



1						8			13					**		
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	13/64					Use: HL63-6										
6	7/32	.3303 .3253	.325	.2182 .2172	.1840 .1810	.005	.0470 .0449	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	7,100	2,000
8	9/32	.4260 .4210	.395	.2807 .2797	.2440 .2410	.006	.0610 .0589	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	11,800	3,700
10	11/32	.5051 .5001	.500	.3432 .3422	.3060 .3020	.007	.0679 .0658	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	17,600	5,000
12	13/32	.5916 .5866	.545	.4057 .4047	.3680 .3640	.008	.0780 .0759	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	24,600	7,200
14	15/32	.6992 .6932	.635	.4682 .4672	.4310 .4260	.009	.0969 .0944	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	32,700	10,000
16	17/32	.7852 .7792	.685	.5307 .5297	.4930 .4880	.010	.1068 .1043	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	42,000	13,500
18	19/32	.8692 .8622	.770	.5927 .5917	.5550 .5500	.010	.1160 .1131	.050 .040	.022	1/16 x 45°	.5625-1 UNJF-3A	.2555 .2520	.290 .270	.326 .306	52,400	17,000
20	21/32	.9562 .9492	.825	.6552 .6542	.6180 .6120	.010	.1263 .1233	.050 .040	.022	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	64,100	21,000
24	25/32	1.1282 1.1162	1.050	.7802 .7792	.7430 .7370	.012	.1460 .1410	.050 .040	.022	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	90,900	30,700
28	29/32	1.3509 1.3342	1.210	.9052 .9042	.8680 .8610	.014	.1870 .1800	.050 .040	.022	5/64 x 45°	.8750-14 UNJF-3A	.3820 .3780	.455 .425	.471 .451	122,000	42,000
32	1-1/32	1.5498 1.5307	1.390	1.0302 1.0292	.9930 .9860	.014	.2180 .2100	.050 .040	.022	5/64 x 45°	1.0000-12 UNJF-3A	.5100 .5040	.580 .550	.618 .598	158,000	55,000

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

** The double Shear Values shown are based on cross sectional area for nominal pin diameter.

"HI-LOK", "HL", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION		
DRAWN BY BRLEJ	DATE 1964-03-11	TITLE HI-LOK™ PIN 100° FLUSH SHEAR HEAD ALLOY STEEL 1/16 GRIP VARIATION-1/32 OVERSIZE
APPROVED CESSNA	DATE 1964-03-11	
REVISION 13	DATE K. TRAN 2017-11-13	DRAWING NUMBER HL219

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 are in inches and to be met after plating.
5. Surface texture per ASME B46.1.
6. Hole preparation per NAS618.
7. Use HL203 for oversize replacement.
8. Curved or flat edge manufacturer's option.

⑬ Alloy steel per Spec. AMS6415, AMS6349, AMS6322, AMS6484, AMS6382, AMS6325 or AMS6327.

: (13) 95,000 psi shear minimum (160,000-180,000 psi tensile per Spec. AMS-H-6875).

⑬ HL219-()-() = Cadmium plate per Spec. AMS-QQ-P-416, Type II, Class 2, color bronze, and cetyl alcohol lube per Hi-Shear Spec. 305.

HL219A-()-() = Cadmium plate per AMS2400-3 and cetyl alcohol lube per Hi-Shear Spec. 305.

HI-LOK™ Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds which HL219 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See "Finish" note for explanation of code letters.

⑬ EXAMPLE:

Pin Part Number
HL219A-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

HL21984-8-8

HL21984 8 8

Size and Grip Length,
See Above Example

Collar Part Number

Pin Part Number

H219

HL219

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