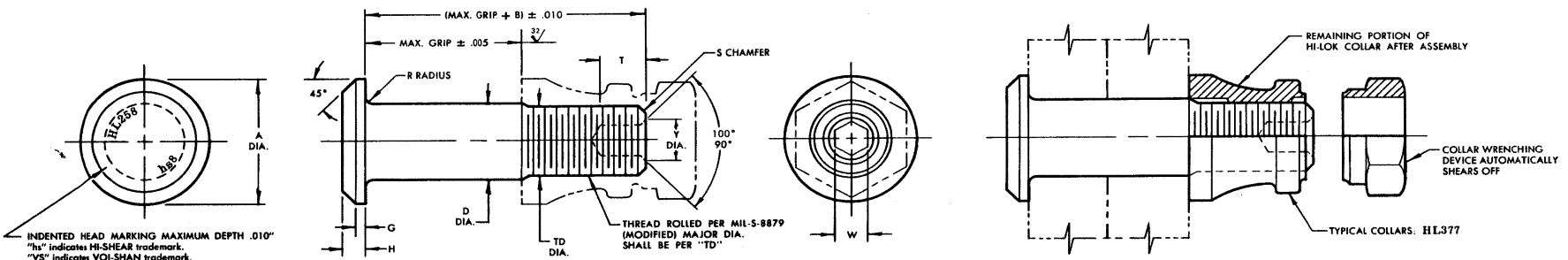


**STANDARDS COMMITTEE
FOR HI-LOK® PRODUCTS**
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) U.S. Federal Code No. 73197	HI-SHEAR FASTENERS EUROPE, LTD. U.K. (Licensee)
Division of Hi-Shear Industries Inc., U.S.A.	Division of Hi-Shear Industries Inc., U.S.A.
AIR INDUSTRIES CO., INC. (Licensee - U.S. & Canada) U.S. Federal Code No. 08725	KAMAX-WERKE, Germany (Licensee - EEC Countries)
DEUTSCH FASTENER CO., INC. (Licensee) U.S. Federal Code No. 87925	Rudolph Kellerman GmbH & Co. (Licensee - EEC Countries)
SPS TECHNOLOGIES, U.S.A. (Licensee) U.S. Federal Code No. 95079	ST. CHAMOND ORMAT, S.A. France (Licensee - EEC Countries)
VOI-SHAN, Division of YSI Corp., U.S.A. (Licensee) U.S. Federal Code No. 92215	BIMMONDS, S.A. France (Licensee - EEC Countries)
WEST COAST AEROSPACE INC., U.S.A. (Licensee) U.S. Federal Code No. 68518	Plus 2 Steel Collars (Licensee - Japan)
	TOKYO SCREW COMPANY, Japan (Licensee - Japan)



INDENTED HEAD MARKING MAXIMUM DEPTH .010"
"hs" indicates HI-SHEAR trademark.
"VS" indicates VOI-SHAN trademark.
"SPS" indicates STANDARD PRESSED STEEL trademark.
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
											W HEX.	T DEPTH	Y DIA.		
-5	13/64			NOTE: Use HL122-6			⓪								
-6	7/32	.315 .295	.325	.2182 .2172	.1840 .1810	-.035	.074 .064	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	3,400	1,240
-8	9/32	.412 .387	.395	.2807 .2797	.2440 .2410	-.045	.090 .080	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	5,600	2,170
-10	11/32	.505 .475	.500	.3432 .3422	.3060 .3020	-.055	.110 .100	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	8,300	3,020
-12	13/32	.600 .565	.545	.4057 .4047	.3680 .3640	-.065	.135 .125	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	11,700	4,370
-14	15/32	.676 .641	.635	.4682 .4672	.4310 .4260	-.075	.155 .145	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	15,500	6,000
-16	17/32	.770 .735	.685	.5307 .5297	.4930 .4880	-.085	.180 .170	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	19,900	7,600

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

GENERAL NOTES:

1. Concentricity: "A" to "D" diameter within .010 FIR.
2. Dimensions to be met after finish.
3. Surface texture per ANSI B46-1.
4. Hole preparation per NAS618.
5. Use HL322 for oversize replacement.

MATERIAL:

7075 aluminum alloy per Spec. QQ-A-225/9 or QQ-A-430.

HEAT TREAT:

Age to T6 condition per Spec. MIL-H-6088.

FINISH:

HL258-()-() = Anodize per Spec. MIL-A-8625, dye color natural, and cetyl alcohol lubricant per Hi-Shear Spec. 305.
HL258D-()-() = Anodize per Spec. MIL-A-8625 and solid film lube per Spec. MIL-L-46010, Type 1.

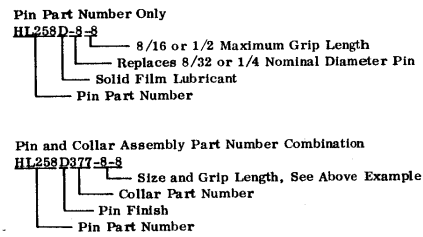
SPECIFICATION:

Hi-Lok Product Specification 342.

CODE:

First dash number indicates nominal diameter in 1/32nds of the pin which HL258 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See "Finish" note for explanation of code letters.

HOW TO ORDER EXAMPLES:



** 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	
M.M.	9-6-63	
APPROVED	DATE	PROTRUDING SHEAR HEAD ALUMINUM ALLOY 1/16" GRIP VARIATION - 1/32" OVERSIZE
Cesena	9-6-63	
REVISION	DATE	DRAWING NUMBER
9	10-6-72	HL258

HL258