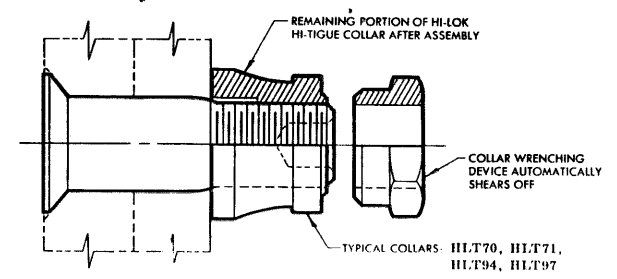
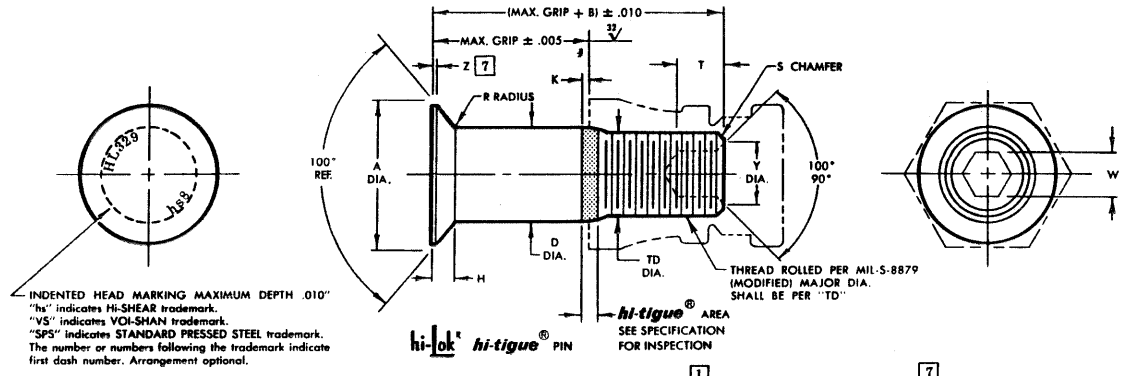


**STANDARDS COMMITTEE FOR  
HI-LOK® HI-TIGUE® PRODUCTS**  
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) U.S. Federal Code No. 73197  
 Division of Hi-Shear Industries Inc., U.S.A.  
 AIR INDUSTRIES CO., INC. (Licensee - U.S. & Canada) U.S. Federal Code No. 08725  
 DEUTSCH FASTENER CO., INC. (Licensee) U.S. Federal Code No. 07928  
 SPS TECHNOLOGIES, U.S.A. (Licensee) U.S. Federal Code No. 58878  
 VOI-SHAN, Division of VSI Corp., U.S.A. (Licensee) U.S. Federal Code No. 82215  
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) U.S. Federal Code No. 40516  
 Pins & Steel Collars

HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee)  
 Division of Hi-Shear Industries Inc., U.S.A.  
 KAWAX-WERKE, Germany (Licensee - EEC Countries)  
 Rudolph Kriegerman GmbH & Co. (Licensee - EEC Countries)  
 ST. 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  
 "hs" indicates HI-SHEAR trademark.  
 "VS" indicates VOI-SHAN trademark.  
 "SPS" indicates STANDARD PRESSED STEEL trademark.  
 The number of numbers following the trademark indicate first dash number. Arrangement optional.

hi-lok hi-tigue PIN

hi-tigue AREA  
 SEE SPECIFICATION  
 FOR INSPECTION

hi-lok hi-tigue PIN AND COLLAR AFTER ASSEMBLY

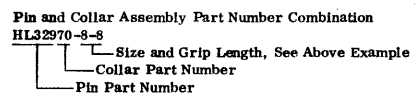
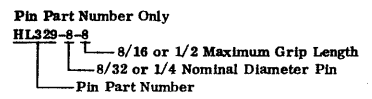
FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.	TD DIA.	F	H	K REF.	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	MIN. GRIP LENGTH
													W HEX.	T DEPTH	Y DIA.			
-4	1/8	.2219	.294	.1375	.1335	.003	.0354	.010	.020	.010	1/32" x 45°	6-32UNJC-3A Modified	.0645	.080	.090	2,840	950	-2
		.2171		.1365	.1310								.0334	.0635	.065			
-5	5/32	.2612	.312	.1850	.1595	.004	.0403	.013	.025	.010	1/32" x 45°	8-32UNJC-3A Modified	.0801	.135	.109	4,560	1,750	-3
		.2564		.1640	.1570		.0383						.0791	.115	.094			
-6	3/16	.3016	.325	.1895	.1840	.005	.0470	.016	.030	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806	.100	.119	6,100	2,340	-3
		.2966		.1885	.1810		.0449						.0791	.080	.104			
-8	1/4	.3948	.395	.2495	.2440	.006	.0610	.021	.030	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967	.110	.142	10,600	4,200	-3
		.3898		.2485	.2410		.0589						.0947	.090	.122			
-10	5/16	.4739	.500	.3120	.3060	.007	.0679	.026	.040	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295	.130	.180	16,600	6,500	-4
		.4689		.3110	.3020		.0658						.1270	.110	.160			
-12	3/8	.5604	.545	.3745	.3690	.008	.0780	.030	.040	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617	.160	.217	23,900	9,230	-5
		.5554		.3735	.3640		.0759						.1582	.140	.197			
-14	7/16	.6680	.635	.4370	.4310	.009	.0969	.035	.050	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930	.190	.253	32,500	13,200	-5
		.6620		.4360	.4260		.0944						.1895	.170	.233			
-16	1/2	.7540	.685	.4995	.4930	.010	.1068	.039	.050	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242	.220	.289	42,400	16,900	-6
		.7480		.4985	.4880		.1043						.2207	.200	.269			
-18	9/16	.8380	.770	.5615	.5550	.010	.1160	.039	.050	.022	1/16" x 45°	9/16-18UNJF-3A Modified	.2555	.260	.326	53,700	19,000	
		.8310		.5605	.5500		.1131						.2520	.240	.306			

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

- GENERAL NOTES:
- Head edge out of roundness shall not exceed "F."
  - Concentricity: Conical surface of head to "D" diameter within .005 FIR.
  - "H" dimensioned from maximum "D" diameter.
  - Dimensions to be met after plating.
  - Surface texture per ANSI B46.1.
  - Hole preparation per NAS618.
  - Curved or flat edge manufacturer's option.
  - Minimum required for head and Hi-Tigue feature.
  - Standard Hi-Lok pins available in shorter grips.
  - Use HLT1001 for oversize replacement.

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:



MATERIAL: Alloy steel per Spec. MIL-S-5000, MIL-S-5626, or MIL-S-6049.  
 HEAT TREAT: 108,000 psi shear minimum (180,000-200,000 psi tensile per Spec. MIL-H-6375).  
 FINISH: HL329-( )-( ) = Cadmium plate per Spec. QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HL329TB-( )-( ) = 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.

DRAWN DATE		DATE		"HL", "Hi-Lok", "HLT", and "Hi-Tigue" are internationally registered trademarks of Hi-Shear Corporation hi-lok hi-tigue PIN 100° FLUSH SHEAR HEAD ALLOY STEEL 1/16" GRIP VARIATION INTERFERENCE APPLICATION DRAWING NUMBER <b>HL329</b>	
SHRODE 1-24-68		DATE			
APPROVED DATE		DATE			
J. MILLER 1-26-68		DATE			
REVISION (16)		DATE			
		T. Craine 11-2-92			

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HL329