



HI-LOK™ PIN											SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	W HEX	T DEPTH	Y DIA		
-5	7/32					NOTE: Use HL220-6									
-6	15/64	.400 .380	.360	.2339 .2329	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	8,160	3,180
-8	19/64	.470 .445	.430	.2963 .2953	.2440 .2410	.045	.090 .077	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	13,100	5,820
-10	23/64	.530 .500	.530	.3589 .3579	.3060 .3020	.055	.112 .098	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	19,200	9,200
-12	27/64	.595 .560	.575	.4214 .4204	.3680 .3640	.065	.140 .130	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	26,500	14,000
-14	31/64	.660 .625	.660	.4839 .4829	.4310 .4260	.075	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	34,900	18,900
-16	35/64	.785 .750	.710	.5464 .5454	.4930 .4880	.085	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	44,600	25,600
-18	39/64	.920 .885	.795	.6084 .6074	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	55,300	32,400
-20	43/64	.990 .955	.850	.6709 .6699	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	67,200	41,000
-24	41/64	1.200 1.160	1.075	.7959 .7949	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	94,500	59,500

HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIR.
 - ⑨ 2. Dimensions are in inches and to be met after plating.
 - ③ Non-lubed pins must be used with wet sealant or with lubed collars.
 - ④ 4. Surface texture per ASME B46.1.
 5. Hole preparation per NAS618.

MATERIAL: ⑨ Alloy steel per Spec. AMS6415, AMS6382 or AMS6322.

HEAT TREAT: ⑨ 160,000-180,000 psi tensile per Spec. AMS-H-6875.

FINISH: ⑨ HL204-(-)(-) = Cadmium plate per Spec. AMS-QQ-P-416, Type II, Class 2, Cetyl alcohol lube per Hi-Shear Spec. 305.
 HL204A-(-)(-) = Cadmium plate per Spec. AMS2400-3, and cetyl alcohol lube per Hi-Shear Spec. 305.
 ⑨ ③ HL204PN-(-)(-) = Cadmium plate per Spec. AMS-QQ-P-416, Type II, Class 2.

SPECIFICATION: HI-LOK™ Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL204 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER

⑨ EXAMPLE:

Pin Part Number
HL204PN-8-8
 — 8/16 or 1/2 Maximum Grip Length
 — 8/32 or 1/4 Nominal Diameter Pin
 — Finish Code
 — Pin Basic Part Number

Pin and Collar Assembly Part Number Combination
HL204287-8-8

— 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.**

"HI-LOK", "HL", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY BRIEJ	DATE 1964-04-14	TITLE HI-LOK™ PIN PROTRUDING TENSION HEAD ALLOY STEEL 1/16 GRIP VARIATION, 3/64 OVERSIZE	
APPROVED CESSNA	DATE 1964-04-14		
REVISION 9	DATE F.CARINGELLA 2017-11-07	DRAWING NUMBER HL204	