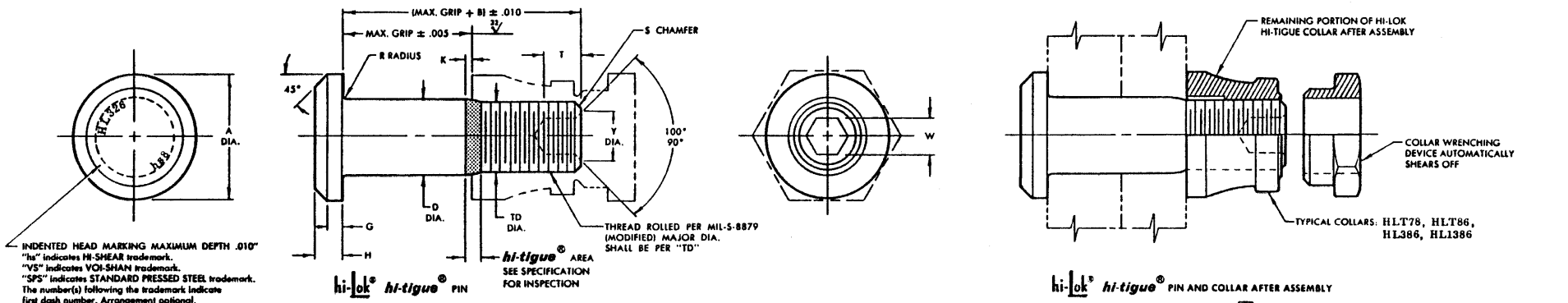


**STANDARDS COMMITTEE FOR
HI-LOK® HI-TIGUE® PRODUCTS**
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

HI-SHEAR CORPORATION U.S.A. (Patent Holder) U.S. Federal Code 10 No. 73197	HI-SHEAR FASTENERS EUROPE LTD. U.K. (Licenses)
Division of Hi-Shear Industries Inc. U.S.A.	Division of Hi-Shear Industries Inc. U.S.A.
AIR INDUSTRIES CO. INC. (Licenses) U.S. Federal Code 10 No. 06723	KAMAX-WERKE, Germany (Licenses—EEC Countries)
DEUTSCH FASTENER CO. INC. (Licenses) U.S. Federal Code 10 No. 07928	Rudolph Kahrbaum GmbH & Co. (Licenses—EEC Countries)
SPS TECHNOLOGIES U.S.A. (Licenses) U.S. Federal Code 10 No. 36670	St. CHAMPION CRANET, S.A. France (Licenses—EEC Countries)
NO. 3346, Division of VEC Corp. U.S.A. (Licenses) U.S. Federal Code 10 No. 32216	SINMONDE S.A. France (Licenses—EEC Countries—Collars)
WEST COAST AEROSPACE INC. U.S.A. (Licenses) U.S. Federal Code 10 No. 80516	TOKYO SCREW COMPANY, Japan (Licenses—Japan)
Pin & Sheet Collars	



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.

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.	TD DIA.	G REF.	H	K REF.	R RAD.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	MIN. GRIP LENGTH
												W HEX.	T DEPTH	Y DIA.			
- 5	5/32	.322 .306	.312	.1650 .1640	.1595 .1570	.030	.065 .065	.013	.025 .015	1/32" x 45°	8-32UNJ-C-3A Modified	.0801 .0791	.135 .115	.104 .094	4,010	2,180	-2
- 6	3/16	.377 .357	.325	.1895 .1885	.1840 .1810	.035	.074 .064	.016	.025 .015	1/32" x 45°	10-32UNJ-F-3A Modified	.0806 .0791	.100 .080	.119 .104	5,380	2,750	-2
- 8	1/4	.440 .415	.385	.2495 .2485	.2440 .2410	.045	.090 .080	.021	.025 .015	1/32" x 45°	1/4-28UNJ-F-3A Modified	.0967 .0947	.110 .090	.142 .122	9,300	5,820	-2
- 10	5/16	.505 .475	.500	.3120 .3110	.3060 .3020	.065	.112 .102	.026	.030 .020	3/64" x 45°	5/16-24UNJ-F-3A Modified	.1295 .1270	.130 .110	.180 .160	14,600	9,200	-2
- 12	3/8	.600 .530	.545	.3745 .3735	.3680 .3640	.075	.140 .130	.030	.030 .020	3/64" x 45°	3/8-24UNJ-F-3A Modified	.1617 .1582	.160 .140	.217 .197	21,000	14,000	-3
- 14	7/16	.676 .592	.635	.4370 .4360	.4310 .4260	.095	.160 .150	.035	.030 .020	3/64" x 45°	7/16-20UNJ-F-3A Modified	.1930 .1895	.190 .170	.253 .233	28,600	18,900	-4
- 16	1/2	.770 .717	.685	.4995 .4985	.4930 .4880	.095	.188 .178	.039	.030 .020	3/64" x 45°	1/2-20UNJ-F-3A Modified	.2242 .2207	.220 .200	.289 .269	37,300	25,500	-4
- 18	9/16	.877 .842	.770	.5615 .5605	.5550 .5500	.125	.210 .200	.039	.040 .025	1/16" x 45°	9/16-18UNJ-F-3A Modified	.2555 .2520	.260 .240	.326 .306	47,200	32,400	-5

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 plating.
 3. Surface texture per ANSI B46.1.
 4. Hole preparation per NAS618.
 5. Use HLT426 for oversize replacement.
 6. Minimum required for head and Hi-Tigue feature. Standard Hi-Lok pins available in shorter grips.

MATERIAL: Alloy steel per Spec. MIL-S-5000, MIL-S-5626, or MIL-S-6049.

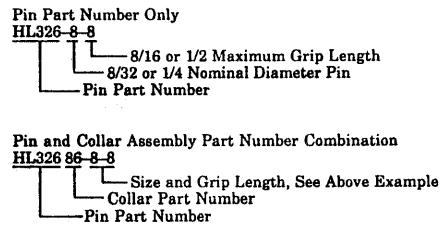
HEAT TREAT: 160,000-180,000 psi tensile per Spec. MIL-H-6875.

- FINISH:**
- HL326-() = Cadmium plate per Spec. QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL326K-() = Cadmium plate per QQ-P-416, Type III, Class 2, and solid film lube per "Lubeco 905".
 - HL326TB-() = Cadmium plate per QQ-P-416, Type II, Class 2, Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lok Hi-Tigue 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 EXAMPLES:



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

DRAWN	DATE	hi-lok hi-tigue [®] PIN PROTRUDING TENSION HEAD ALLOY STEEL 1/16" GRIP VARIATION INTERFERENCE APPLICATION
SHRODE 1-24-68		
APPROVED	DATE	
W.MILLER 1-26-68		
REVISION	DATE	DRAWING NUMBER
14	D.P.S. 4-8-91	HL326

HL326