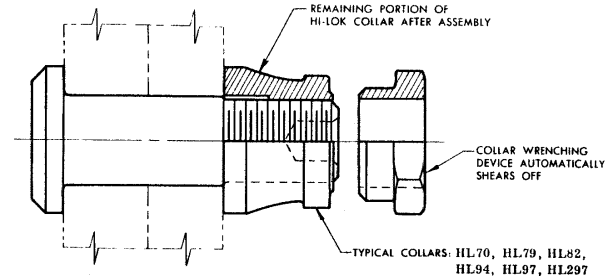
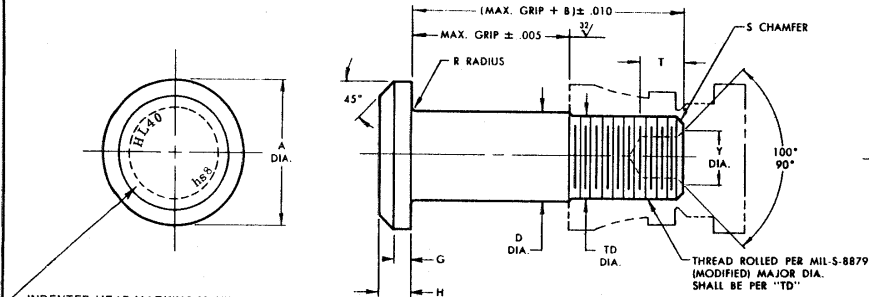


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

2600 Skypark Drive, Torrance, California U.S.A. 90509

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. 80516
 (Pins & Steel Collars)

HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee) CAGE No. 0L68
 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. [6]		TD DIA.	G REF.	H	R RAD.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	
				WITHOUT SOLID FILM LUBE	WITH SOLID FILM LUBE							W HEX.	T DEPTH	Y DIA.			
4	1/8	.240 .225	.294	.1375 .1370	.1375 .1365	.1335 .1310	.020 .032	.042 .032	.020 .010		1/32° x 45°	6-32UNJC-3A Modified	.0645 .0635	.100 .085	[8]	2,840	1,350
5	5/32	.262 .242	.312	.1635 .1630	.1635 .1625	.1595 .1570	.020 .037	.047 .037	.025 .015		1/32° x 45°	8-32UNJC-3A Modified	.0801 .0791	.135 .115	[8]	4,010	1,940
6	3/16	.315 .295	.325	.1895 .1890	.1895 .1885	.1840 .1810	.025 .045	.055 .045	.025 .015		1/32° x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	5,380	2,500
8	1/4	.412 .387	.395	.2495 .2490	.2495 .2485	.2440 .2410	.030 .059	.069 .059	.025 .015		1/32° x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	9,300	4,300
10	5/16	.505 .475	.500	.3120 .3115	.3120 .3110	.3060 .3020	.035 .068	.078 .068	.030 .020		3/64° x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	14,600	6,300
12	3/8	.600 .565	.545	.3745 .3740	.3745 .3735	.3680 .3640	.040 .078	.088 .078	.030 .020		3/64° x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	21,000	8,700
14	7/16	.641 .611	.635	.4370 .4365	.4370 .4360	.4310 .4260	.045 .093	.105 .093	.030 .020		3/64° x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	28,600	12,100
16	1/2	.770 .735	.685	.4995 .4990	.4995 .4985	.4930 .4880	.050 .103	.115 .103	.030 .020		3/64° x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	37,300	15,300
18	9/16	.864 .829	.770	.5615 .5610	.5615 .5605	.5550 .5500	.055 .112	.127 .112	.040 .025		1/16° x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.290 .270	.326 .306	47,200	19,000
20	5/8	.953 .918	.825	.6240 .6235	.6240 .6230	.6180 .6120	.060 .122	.137 .122	.040 .025		1/16° x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.330 .305	.326 .306	58,300	23,000
24	3/4	1.108 1.066	1.050	.7490 .7485	.7490 .7480	.7430 .7370	.070 .136	.151 .136	.045 .030		1/16° x 45°	3/4-UNJF-3A Modified	.3185 .3150	.395 .365	.398 .378	83,900	30,700

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

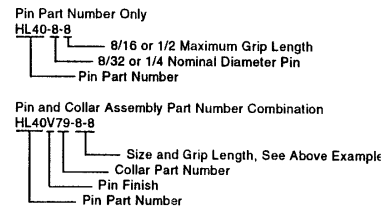
GENERAL NOTES:

- Concentricity: "A" to "D" diameter within .010 FIR.
- Dimensions to be met after finish.
- Non-lubed pins must be used with lubed collars.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- Maximum "TD" diameter may be increased by .0002 to allow for solid film application.
- Use HL140 for oversize replacement.
- Evidence of broken edge across points.
- Broach petals removed.

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	TITLE
C.E.K.	10-17-62	HI-LOK® PIN
APPROVED	DATE	PROTRUDING SHEAR HEAD
M.E.C.	10-17-62	A-286 HIGH TEMPERATURE ALLOY
		1/16" GRIP VARIATION
REVISION	DATE	DRAWING NUMBER
(22)	J.F.Obispo 7-11-95	HL40