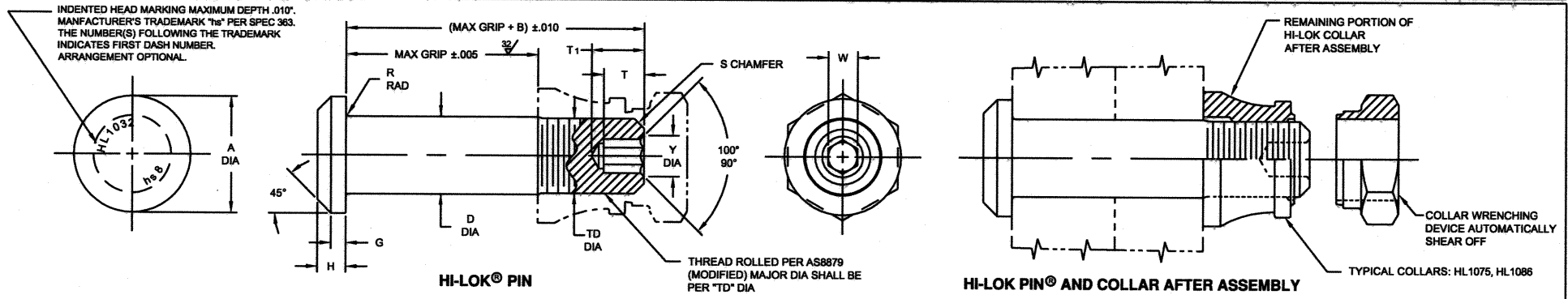


# STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. — (Patent Holder) — CAGE No. 73197	BLANC AERO INDUSTRIES UK LIMITED — (Licensee) — CAGE No. OLB88
a LISI AEROSPACE Company	a LISI AEROSPACE Company
AIR INDUSTRIES CO., INC., U.S.A. — (Licensee - U.S.A & Canada) — CAGE No. 06725	HUCK S.A. France — (Licensee - ECC Countries) — CAGE No. 97928
HUCK INTERNATIONAL, INC., U.S.A. — (Licensee) — CAGE No. 97928	BLANC AERO S.A. France — (Licensee - ECC Countries) — CAGE No. 56878
SPS TECHNOLOGIES, U.S.A. — (Licensee) — CAGE No. 56878	a LISI AEROSPACE Company
FAIRCHILD Aerospace Fastener Division — (Licensee) — CAGE No. 92215	TOKYO SCREW COMPANY, Japan — (Licensee - Japan)
WEST COAST AEROSPACE INC., U.S.A. — (Licensee) — CAGE No. 60616	
(Pins & Steel Collars)	



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	
				WITHOUT COATING OR SOLID FILM LUBE	WITH COATING OR SOLID FILM LUBE							W HEX	T DEPTH	T1 DEPTH MAX	Y DIA			
5						NOTE: USE HL1022-6(-)												
6	7/32	.390 .370	.325	.2182 .2177	.2182 .2172	.1840 .1810	.035	.074 .064	.025 .015	1/32" x 37°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.140 .104	.119 .104	7,100	3,180	
8	9/32	.460 .435	.395	.2807 .2802	.2807 .2797	.2440 .2410	.045	.090 .080	.025 .015	1/32" x 37°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.160 .122	.142 .122	11,800	5,820	
10	11/32	.520 .500	.500	.3432 .3427	.3432 .3422	.3060 .3020	.055	.112 .102	.030 .020	3/64" x 37°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.200 .160	.180 .160	17,600	9,200	
12	13/32	.620 .600	.545	.4057 .4052	.4057 .4047	.3680 .3640	.075	.140 .130	.030 .020	3/64" x 37°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.235 .197	.217 .197	24,600	14,000	
14	15/32	.695 .670	.635	.4682 .4677	.4682 .4672	.4310 .4260	.095	.160 .150	.030 .020	3/64" x 37°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.280 .233	.253 .233	32,700	18,900	
16	17/32	.790 .765	.685	.5307 .5302	.5307 .5297	.4930 .4880	.095	.188 .178	.030 .020	3/64" x 37°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.320 .269	.289 .269	42,000	25,600	
18	19/32	.905 .870	.770	.5927 .5922	.5927 .5917	.5550 .5500	.125	.210 .200	.040 .025	1/16" x 37°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.360 .306	.326 .306	52,400	32,400	
20	21/32	.975 .940	.825	.6552 .6547	.6552 .6542	.6180 .6120	.140	.238 .228	.040 .025	1/16" x 37°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.400 .306	.326 .306	64,100	41,000	
24	25/32	1.185 1.145	1.050	.7802 .7797	.7802 .7792	.7430 .7370	.200	.335 .320	.045 .030	1/16" x 37°	3/4-16UNJF-3A Modified	.3185 .3150	.330 .300	.425 .378	.398 .378	90,900	59,500	

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

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
  2. Dimensions to be met after finish.
  3. Surface texture per ANSI B46.1.
  4. Hole preparation per NAS618.
  5. Oversize replacement for HL1012 and HL1022.

**SPECIFICATION:** Hi-Lok Product Specification 342.

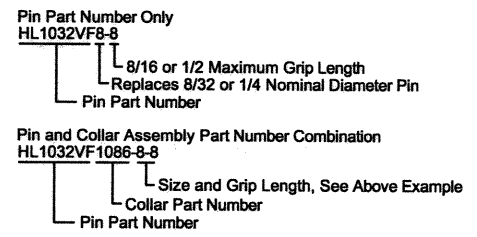
**CODE:** First dash number indicates nominal diameter in 1/32nds of the pin which HL1032 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

**MATERIAL:** 6AI-4V titanium alloy per AMS4928 or AMS4967.

**HEAT TREAT:** 160,000 psi tensile minimum (95,000 psi shear minimum).

- FINISH:**
- HL1032(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL1032AZ(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 with color code black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL1032DK(-)(-) = Solid film lube per Kalgard FA.
  - HL1032GL(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 on threads only (no overspray on the shank is allowed) color code white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL1032RA(-)(-) = Phosphate fluoride treat with color red on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL1032VF(-)(-) = Surface coating per Hi-Shear Spec. 306, Type I, color blue and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL1032SY(-)(-) = Phosphate fluoride treat, solid film lube per AS5272, Type I, and color red on thread end.

**HOW TO ORDER EXAMPLE:**



DRAWN DATE		TITLE	
J.F.Obispo	3-22-95	HI-LOK® PIN PROTRUDING TENSION HEAD TITANIUM, 1/32" OVERSIZE 1/16 GRIP VARIATION (SPECIAL SOCKET APPLICATION)	
APPROVED DATE		DRAWING NUMBER	
E.E.B.	3-23-95	HL1032	
REVISION DATE			
4	J.F.O. 10-25-06		

HL1032