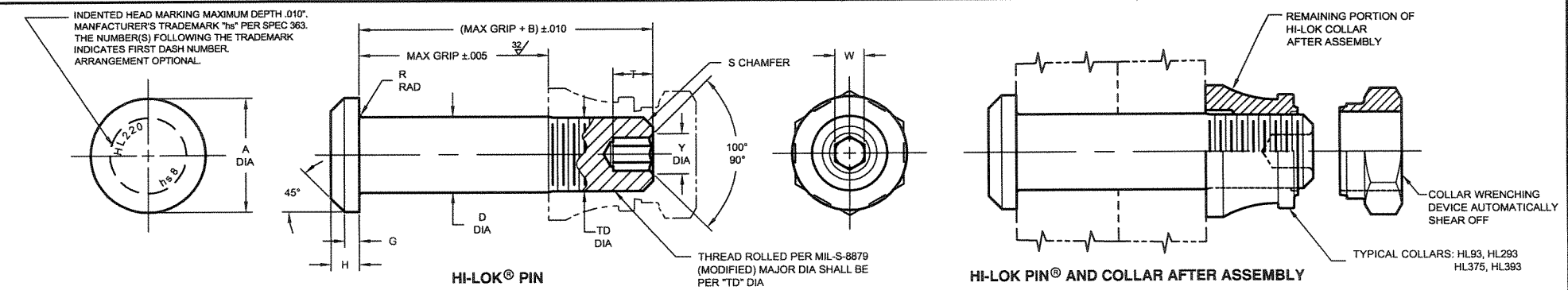


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197	BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE No. OLB68
a LISI AEROSPACE Company	a LISI AEROSPACE Company
AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A & Canada) CAGE No. 06725	HUCK S.A. France (Licensee - ECC Countries)
HUXO INTERNATIONAL, INC., U.S.A. (Licensee) CAGE No. 97928	BLANC AERO S.A. France (Licensee - ECC Countries)
SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878	a LISI AEROSPACE Company
FAIRCHILD Aerospace Fastener Division (Licensee) CAGE No. 92215	TOKYO SCREW COMPANY, Japan (Licensee - Japan)
WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516	

(Pins & Steel Collars)



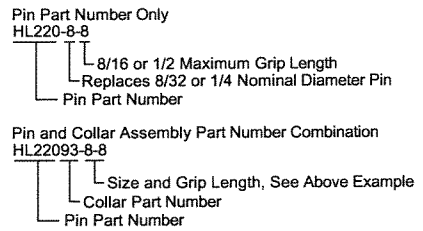
FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
											W HEX	T DEPTH	Y DIA		
5															
NOTE: USE HL64-6(-)															
6	7/32	.390 .370	.325	.2182 .2172	.1840 .1810	.035	.074 .064	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	7,100	3,180
8	9/32	.460 .435	.395	.2807 .2797	.2440 .2410	.045	.090 .077	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	11,800	5,820
10	11/32	.520 .490	.500	.3432 .3422	.3060 .3020	.055	.112 .102	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	17,600	9,200
12	13/32	.585 .550	.545	.4057 .4047	.3680 .3640	.065	.140 .130	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	24,600	14,000
14	15/32	.650 .615	.635	.4682 .4672	.4310 .4260	.075	.160 .150	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	32,700	18,900
16	17/32	.775 .740	.685	.5307 .5297	.4930 .4880	.085	.188 .178	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	42,000	25,600
18	19/32	.905 .870	.770	.5927 .5917	.5550 .5500	.125	.210 .200	.040 .025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.290 .270	.326 .306	52,400	32,400
20	21/32	.975 .940	.825	.6552 .6542	.6180 .6120	.140	.238 .228	.040 .025	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.330 .305	.326 .306	64,100	41,000
24	25/32	1.185 1.145	1.050	.7802 .7792	.7430 .7370	.200	.335 .320	.045 .030	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.395 .365	.398 .378	90,900	59,500

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

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 2. Dimensions to be met after plating.
 3. Surface texture per ANSI B46.1.
 4. Non-lubed pins must be used with wet sealant or with lubed collars.
 5. Hole preparation per NAS618.
 6. Use HL204 for oversize replacement.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL220 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER EXAMPLE:



- MATERIAL:** Alloy steel per AMS-S-6049, AMS6322; AMS6349, AMS6382; AMS6415.
- HEAT TREAT:** 95,000 psi shear minimum (160,000-180,000 psi tensile per AMS-H-6875).
- FINISH:** HL220(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL220A(-)(-) = Cadmium plate per AMS2400-3, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL220PN(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2. (See Note 4).
- SPECIFICATION:** Hi-Lok Product Specification 342.

DRAWN		DATE		TITLE HI-LOK® PIN PROTRUDING TENSION HEAD ALLOY STEEL 1/16" GRIP VARIATION, 1/32" OVERSIZE	
Brlfej		3-11-64			
APPROVED		DATE		DRAWING NUMBER HL220	
M.C.		3-11-64			
REVISION		DATE			
(10)		J.F.O. 5-1-2003			

HL220