STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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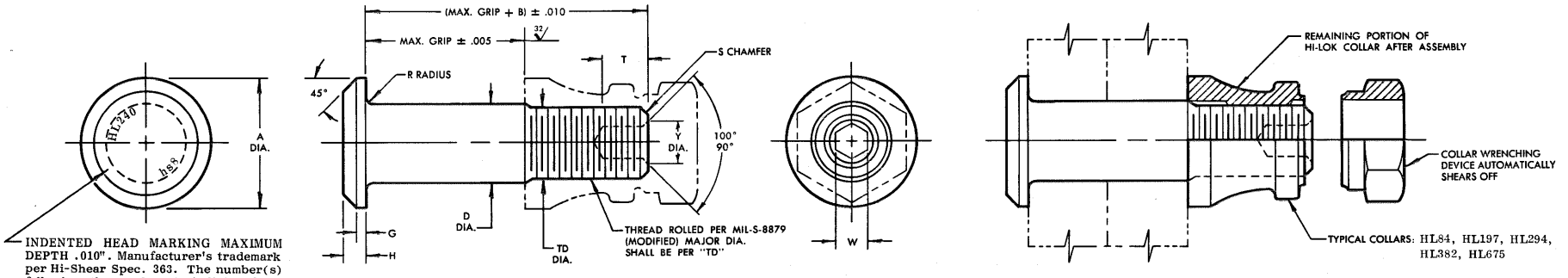
HI-SHEAR CORPORATION, U.S.A. ---------- (Patent Holder) ---------- CAGE No. 73197 Division of Hi-Shear Industries Inc., U.S.A. AIR INDUSTRIES CO., INC., U.S.A ---------- (Licensee - U.S.& Canada)---CAGE No. 06725 HUCK INTERNATIONAL, INC., Deutsch Operation, U.S.A---(Licensee)----------CAGE No. 97928 SPS TECHNOLOGIES, U.S.A. ----------(Licensee)----------CAGE No. 56878 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)	HI-SHEAR FASTENERS EUROPE, LTD., U.K.----------(Licensee)---CAGE No. OLB68 Division of Hi-Shear Industries Inc., U.S.A. HUCK INTERNATIONAL GMBH & CO., Germany------(Licensee - EEC Countries) SAINT CHAMOND GRANAT, S.A. France----------(Licensee - EEC Countries) SIMMONDS S.A., France----------(Licensee - EEC Countries-Collars) TOKYO SCREW COMPANY, Japan----------(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 WITHOUT COATING, PLATING OR SOLID FILM	D DIA WITH COATING, PLATING OR SOLID FILM	TD DIA.	G REF.	H		R RAD.		S CHAMFER REF.	THREAD	SOCKET W HEX.	SOCKET T DEPTH	SOCKET Y DIA.	** DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
5							NOTE: USE HL140-6-( )											
6	7/32	.315 .295	.325	.2182 .2177	.2182 .2172	.1840 .1810	.025	.055 .045		.025 .015		1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	7,100	2,500
8	9/32	.412 .387	.395	.2807 .2802	.2807 .2797	.2440 .2410	.030	.069 .059		.025 .015		1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	11,800	4,300
10	11/32	.505 .475	.500	.3432 .3427	.3432 .3422	.3060 .3020	.035	.078 .068		.030 .020		3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	17,600	6,300
12	13/32	.600 .565	.545	.4057 .4052	.4057 .4047	.3680 .3640	.040	.088 .078		.030 .020		3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	24,600	8,700
14	15/32	.676 .641	.635	.4682 .4677	.4682 .4672	.4310 .4260	.045	.105 .093		.030 .020		3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	32,700	12,100
16	17/32	.770 .735	.685	.5307 .5302	.5307 .5297	.4930 .4880	.050	.115 .103		.030 .020		3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	42,000	15,300
18	19/32	.864 .829	.770	.5927 .5922	.5927 .5917	.5550 .5500	.055	.127 .112		.040 .025		1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.290 .270	.326 .306	52,400	19,000
20	21/32	.953 .918	.825	.6552 .6547	.6552 .6542	.6180 .6120	.060	.137 .122		.040 .025		1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.330 .305	.326 .306	64,100	23,000
24	25/32	1.108 1.066	1.050	.7802 .7797	.7802 .7792	.7430 .7370	.070	.151 .136		.045 .030		1/16" x 45°	3/4-UNJF-3A Modified	.3185 .3150	.395 .365	.398 .378	90,900	30,700

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

⑯GENERAL NOTES:
1. Concentricity: "A" to "D" diameter within .010 FIM.
2. Dimensions to be met after finish.
3. Non-lubed pins must be used with lubed collars.
4. Surface texture per ANSI B46.1.
5. Hole preparation per NAS618.
6. Oversize replacement of HL40 and HL140.

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

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

⑯FINISH:
- HL240-( )-( ) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL240AZ( )-( ) = 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.
- HL240DU( )-( ) = Solid film lube per MIL-L-46010, Type I.
- [3] HL240GU( )-( ) = Silver plate per AMS2410.
- [3] HL240N( )-( ) = Cadmium plate per QQ-P-416, Type II, Class 2, without lube (for use in LOX systems).
- HL240PB( )-( ) = Cadmium plate per QQ-P-416, Type II, Class 2, with color code green on thread end plus cetyl alcohol lube per Hi-Shear Spec. 305.
- HL240V( )-( ) = 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 HL240 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER EXAMPLES:

Pin Part Number Only
HL240-8-8
- 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
HL24084-8-8
- Size and Grip Length, See Above Example
- Collar Part Number
- Pin Part Number

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

"Hi-Lok" and "HL" are internationally registered trademarks of Hi-Shear Corporation.

DRAWN	DATE	TITLE
BRLEJ	3-31-66	HI-LOK® PIN PROTRUDING SHEAR HEAD A-286 HIGH TEMPERATURE ALLOY 1/16" GRIP VARIATION, 1/32" OVERSIZE
APPROVED	DATE	
MILLER	3-31-66	
REVISION	DATE	DRAWING NUMBER
⑯	J.F.Obispo 1-7-97	HL240

HL240

STD/HLPIN