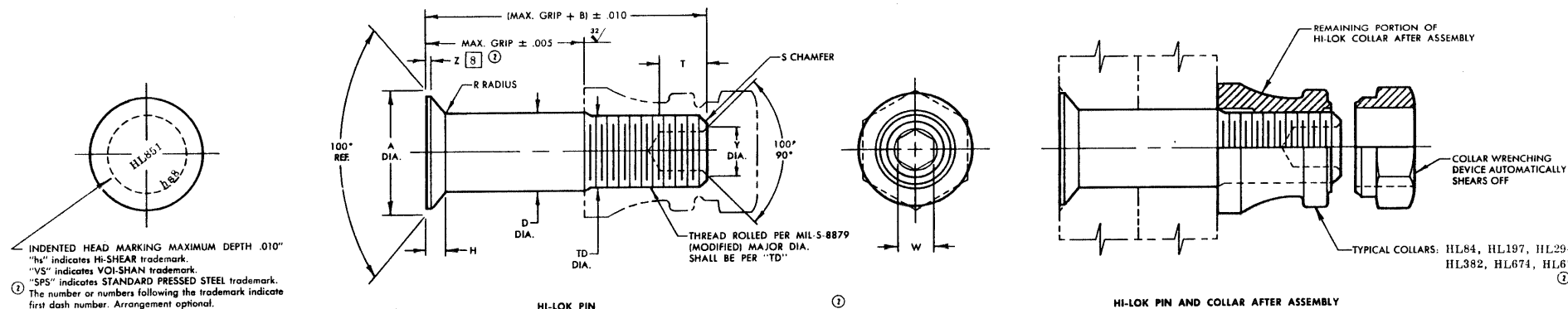


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

HI-SHEAR CORPORATION (Patent Holder) — Federal Code Ident. No. 73197
VOI-SHAN DIV., VSI CORP. (Licensee) — Federal Code Ident. No. 92215
STANDARD PRESSED STEEL CO. (Licensee) — Federal Code Ident. No. 56878



HI-LOK PIN										①	⑧	HI-LOK PIN AND COLLAR AFTER ASSEMBLY									
FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA. ⑦		TD DIA.	F	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET			** DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM				
				WITHOUT SOLID FILM LUBE	WITH SOLID FILM LUBE								W HEX.	T DEPTH	Y DIA.						
- 5	13/64			NOTE: Use HL751-6																	
① - 6	7/32	.3303 .3253	.325	.2182 .2177	.2182 .2172	.1840 .1810	.005	.0470 .0450	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	9,400	2,600				
②																					
- 8	9/32	.4260 .4210	.395	.2807 .2802	.2807 .2797	.2440 .2410	.006	.0610 .0590	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	15,500	4,400				
- 10	11/32	.5051 .5001	.500	.3432 .3427	.3432 .3422	.3060 .3020	.007	.0680 .0660	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	23,200	7,000				
- 12	13/32	.5916 .5866	.545	.4057 .4052	.4057 .4047	.3680 .3640	.008	.0780 .0760	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	32,400	10,000				
- 14	15/32	.6992 .6932	.635	.4682 .4677	.4682 .4672	.4310 .4260	.009	.0969 .0944	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	43,100	12,500				
- 16	17/32	.7852 .7792	.685	.5307 .5302	.5307 .5297	.4930 .4880	.010	.1068 .1043	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	55,400	18,000				
- 18	19/32	.8692 .8622	.770	.5927 .5922	.5927 .5917	.5550 .5500	.010	.1160 .1130	.050 .040	.022	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	69,200	22,500				
- 20	21/32	.9562 .9492	.825	.6552 .6547	.6552 .6542	.6180 .6120	.010	.1260 .1230	.050 .040	.022	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	84,500	28,000				
- 24	25/32	1.1282 1.1162	1.050	.7802 .7797	.7802 .7792	.7430 .7370	.012	.1460 .1410	.050 .040	.022	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.330 .300	.398 .378	120,000	40,200				
- 28	29/32	1.3509 1.3342	1.210	.9052 .9047	.9052 .9042	.8680 .8610	.014	.1870 .1800	.050 .040	.022	5/64" x 45°	7/8-14UNJF-3A Modified	.3820 .3780	.400 .370	.471 .451	161,000	54,000				
- 32	1-1/32	1.5498 1.5307	1.390	1.0302 1.0297	1.0302 1.0292	.9930 .9860	.014	.2180 .2100	.050 .040	.022	5/64" x 45°	1-12UNJF-3A Modified	.5100 .5040	.520 .490	.618 .598	209,000	72,000				

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.
 - Surface texture per ANSI B46.1.②
 - Hole preparation per NAS618.
 - Maximum "D" diameter may be increased by .0002 to allow for solid film application.
 - ⑧ Curved or flat edge manufacturer's option.
- MATERIAL: PH13-8Mo stainless steel per Spec. AMS5629.
HEAT TREAT: 125,000 psi shear minimum.
FINISH: HL851-()-() = Solid film lube per Spec. MIL-L-8937.
HL851LL-()-() = Passivate per HI-Shear Spec. 258 and cetyl alcohol lube per HI-Shear Spec. 305.
- ⑨ HL851TB-()-() = HI-Kote 2 solid film lube per HI-Shear Spec. 292 and cetyl alcohol lube per HI-Shear Spec. 305.
- SPECIFICATION: HI-Lok Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds which HL851 oversize pin replaces.
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
HL851-8-8
8/16 or 1/2 Maximum Grip Length
Replaces 8/32 or 1/4 Nominal Diameter Pin
Pin Part Number

Pin and Collar Assembly Part Number Combination
HL85184-8-8
Size and Grip Length, See Above Example
Collar Part Number
Pin Part Number

** The Double Shear values shown are based on cross sectional area for nominal diameter pin.

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 VAN 11-19-71	DATE
APPROVED R. J. 11-22-71	DATE
REVISION ② VAN 1-10-75	DATE
hi-Lok[®] PIN 100° FLUSH SHEAR HEAD PH13-8Mo STAINLESS STEEL 1/16" GRIP VARIATION - 1/32" OVERSIZE DRAWING NUMBER HL851	