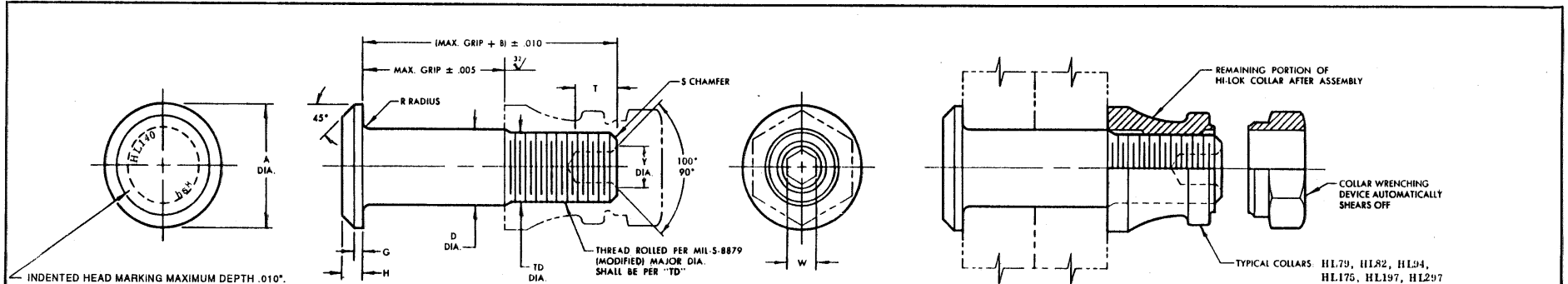


# STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

2600 Skypark Drive, Torrance, California U.S.A. 90509

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197	HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee) CAGE No. OLB68
Division of Hi-Shear Industries Inc., U.S.A.	Division of Hi-Shear Industries Inc., U.S.A.
AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S. & Canada) CAGE No. 06725	HUCK INTERNATIONAL GMBH & CO., Germany (Licensee - EEC Countries)
HUCK INTERNATIONAL, INC., Deutsch Operation, U.S.A. (Licensee) CAGE No. 97928	SAINT CHAMOND GRANAT, S.A. France (Licensee - EEC Countries)
SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56876	SIMMONDS S.A., France (Licensee - EEC Countries-Collars)
FAIRCHILD Aerospace Fastener Division, U.S.A. (Licensee) CAGE No. 92215	WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516
(Pins & Steel Collars)	(Licensee - Japan)



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

HI-LOK® PIN

HI-LOK® PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	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, PLATING OR SOLID FILM	WITH COATING, PLATING OR SOLID FILM							W HEX.	T DEPTH	Y DIA.		
5	3/16															
NOTE: USE HL40-6(-)																
6	13/64	.315 .295	.325	.2026 .2021	.2026 .2016	.1840 .1810	.025	.055 .045	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	6,130	2,500
8	17/64	.412 .387	.395	.2651 .2646	.2651 .2641	.2440 .2410	.030	.069 .059	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	10,490	4,300
10	21/64	.505 .475	.500	.3276 .3271	.3276 .3266	.3060 .3020	.035	.078 .068	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	16,000	6,300
12	25/64	.600 .565	.545	.3901 .3896	.3901 .3891	.3680 .3640	.040	.088 .078	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	22,700	8,700
14	29/64	.676 .641	.635	.4526 .4521	.4526 .4516	.4310 .4260	.045	.105 .093	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	30,600	12,100
16	33/64	.770 .735	.685	.5151 .5146	.5151 .5141	.4930 .4880	.050	.115 .103	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	39,600	15,300
18	37/64	.864 .829	.770	.5771 .5766	.5771 .5761	.5550 .5500	.055	.127 .112	.040 .025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.290 .270	.326 .306	49,700	19,000
20	41/64	.953 .918	.825	.6396 .6391	.6396 .6386	.6180 .6120	.060	.137 .122	.040 .025	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.330 .305	.326 .306	61,000	23,000
24	49/64	1.108 1.066	1.050	.7646 .7641	.7646 .7636	.7430 .7370	.070	.151 .136	.045 .030	1/16" x 45°	3/4-UNJF-3A Modified	.3185 .3150	.395 .365	.398 .378	87,200	30,700

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.
- Non-lubed pins must be used with lubed collars.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS818.
- Use HL240 for oversize replacement.

MATERIAL: A-286 high temperature alloy per Spec. AMS5737 or AMS5731.

HEAT TREAT: 95,000 psi shear minimum at 70°F.

FINISH:

- HL140(-)(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL140AZ(-)(-) = 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.
- HL140DU(-)(-) = Solid film lube per MIL-L-46010, Type I.
- HL140GU(-)(-) = Silver plate per AMS2410.
- HL140PY(-)(-) = Passivate per Hi-Shear Spec. 258.
- HL140V(-)(-) = Solid film lubricant per Lubeco 2123, Type II.

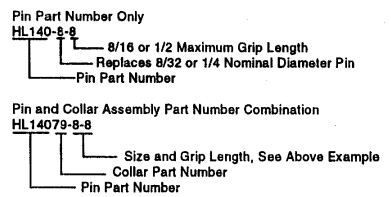
SPECIFICATION: Hi-Lok Product Specification 342.

CODE:

First dash number indicates nominal diameter in 1/32nds of the pin which HL140 oversize pin replaces.  
Second dash number indicates maximum grip in 1/16ths.  
See Finish note for explanation of code letters.

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

HOW TO ORDER EXAMPLES:



"Hi-Lok" and "HL" are internationally registered trademarks of Hi-Shear Corporation.		
DRAWN	DATE	TITLE
BRLEJ	3-8-65	HI-LOK® PIN PROTRUDING SHEAR HEAD A-286 HIGH TEMPERATURE ALLOY 1/16" GRIP VARIATION, 1/64" OVERSIZE
APPROVED	DATE	DRAWING NUMBER
MILLER	3-8-65	HL140
REVISION	DATE	
13	J.F. Obispo 1-7-97	

HL140

STD/HLPIN