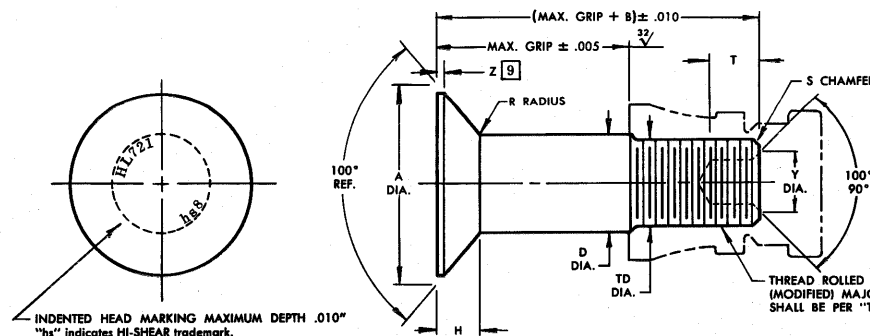


FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.	TD DIA.	F	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
												W HEX.	T DEPTH	Y DIA.		
—5	5/32	.3304 .3256	.312	.1635 .1625	.1595 .1570	.004	.0700 .0680	.025 .015	.010	1/32" x 45°	8-32UNJC-3A Modified	.0801 .0791	.135 .115	8	4,560	2,450
—6	3/16	.3813 .3765	.325	.1895 .1885	.1840 .1810	.005	.0805 .0785	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	6,125	3,850
—8	1/4	.5066 .5018	.395	.2495 .2485	.2440 .2410	.006	.1080 .1060	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	10,600	6,550
—10	5/16	.6335 .6287	.500	.3120 .3110	.3060 .3020	.007	.1350 .1330	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	16,600	10,350
—12	3/8	.7604 .7556	.545	.3745 .3735	.3680 .3640	.008	.1620 .1600	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	23,900	15,750
—14	7/16	.8884 .8812	.635	.4370 .4360	.4310 .4260	.009	.1895 .1865	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	32,500	21,200
—16	1/2	1.0139 1.0068	.685	.4995 .4985	.4930 .4880	.010	.2160 .2130	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	42,400	28,800
—18	9/16	1.1408 1.1337	.770	.5615 .5605	.5550 .5500	.010	.2430 .2400	.050 .040	.025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.290 .270	.326 .306	53,700	36,400
—20	5/8	1.2723 1.2651	.825	.6240 .6230	.6180 .6120	.010	.2720 .2690	.050 .040	.025	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.330 .305	.326 .306	66,300	46,100
—24	3/4	1.5308 1.5236	1.050	.7490 .7480	.7430 .7370	.012	.3280 .3250	.050 .040	.025	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.395 .365	.398 .378	95,400	66,900

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" is dimensioned from maximum "D" diameter.
 - Dimensions to be met after finish.
 - Non-lubed pins must be used with wet sealant or with lubed collars.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - Evidence of broken edge across points.
 - Curved or flat edge manufacturer's option.
 - Use HL765 for oversize replacement.
 - Maximum "D" diameter may be increased by .0002 to allow for plating or coating application.

MATERIAL: Alloy steel per Spec. MIL-S-5000, MIL-S-5626 or MIL-S-6049.
HEAT TREAT: 180,000-200,000 psi tensile per Spec. MIL-H-6875.
FINISH: HL721-()-() = Cadmium plate per Spec. QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL721BJ-()-() = I.V.D. aluminum coating per MIL-C-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
Ⓢ HL721BV-()-() = I.V.D. aluminum coating per MIL-C-83488, Type II, Class 3, with color code blue on thread end.
Ⓢ HL721PN-()-() = Cadmium plate per Spec. QQ-P-416, Type II, Class 2.
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.
See "Finish" note for explanation of code letters.

HOW TO ORDER EXAMPLES:

Pin Part Number Only
HL721-8-8
— 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
HL72186-8-8
— Size and Grip Length, See Above Example
— Collar Part Number
— Pin Part Number

U.S. patents 3,390,906; and foreign patents. "Hi-Lok" and "HL" are Registered Trademarks of Hi-Shear Corporation.	
DRAWN Briej	DATE 2-17-65
APPROVED Cessna	DATE 2-17-65
REVISION 12	DATE D. P. S. 12-2-82
hi-lok® PIN 100° FLUSH MS24694 TENSION HEAD ALLOY STEEL 1/16" GRIP VARIATION HL721	