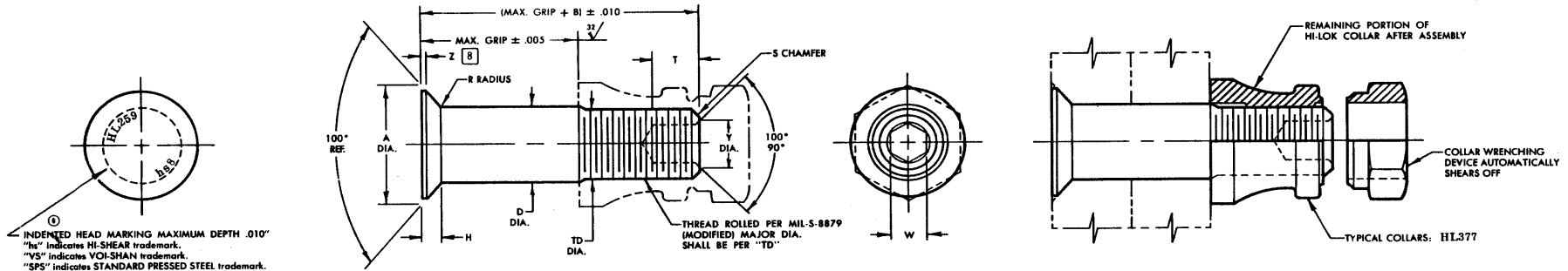


**STANDARDS COMMITTEE
FOR HI-LOK® PRODUCTS**
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

© 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. 97926
 KAMAX-WERKE, Germany (Licensee)
 Rudolph Kellerman GmbH & Co.
 ST. CHAMOND-BRANAT, 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.

HI-LOK PIN

HI-LOK PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	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	13/64															
				NOTE: Use HL23-6												
-6	7/32	.3536 .3486	.325	.2182 .2172	.1840 .1810	.005	.0568 .0547	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	3,400	1,150
-8	9/32	.4732 .4682	.395	.2807 .2797	.2440 .2410	.008	.0807 .0786	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0987 .0947	.150 .130	.142 .122	5,600	2,000
-10	11/32	.5619 .5569	.500	.3432 .3422	.3060 .3020	.007	.0917 .0896	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	8,300	2,800
-12	13/32	.6912 .6862	.545	.4057 .4047	.3680 .3640	.008	.1198 .1177	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	11,700	3,900
-14	15/32	.8041 .7991	.635	.4682 .4672	.4310 .4260	.009	.1409 .1379	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	15,500	6,000
-16	17/32	.9166 .9095	.685	.5307 .5297	.4930 .4980	.010	.1619 .1589	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	19,900	7,600

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

- ① GENERAL NOTES:
- Head edge out of roundness shall not exceed ".F."
 - Concentricity: Conical surface of head to "D" diameter within .005 FIR.
 - "H" dimensioned from maximum "D" diameter.
 - Dimensions to be met after finish.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - Use HL309 for oversize replacement.
 - Curved or flat edge manufacturer's option.

CODE: First dash number indicates nominal diameter in 1/32nds which HL259 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See "Finish" note for explanation of code letters.

MATERIAL: 7075 aluminum alloy per Spec. QQ-A-225/9 or QQ-A-430.
 HEAT TREAT: Age to T6 condition per Spec. MIL-H-6088.
 FINISH: HL259-()-() = Anodize per Spec. MIL-A-8625, dye color natural, and cetyl alcohol lubricant per Hi-Shear Spec. 305.
 HL259D-()-() = Anodize per Spec. MIL-A-8625 and solid film lubricant per Spec. MIL-L-8937.

HOW TO ORDER EXAMPLES:

Pin Part Number Only
 HL259D-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
 HL259D377-8-8
 — 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 M.M. 9-6-63	DATE	100° FLUSH MS20426 SHEAR HEAD ALUMINUM ALLOY 1/16" GRIP VARIATION - 1/32" OVERSIZE
APPROVED DATE CERRINA 9-6-63	DATE	
REVISION DATE 8 D.P.S. 5-14-80	DATE	DRAWING NUMBER HL259

HL259