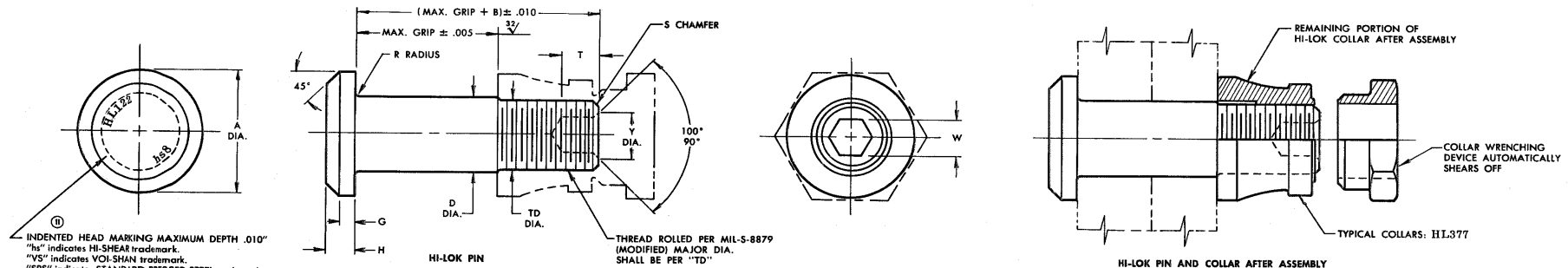


**STANDARDS COMMITTEE
FOR HI-LOK® PRODUCTS**
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

① HI-SHEAR CORPORATION, U.S.A. (Patent Holder) U.S. Federal Code I.D. No. 73197
Division of Hi-Shear Industries Inc.
VOI-SHAN, Division of VSI Corp., U.S.A. (Licensee) U.S. Federal Code I.D. No. 92215
SPS TECHNOLOGIES, U.S.A. (Licensee) U.S. Federal Code I.D. No. 56878
LITTON FASTENING SYSTEMS, U.S.A. (Licensee) U.S. Federal Code I.D. No. 97928

KAMAX-WERKE, Germany (Licensee)
Rudolph Kallerman GmbH & Co.
ST. CHAMOND-GRANAT, S.A. France (Licensee)
TOKYO SCREW COMPANY, Japan (Licensee)



① INDENTED HEAD MARKING MAXIMUM DEPTH .010"
"hs" indicates HI-SHEAR trademark.
"vs" indicates VOI-SHAN trademark.
"SPS" indicates STANDARD PRESSED STEEL trademark.
The number(s) following the trademark indicate first dash number. Arrangement optional.

FIRST DASH NO.	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	11/64	.262 .242	.312	.1770 .1760	.1595 .1570	.030	.060 .045	.025 .015	1/32" x 45°	8-32UNJC-3A Modified	.0645 .0835	.135 .115	.090 .075	2,200	940
-6	13/64	.315 .295	.325	.2026 .2016	.1840 .1810	.035	.074 .055	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	2,900	1,240
-8	17/64	.412 .387	.395	.2651 .2641	.2440 .2410	.045	.090 .080	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	5,000	2,170
-10	21/64	.505 .475	.500	.3276 .3266	.3060 .3020	.055	.110 .100	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	7,600	3,020
-12	25/64	.600 .565	.545	.3901 .3891	.3680 .3640	.065	.135 .125	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	10,800	4,370
-14	29/64	.676 .641	.635	.4526 .4516	.4310 .4260	.075	.155 .145	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	14,500	6,000
-16	33/64	.770 .755	.685	.5151 .5141	.4930 .4880	.085	.180 .170	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	18,800	7,600

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

- ① GENERAL NOTES:
1. Concentricity: "A" to "D" diameter within .010 FIR.
 2. Dimensions to be met after finish.
 3. Surface texture per ANSI B46.1.
 4. Hole preparation per NAS618.
 5. Use HL258 for oversize replacement.

CODE: First dash number indicates nominal diameter in 1/32nds which HL122 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths. See "Finish" note for explanation of code letters.

MATERIAL: 7075-T6 aluminum alloy per Spec. QQ-A-225/9 or QQ-A-430.

HOW TO ORDER EXAMPLES:

① HEAT TREAT: Age to T6 condition per MIL-H-6038.

FINISH: HL122-()-() = Anodize per Spec. MIL-A-8625, dye color natural, and cetyl alcohol lubricant per HI-Shear Spec. 305.
HL122D-()-() = Anodize per MIL-A-8625 and solid film lubricant per Spec. MIL-L-8937.

① SPECIFICATION: HI-Lok Product Specification 342.

Pin Part Number Only
HL122D-8-8
8/16 or 1/2 Maximum Grip Length
Replaces 8/32 or 1/4 Nominal Diameter Pin
Solid Film Lubricant
Pin Part Number

Pin and Collar Assembly Part Number Combination
HL122D377-8-8
Size and Grip Length, See Above Example
Collar Part Number
Pin Finish
Pin Part Number

* * The double shear values shown are based on cross sectional area for nominal diameter pin.

U.S. patents 2,927,491; 2,940,495; 3,027,789; 3,138,987.
Other U.S. and Foreign patents granted and pending.
"Hi-Lok" and "HL" are Registered Trademarks of Hi-Shear Corporation.

DRAWN	DATE	hi-lok ® PIN
Brlej	3-22-63	
APPROVED	DATE	PROTRUDING SHEAR HEAD ALUMINUM ALLOY 1/16" GRIP VARIATION - 1/64" OVERSIZE
Cessna	3-22-63	
REVISION	DATE	DRAWING NUMBER
①	D, P, S 5-14-80	HL122