



① * INDENTED HEAD MARKING MAXIMUM DEPTH .010" BASIC NO'S, APPLICABLE DASH NO'S, & MFR'S. TRADEMARK ARRANGEMENT OPTIONAL. "hs" or "H" or no letter indicates HI-SHEAR trademark. "VS" indicates VOI-SHAN trademark. "SPS" indicates STANDARD PRESSED STEEL trademark.

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

FIRST DASH NO.	NOM. DIA.	A DIA. MAX.	B REF.	D DIA.	TD DIA.	F	H (REF.)	R RAD.	Z	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 (REF.)
-6	7/32	.385	.331	.2182 .2177	.1840 .1810	.005	.067	.030 .020	.020 .010	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	9,400	4,350	3	76	.305	.110	.045 .042	.025 .019	.327
-8	9/32	.507	.397	.2807 .2802	.2440 .2410	.006	.095	.030 .020	.020 .010	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	15,500	7,750	4	165	.422	.134	.054 .051	.033 .026	.432
-10	11/32	.635	.467	.3432 .3427	.3060 .3020	.007	.120	.040 .030	.020 .010	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	23,200	12,300	5	260	.490	.160	.064 .061	.039 .032	.545
-12	13/32	.762	.516	.4057 .4052	.3680 .3640	.008	.147	.040 .030	.020 .010	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	32,400	19,100	6	400	.639	.198	.088 .084	.045 .037	.658
-14	15/32	.890	.599	.4682 .4677	.4310 .4260	.009	.175	.050 .040	.020 .010	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	43,100	25,800	7	730	.715	.224	.100 .096	.049 .041	.778
-16	17/32	1.017	.649	.5307 .5302	.4920 .4880	.010	.202	.050 .040	.020 .010	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	55,400	34,300	8	1,220	.766	.256	.105 .101	.056 .046	.890
-18	19/32	1.145	.725	.5927 .5922	.5590 .5500	.010	.229	.050 .040	.020 .010	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.290 .270	.326 .306	69,200	43,500	9	1,620	.877	.300	.118 .114	.062 .053	1.002
-20	21/32	1.272	.777	.6552 .6547	.6180 .6120	.010	.257	.050 .040	.020 .010	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.330 .305	.326 .306	84,500	54,600	10	2,500	1.020	.344	.141 .137	.070 .060	1.112

- 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.

CODE: First dash number indicates nominal diameter in 1/32nds which HL847 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths.

HOW TO ORDER EXAMPLES:

Pin Part Number Only
HL847-8-8
 — 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
HL847287-8-8
 — Size and Grip Length, See Above Example
 — Collar Part Number
 — Pin Part Number

① * THIS PART NUMBER HAS BEEN SUPERSEDED BY "HT4009." HL847 MAY CONTINUE TO BE SUPPLIED WHILE INVENTORY EXISTS.

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

MATERIAL: PH13-8Mo stainless steel per Spec. AMS5629.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: HL847-()-() = Passivate per Hi-Shear Spec. 258.

SPECIFICATION: Hi-Lok Product Specification 342.

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 VAN	DATE 4-22-71	
APPROVED [Signature]	DATE 4-25-71	
REVISION ①	DATE 8-16-72	

100° FLUSH MS24694 TENSION HEAD
 PH13-8Mo STAINLESS STEEL
 1/16" GRIP VARIATION - 1/32" OVERSIZE
 (HEAD-RECESS APPLICATION)

DRAWING NUMBER
HL847

HI 847