



FIRST DASH NO.	NOM. DIA.	A DIA. MAX.	A' DIA. MIN.	B REF.	D DIA.	TD DIA.	F	H (REF.)	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	RECESS SIZE	RECESS TORQUE IN. LBS. MIN.	C (REF.)	G (REF.)	J	HEAD INSP. GAGING		
													W HEX.	T DEPTH	Y DIA.								M	V	
-6	7/32	.335	.298	.331	.2182 .2177	.1840 .1810	.005	.049	.030 .020	.012	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	9,400	2,600	2	42	.224	.100	.039 .036	.0374 .0348	.2440 .2438	
-8	9/32	.429	.387	.397	.2807 .2802	.2440 .2410	.006	.063	.030 .020	.014	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	15,500	4,400	3	76	.300	.110	.045 .042	.0401 .0371	.3314 .3312	
-10	11/32	.509	.461	.467	.3432 .3427	.3060 .3020	.007	.071	.040 .030	.016	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	23,200	7,000	4	165	.394	.134	.049 .046	.0428 .0394	.4047 .4045	
-12	13/32	.596	.542	.516	.4057 .4052	.3680 .3640	.008	.081	.040 .030	.018	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	32,400	10,000	5	260	.484	.160	.064 .061	.0455 .0417	.4054 .4052	
-14	15/32	.704	.644	.599	.4682 .4677	.4310 .4260	.009	.101	.050 .040	.020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	43,100	13,500	6	400	.571	.198	.070 .066	.0552 .0510	.5698 .5696	
-16	17/32	.787	.720	.649	.5307 .5302	.4930 .4880	.010	.109	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	55,400	18,000	7	730	.660	.224	.086 .082	.0562 .0516	.6500 .6498	
-18	19/32	.870	.798	.725	.5927 .5922	.5550 .5500	.010	.119	.050 .040	.024	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.290 .270	.326 .306	69,200	22,500	8	1,220	.731	.256	.098 .094	.0619 .0569	.7200 .7198	
-20	21/32	.957	.880	.777	.6552 .6547	.6180 .6120	.010	.129	.050 .040	.026	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.330 .305	.326 .306	84,500	28,000	9	1,620	.819	.300	.104 .100	.0558 .0504	.8214 .8212	

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F."
  - Concentricity: Conical surface of head to "D" diameter within .005 FIR.
  - "H REF." is dimensioned from maximum "D" diameter.
  - Dimensions to be met after finish.
  - Surface texture per ANSI-46.1.
  - Hole preparation per NAS618.

**MATERIAL:** PH13-8Mo stainless steel per Spec. AMS5629.  
**HEAT TREAT:** 125,000 psi shear minimum.  
**FINISH:** HL845-( )-( ) = Passivate per Hi-Shear Spec. 258.  
**SPECIFICATION:** Hi-Lok Product Specification 342.

**CODE:** First dash number indicates nominal diameter in 1/32nds which HL845 oversize pin replaces.  
Second dash number indicates maximum grip in 1/16ths.

**HOW TO ORDER EXAMPLES:**

Pin Part Number Only  
HL845-8-8  
8/16 or 1/2 Maximum Grip Length  
Replaces 8/32 or 1/4 Nominal Diameter Pin  
Pin Part Number

Pin and Collar Assembly Part Number Combination  
HL84584-8-8  
Size and Grip Length, See Above Example  
Collar Part Number  
Pin Part Number

THIS PART NUMBER HAS BEEN SUPERSEDED BY "HT4011."  
HL845 MAY CONTINUE TO BE SUPPLIED WHILE INVENTORY EXISTS.

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 1,91,883; 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 VAN	DATE 4-21-71	
APPROVED R. J. VAN	DATE 4-28-71	
REVISION 1	DATE 8-16-72	100° FLUSH SHEAR HEAD PH13-8Mo STAINLESS STEEL 1/16" GRIP VARIATION - 1/32" OVERSIZE (HEAD-RECESS APPLICATION)
DRAWING NUMBER HL845		