

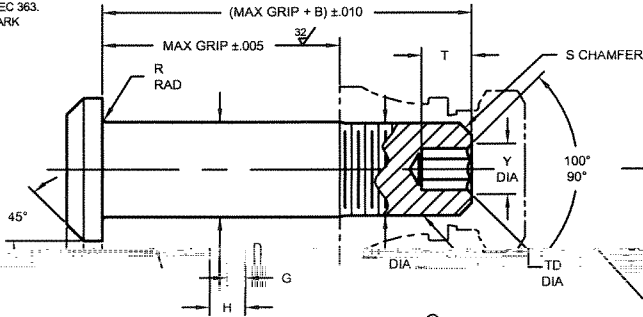
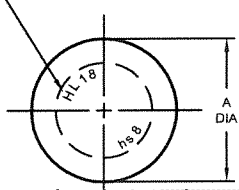
STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

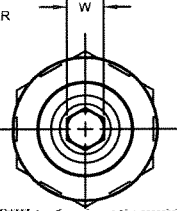
HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
 a LISI AEROSPACE Company
 AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A & Canada) CAGE No. 06725
 HUCK INTERNATIONAL, INC., U.S.A. (Licensee) CAGE No. 97928
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878
 FAIRCHILD Aerospace Fastener Division (Licensee) CAGE No. 92215
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516
 (Pins & Steel Collars)

BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE No. 0LB68
 a LISI AEROSPACE Company
 HUCK S.A. France (Licensee - ECC Countries)
 BLANC AERO S.A. France (Licensee - ECC Countries)
 a LISI AEROSPACE Company
 TOKYO SCREW COMPANY, Japan (Licensee - Japan)

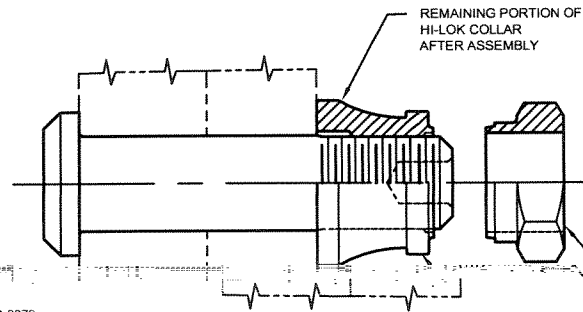
INDENTED HEAD MARKING MAXIMUM DEPTH .010".
 MANUFACTURER'S TRADEMARK "hs" PER SPEC 363.
 THE NUMBER(S) FOLLOWING THE TRADEMARK
 INDICATES FIRST DASH NUMBER.
 ARRANGEMENT OPTIONAL.



HI-LOK® PIN



THREAD ROLLED PER MIL-S-8879
 (MODIFIED) MAJOR DIA SHALL BE
 PER "TD" DIA



HI-LOK PIN® AND COLLAR AFTER ASSEMBLY

TYPICAL COLLARS: HL70, HL79, HL84, HL97, HL98

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
											W HEX	T DEPTH	Y DIA		
5	5/32	.262 .242	.312	.1635 .1625	.1595 .1570	.020	.047 .037	.025 .015	1/32" x 45°	8-32UNJC-3A Modified	.0801 .0791	.135 .115	6	4,010	1,940
6	3/16	.315 .295	.325	.1895 .1885	.1840 .1810	.025	.055 .045	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	5,380	2,500
8	1/4	.412 .387	.395	.2495 .2485	.2440 .2410	.030	.069 .059	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	9,300	4,300
10	5/16	.505 .475	.500	.3120 .3110	.3060 .3020	.035	.078 .068	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	14,600	6,300
12	3/8	.600 .565	.545	.3745 .3735	.3680 .3640	.040	.088 .078	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	21,000	8,700
14	7/16	.676 .641	.635	.4370 .4360	.4310 .4260	.045	.105 .093	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	28,600	12,100
16	1/2	.770 .735	.685	.4995 .4985	.4930 .4880	.050	.115 .103	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	37,300	15,300
18	9/16	.864 .829	.770 .735	.5615 .5605	.5550 .5500	.055	.127 .112	.040 .028	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.290 .270	.326 .306	47,200	19,000
20	5/8	.953 .918	.825	.6240 .6230	.6180 .6120	.060	.137 .122	.040 .025	1/16" x 45°	5/8-18UNJF-3A Modified	.2655 .2520	.330 .305	.326 .306	58,300	23,000
24	3/4	1.108 1.066	1.050	.7490 .7480	.7430 .7370	.070	.153 .136	.045 .030	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.395 .365	.398 .378	83,900	30,700
28	7/8	1.285 1.241	1.210	.8740 .8730	.8680 .8610	.090	.187 .172	.050 .035	5/64" x 45°	7/8-14UNJF-3A Modified	.3820 .3780	.455 .425	.471 .451	114,000	45,000
32	1	1.468 1.424	1.390	.9990 .9980	.9930 .9860	.110	.218 .203	.060 .045	5/64" x 45°	1-12UNJF-3A Modified	.5100 .5040	.580 .550	.618 .598	149,000	60,900

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

GENERAL NOTES:

- Concentricity: "A" to "D" diameter within .010 FIM.
- Dimensions to be met after finish.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- Non-lubed pins must be used with sealant or lubed collars.
- Evidence of broken edge across points.
- Use HL62 for oversize replacement.

MATERIAL:

Alloy steel per AMS6415, AMS6349 or AMS-S-6049.

HEAT TREAT:

95,000 psi shear (160,000 - 180,000 psi tensile per AMS-H-6875).

FINISH:

- HL18(-)(-) = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL18PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL18TF(-)(-) = Cadmium plate per AMS-QQ-P-416, Type III, Class 2, and Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.
- HL18PN(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.

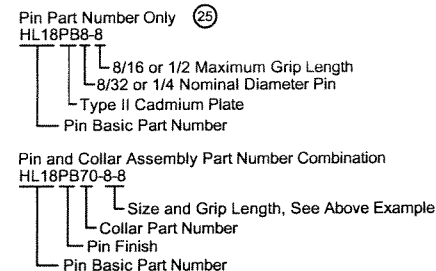
SPECIFICATION:

Hi-Lok Product Specification 342.

CODE:

First dash number indicates nominal diameter in 1/32nds
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

**HOW TO ORDER
EXAMPLE:**



DRAWN DATE		"Hi-Lok" and "HL" are internationally registered trademark of Hi-Shear Corporation	
J.C.S.	7-19-62	TITLE	
APPROVED DATE		HI-LOK® PIN PROTRUDING SHEAR ALLOY STEEL 1/16 GRIP VARIATION	
Cessna	7-24-62	DRAWING NUMBER	
REVISION DATE		HL18	
(25)	J.F.O. 10-17-02		