

IDENTIFIED HEAD MARKING .010 MAX DEPTH.  
IDENTIFY PART WITH NUMBER "209",  
MANUFACTURER'S TRADEMARK "hs", AND  
FIRST DASH NUMBER. LOCATION OPTIONAL.

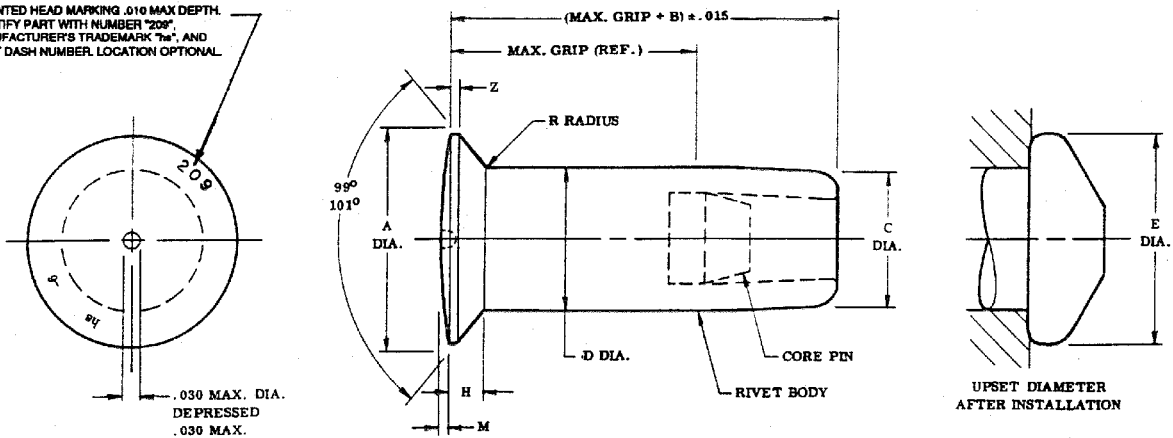


TABLE 1

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	C REF.	D DIA.		E DIA.	H	M REF.	R RAD. REF.	Z REF.	DOUBLE SHEAR POUNDS MIN.	TENSION POUNDS MIN.
					WITHOUT PLATING OR WITH S.F.L.	WITH PLATING							
6	3/16	.3536 .3486	.170	.177	.1895 .1890	.1895 .1885	.275 .236	.0663 .0642	.012	.038	.007	5,380	2,750
8	1/4	.4732 .4682	.233	.237	.2495 .2490	.2495 .2485	.362 .311	.0913 .0892	.013	.050	.010	9,300	5,000
10	5/16	.5619 .5569	.300	.299	.3120 .3115	.3120 .3110	.452 .389	.1023 .1002	.015	.062	.010	14,600	8,300
12	3/8	.6921 .6862	.400	.362	.3745 .3740	.3745 .3735	.543 .468	.1304 .1283	.017	.075	.010	21,000	12,700

TABLE 2  
GRIP RANGE & AVAILABILITY

SECOND DASH NO.	GRIP RANGE			
	-6 DIA.	-8 DIA.	-10 DIA.	-12 DIA.
3	.188 .125	.188 .125	*	*
4	.250 .188	.250 .188	.250 .188	.250 .188
5	.312 .250	.312 .250	.312 .250	.312 .250
6	.375 .312	.375 .312	.375 .312	.375 .312
7	.438 .375	.438 .375	.438 .375	.438 .375
8	.500 .438	.500 .438	.500 .438	.500 .438
9	.562 .500	.562 .500	.562 .500	.562 .500
10	.625 .562	.625 .562	.625 .562	.625 .562
11	.688 .625	.688 .625	.688 .625	.688 .625
12		.750 .688	.750 .688	.750 .688
13		.812 .750	.812 .750	.812 .750
14		.875 .812	.875 .812	.875 .812
15			.938 .875	.938 .875
16			1.000 .938	1.000 .938
17			1.062 1.000	1.062 1.000
18			1.125 1.062	1.125 1.062
19				1.188 1.125
20				1.250 1.188
21				1.312 1.250

- NOTES: 1. Concentricity: "A" diameter to "D" diameter within .005 FIM.  
2. Surface texture:  $\sqrt{125}$  maximum per ANSI B46.1.  
3 See Table 2 for grip length availability.  
4 Dimensions to be met before finish.  
5. "H" is dimensioned from maximum "D" diameter.

MATERIAL: A-286 CRES per AMS5731.

4 SHEAR STRENGTH: 95,000 psi minimum.

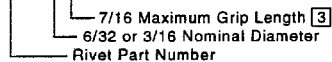
- FINISH: HSR209-(-)(-) = Passivate per QQ-P-35 and cetyl alcohol lube per Hi-Shear Spec. 305.  
HSR209AP(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.  
HSR209DK(-)(-) = Kalgard FA, cured for vacuum compatibility.  
HSR209PN(-)(-) = Cadmium plate per QQ-P-416, Type II, Class 2.  
HSR209PV(-)(-) = Passivate per QQ-P-35.  
HSR209TB(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Set Rivet Specification 332-2.

CODE: First dash number indicates nominal diameter in 1/32nds.  
Second dash number indicates maximum grip length in 1/16ths. 3

HOW TO ORDER

EXAMPLES: HSR209-6-7



\* Parts not available.

Shaded portions of table are available, subject to special pricing and delivery.

U.S. Patent Numbers  
3,995,406; 4,126,076; 4,223,433.  
"Hi-Set" is a registered trademark of  
Hi-Shear Corporation.

			TITLE	DRAWING NUMBER
DRAWN	J.F.Obispo	10-8-96	<b>HI-SET® RIVET</b> 100° FLUSH CROWN TENSION HEAD A-286 CRES, 95 KSI SHEAR	<b>HSR209</b>
APPROVED	J.RAUSCH	1-11-96		
4 REV.	J.Henderson	5-21-98		