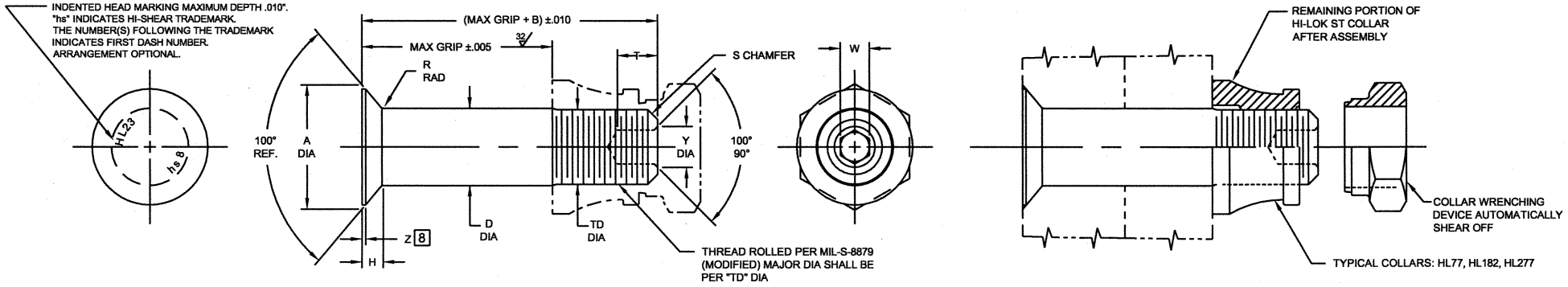
STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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. OLB68
a GFI AEROSPACE Company	a GFI AEROSPACE Company
AIR INDUSTRIES CO., INC., U.S.A. — (Licensee - U.S.A & Canada) — CAGE No. 06725	HUCK S.A. France — (Licensee - ECC Countries)
HUCK INTERNATIONAL, INC., U.S.A. — (Licensee) — CAGE No. 97928	BLANC AERO S.A. France — (Licensee - ECC Countries)
SPS TECHNOLOGIES, U.S.A. — (Licensee) — CAGE No. 56878	a GFI 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. 60516 (Pins & Steel Collars)	



HI-LOK PIN — **HI-LOK PIN AND COLLAR AFTER ASSEMBLY**

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF		D DIA		TD DIA	F [1]	H [1]	R RAD	Z MAX [8]	S CHAMFER REF	THREAD		SOCKET W HEX	SOCKET T DEPTH	SOCKET Y DIA	DOUBLE SHEAR POUNDS MINIMUM [20]	TENSION POUNDS MINIMUM
5	5/32	.2922 .2874	.312		.1635 .1625		.1595 .1570	.004	.0540 .0520	.025 .015	.010	1/32" x 45°	8-32UNJC-3A Modified		.0645 .0635	.135 .115	.090 .075	1,760	860
6	3/16	.3536 .3486	.325		.1895 .1885		.1840 .1810	.005	.0688 .0667	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified		.0806 .0791	.135 .115	.119 .104	2,550	1,150
8	1/4	.4732 .4682	.395		.2495 .2485		.2440 .2410	.006	.0939 .0918	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified		.0967 .0947	.150 .130	.142 .122	4,420	2,000
10	5/16	.5619 .5569	.500		.3120 .3110		.3060 .3020	.007	.1048 .1027	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified		.1295 .1270	.170 .150	.180 .160	6,900	2,800
12	3/8	.6912 .6862	.545		.3745 .3735		.3680 .3640	.008	.1329 .1308	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified		.1617 .1582	.200 .180	.217 .197	9,940	3,900
14	7/16	.8041 .7969	.635		.4370 .4360		.4310 .4260	.009	.1540 .1510	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified		.1930 .1895	.230 .210	.253 .233	13,800	6,000
16	1/2	.9166 .9095	.685		.4995 .4985		.4930 .4880	.010	.1750 .1720	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified		.2242 .2207	.260 .240	.289 .269	18,000	7,600

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

GENERAL NOTES:
1. Head edge out of roundness shall not exceed "F".
2. Concentricity: Conical surface of head to "D" diameter within .005 FIM.
3. "H" is dimensioned from maximum "D" diameter.
4. Dimensions to be met after finish.
5. Surface texture per ANSI B46.1.
6. Hole preparation per NAS618.
7. Use HL123 for oversize replacement.
8. Curved or flat edge manufacturer's option.

MATERIAL: 7075 aluminum alloy per AMS-QQ-A-225/9 or QQ-A-430.

(21) HEAT TREAT: Age to T73 condition per AMS2770.

FINISH:
HL23-( )-( ) = Anodize per AMS-A-8625, dye color natural and cetyl alcohol lube per Hi-Shear Spec. 305.
HL23D( )-( ) = Anodize per AMS-A-8625, and solid film lube per AS5272, Type I.
HL23TT( )-( ) = Anodize per AMS-A-8625, dye color natural and translube.

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:

Pin Part Number Only
HL23D8-8
- 8/16 or 1/2 Maximum Grip Length
- 8/32 or 1/4 Nominal Diameter Pin
- Solid Film Lubricant
- Pin Part Number

Pin and Collar Assembly Part Number Combination
HL23D778-8
- Size and Grip Length, See Above Example
- Collar Part Number
- Pin Finish
- Pin Part Number

DRAWN	DATE	TITLE
R.K.L.	5-8-62	**HI-LOK® PIN**
APPROVED	DATE	100° FLUSH MS20426 SHEAR HEAD ALUMINUM ALLOY 1/16" GRIP VARIATION
Cessna	5-8-62	
REVISION	DATE	DRAWING NUMBER
(21)	JO 5-9-06	**HL23**

HL23