      | 7,100                  |
| — 12           | 3/8       | .6912<br>.6862 | .545   | .3745<br>.3735 | .3680<br>.3640 | .008 | .1329<br>.1308 | .040<br>.030 | .015   | 3/64" x 45°    | 3/8-24UNJF-3A<br>Modified  | .1617<br>.1582 | .200<br>.180 | 21,000                      | 10,600                 |
| — 14           | 7/16      | .8041<br>.7969 | .635   | .4370<br>.4360 | .4310<br>.4260 | .009 | .1540<br>.1510 | .050<br>.040 | .022   | 3/64" x 45°    | 7/16-20UNJF-3A<br>Modified | .1930<br>.1895 | .230<br>.210 | 28,600                      | 14,450                 |
| — 16           | 1/2       | .9166<br>.9095 | .685   | .4995<br>.4985 | .4930<br>.4880 | .010 | .1750<br>.1720 | .050<br>.040 | .022   | 3/64" x 45°    | 1/2-20UNJF-3A<br>Modified  | .2242<br>.2207 | .260<br>.240 | 37,300                      | 19,550                 |

① 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.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- Use HL527 for oversize replacement.
- Evidence of broken edge across points.
- Curved or flat edge manufacturer's option.

① MATERIAL: Alloy steel per Spec. MIL-S-5000, MIL-S-5626 or MIL-S-6049.

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

① FINISH: HL525-( )-( ) = Cadmium plate per Spec. QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

① 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

HL525-8-8

8/16 or 1/2 Maximum Grip Length

8/32 or 1/4 Nominal Diameter Pin

Pin Part Number with Type II Cadmium Plate

Pin and Collar Assembly Part Number Combination

HL52570-8-8

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  
R.K.L. 12-15-61  
APPROVED  
MEC. 12-15-61  
REVISION  
① D. P. S. 9-11-74

hi-lok® PIN

100° FLUSH MS20426 HEAD  
ALLOY STEEL  
1/16" GRIP VARIATION

DRAWING NUMBER  
HL525

HL525