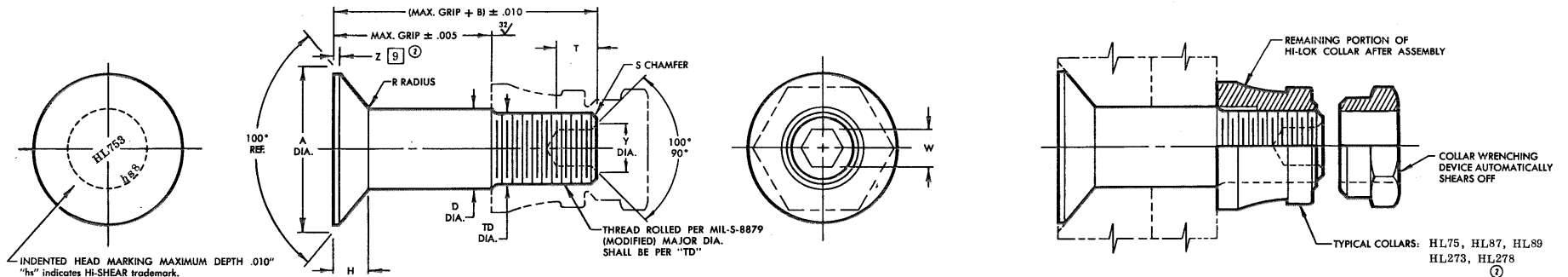


**STANDARDS COMMITTEE  
FOR HI-LOK® PRODUCTS**  
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

HI-SHEAR CORPORATION (Patent Holder) — Federal Code Ident. No. 73197  
VOI-SHAN DIV., VSI CORP. (Licensee) — Federal Code Ident. No. 92215  
STANDARD PRESSED STEEL CO. (Licensee) — Federal Code Ident. No. 56878



INDENTED HEAD MARKING MAXIMUM DEPTH .010"  
"hs" indicates HI-SHEAR trademark.  
"VS" indicates VOI-SHAN trademark.  
"SPS" indicates STANDARD PRESSED STEEL trademark.  
The number or numbers following the trademark indicate first dash number. Arrangement optional.

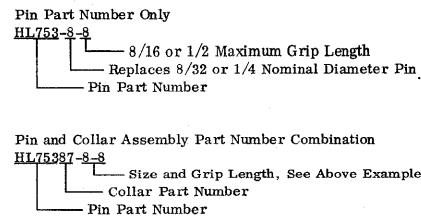
FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA. [7]		TD DIA.	F	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT SOLID FILM LUBE	WITH SOLID FILM LUBE								W HEX.	T DEPTH	Y DIA.		
-5	3/16			NOTE: Use HL647-6													
-6	13/64	.3813 .3765	.325	.2026 .2021	.2026 .2016	.1840 .1810	.005	.0750 .0730	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	8,100	4,350
-8	17/64	.5066 .5018	.395	.2651 .2646	.2651 .2641	.2440 .2410	.006	.1013 .0993	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	13,500	7,750
-10	21/64	.6335 .6287	.500	.3276 .3271	.3276 .3266	.3060 .3020	.007	.1283 .1263	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	21,100	12,300
-12	25/64	.7604 .7556	.545	.3901 .3896	.3901 .3891	.3680 .3640	.008	.1553 .1533	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	30,000	19,100
-14	29/64	.8884 .8812	.635	.4526 .4521	.4526 .4516	.4310 .4260	.009	.1828 .1798	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	40,300	25,800
-16	33/64	1.0139 1.0068	.685	.5151 .5146	.5151 .5141	.4930 .4880	.010	.2093 .2063	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	52,200	34,300
-18	37/64	1.1408 1.1337	.770	.5771 .5766	.5771 .5761	.5550 .5500	.010	.2365 .2335	.050 .040	.025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	65,600	43,500
-20	41/64	1.2723 1.2651	.825	.6396 .6391	.6396 .6386	.6180 .6120	.010	.2654 .2624	.050 .040	.025	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	80,600	54,600
-24	49/64	1.5308 1.5236	1.050	.7646 .7641	.7646 .7636	.7430 .7370	.012	.3214 .3184	.050 .040	.025	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.330 .300	.398 .378	115,000	79,200
-28	57/64	1.7945 1.7773	1.210	.8896 .8891	.8896 .8886	.8680 .8610	.014	.3754 .3724	.050 .040	.025	5/64" x 45°	7/8-14UNJF-3A Modified	.3820 .3780	.400 .370	.471 .451	156,000	117,000
-32	1-1/64	2.0405 2.0310	1.390	1.0146 1.0141	1.0146 1.0136	.9930 .9860	.014	.4304 .4264	.050 .040	.025	5/64" x 45°	1-12UNJF-3A Modified	.5100 .5040	.520 .490	.618 .598	202,000	143,000

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

- 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. ①
  - Maximum "D" diameter may be increased by .0002 to allow for solid film application.
  - Use HL853 for oversize replacement.
  - Curved or flat edge manufacturer's option.
- MATERIAL:** PH13-8Mo stainless steel per Spec. AMS5629.  
**HEAT TREAT:** 125,000 psi shear minimum.  
**FINISH:** HL753-( )-( ) = Solid film lube per Spec. MIL-L-8937.  
HL753LL-( )-( ) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.  
① HL753TB-( )-( ) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 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 which HL753 oversize pin replaces.  
Second dash number indicates maximum grip in 1/16ths.  
See "Finish" note for explanation of code letters.

**HOW TO ORDER EXAMPLES:**



\*\* The Double Shear values shown are based on cross sectional area for nominal diameter pin.

U.S. patents 2,882,773; 2,927,491; 2,940,495; 3,027,789; 3,138,987; design patent 191,883; other U.S. and Foreign patents granted and pending; property of Hi-Shear Corporation. "Hi-Lok" and "HL" are Registered Trademarks of Hi-Shear Corporation.

DRAWN	DATE	100° FLUSH MS24694 TENSION HEAD PH13-8Mo STAINLESS STEEL 1/16" GRIP VARIATION — 1/64" OVERSIZE
VAN	11-18-71	
APPROVED	DATE	DRAWING NUMBER <b>HL753</b>
[Signature]	11-22-71	
REVISION	DATE	
②	11-10-75	

HL753