

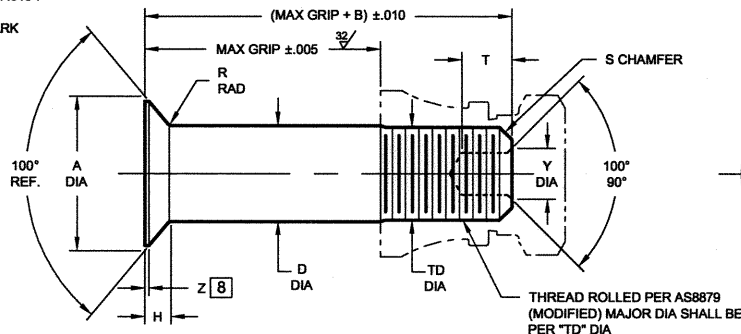
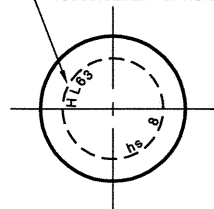
STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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

19 HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
a LISI AEROSPACE Company
AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A. & Canada) CAGE No. 06725
HUCK INTERNATIONAL, INC., U.S.A. (Licensee) CAGE No. 97928
SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878
FAIRCHILD Aerospace Fastener Division (Licensee) CAGE No. 92215
WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516
(Pins & Steel Collars)

BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE No. 0LB68
a LISI AEROSPACE Company
HUCK S.A. France (Licensee - ECC Countries)
BLANC AERO S.A. France (Licensee - ECC Countries)
a LISI AEROSPACE Company
TOKYO SCREW COMPANY, Japan (Licensee - Japan)

INDENTED HEAD MARKING MAXIMUM DEPTH .010".
"hs" INDICATES HI-SHEAR TRADEMARK.
THE NUMBER(S) FOLLOWING THE TRADEMARK
INDICATES FIRST DASH NUMBER.
ARRANGEMENT OPTIONAL.



HI-LOK® PIN

FIRST DASH NO.	PIN 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																
NOTE: USE HL19()6-() or HL419()6-()																
6	13/64	.3016 .2966	.325	.2026 .2016	.1840 .1810	.005		.0415 .0394	.030 .020	.015	1/32" x 45°	.0806 .0791	.135 .115	.119 .104	6,130	2,000
8	17/64	.3948 .3898	.395	.2651 .2641	.2440 .2410	.006		.0544 .0523	.030 .020	.015	1/32" x 45°	.0967 .0947	.150 .130	.142 .122	10,490	3,700
10	21/64	.4739 .4689	.500	.3276 .3266	.3060 .3020	.007		.0614 .0593	.040 .030	.015	3/64" x 45°	.1295 .1270	.170 .150	.180 .160	16,000	5,000
12	25/64	.5604 .5554	.545	.3901 .3891	.3680 .3640	.008		.0714 .0693	.040 .030	.015	3/64" x 45°	.1617 .1582	.200 .180	.217 .197	22,700	7,200
14	29/64	.6680 .6620	.635	.4526 .4516	.4310 .4260	.009		.0904 .0879	.050 .040	.022	3/64" x 45°	.1930 .1895	.230 .210	.253 .233	30,600	10,000
16	33/64	.7540 .7480	.685	.5151 .5141	.4930 .4880	.010		.1002 .0977	.050 .040	.022	3/64" x 45°	.2242 .2207	.260 .240	.289 .269	39,600	13,500
18	37/64	.8380 .8310	.770	.5771 .5761	.5550 .5500	.010		.1094 .1065	.050 .040	.022	1/16" x 45°	.2555 .2520	.290 .270	.326 .306	49,700	17,000
20	41/64	.9250 .9180	.825	.6396 .6386	.6180 .6120	.010		.1197 .1168	.050 .040	.022	1/16" x 45°	.2555 .2520	.330 .305	.326 .306	61,000	21,000
24	49/64	1.0970 1.0850	1.050	.7646 .7636	.7430 .7370	.012		.1394 .1344	.050 .040	.022	1/16" x 45°	.3185 .3150	.395 .365	.398 .378	87,200	30,700
28	57/64	1.3197 1.3030	1.210	.8896 .8886	.8680 .8610	.014		.1804 .1734	.050 .040	.022	5/64" x 45°	.3820 .3780	.455 .425	.471 .451	118,000	42,000
32	1-1/64	1.5186 1.4995	1.390	1.0146 1.0136	.9930 .9860	.014		.2114 .2034	.050 .040	.022	5/64" x 45°	.5100 .5040	.580 .550	.618 .598	154,000	55,000

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .005 FIM.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions to be met after finish.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - Use HL219 for oversize replacement.
 - Curved or flat edge manufacturer's option.

MATERIAL: Alloy steel per AMS6415, AMS6349, or AMS-S-6049.

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

FINISH:

HL63-()-() = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

HL63A()-() = Cadmium plate per AMS2400-3 and cetyl alcohol lube per Hi-Shear Spec. 305.

HL63PB()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, 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 of the pin which HL63 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

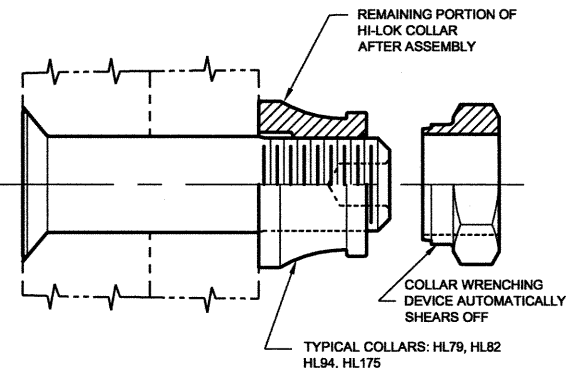
HOW TO ORDER EXAMPLE:

Pin Part Number Only
HL63PB8-8

8/16 or 1/2 Maximum Grip Length
Replaces 8/32 or 1/4 Nominal Diameter Pin
Type II Cadmium Plating
Pin Part Number

Pin and Collar Assembly Part Number Combination
HL63PB79-8-8

Size and Grip Length, See Above Example
Collar Part Number
Pin Finish
Pin Part Number



HI-LOK® PIN AND COLLAR AFTER ASSEMBLY

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

"Hi-Lok" and "HL" are internationally registered trademark of Hi-Shear Corporation.			
DRAWN	DATE	TITLE	
Briej	5-2-63	HI-LOK® PIN	
APPROVED	DATE	100° FLUSH SHEAR HEAD ALLOY STEEL 1/16" GRIP VARIATION, 1/64" OVERSIZE	
Cessna	11-1-63		
REVISION	DATE	DRAWING NUMBER	
19	JMO 12-1-04	HL63	
			SHEET 1 OF 1