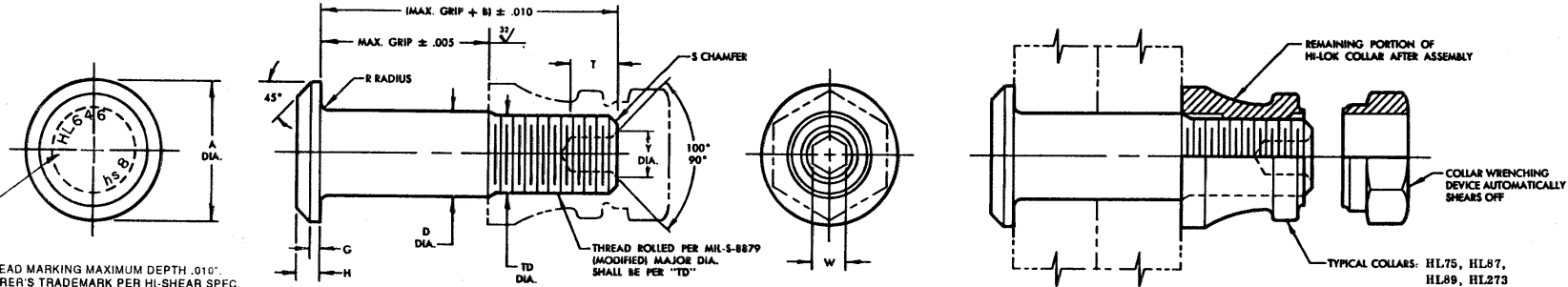


# STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197	HI-SHEAR FASTENERS EUROPE (Licensee) CAGE No. 04B66
Division of Hi-Shear Industries Inc., U.S.A.	Division of Hi-Shear Industries
AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S. & Canada) CAGE No. 06725	HUCK INTERNATIONAL GMBH & CO. (Licensee - EEC Countries)
HUCK INTERNATIONAL, INC., Deutsch Operation, U.S.A. (Licensee) CAGE No. 07928	SAINT CHAMOND GRANAT, S.A. France (Licensee - EEC Countries)
SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878	SIMMONDS S.A., France (Licensee - EEC Countries - Collar)
FAIRCCHILD Aerospace Fastener Division, U.S.A. (Licensee) CAGE No. 02215	TOKYO SCREW COMPANY, Japan (Licensee - Japan)
WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516	

(Pins & Steel Collars)



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. [5]		TD DIA.	G REF.	H	R RAD.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING OR PLATING	WITH COATING OR PLATING							W HEX.	T DEPTH	Y DIA.		
5	5/32	.322 .306	.312	.1635 .1630	.1635 .1625	.1595 .1570	.030	.060 .055	.025 .015	1/32" x 45°	8-32UNJC-3A Modified	.0801 .0791	.100 .080	[6]	5,280	2,940
6	3/16	.377 .357	.325	.1895 .1890	.1895 .1885	.1840 .1810	.035	.074 .064	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	7,060	4,350
8	1/4	.440 .415	.395	.2495 .2490	.2495 .2485	.2440 .2410	.045	.090 .080	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	12,260	7,750
10	5/16	.505 .475	.500	.3120 .3115	.3120 .3110	.3060 .3020	.055	.112 .102	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	19,160	12,300
12	3/8	.600 .565	.545	.3745 .3740	.3745 .3735	.3680 .3640	.075	.140 .130	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	27,600	19,100
14	7/16	.676 .641	.635	.4370 .4365	.4370 .4360	.4310 .4260	.095	.160 .150	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	37,500	25,800
16	1/2	.770 .735	.685	.4995 .4990	.4995 .4985	.4930 .4880	.095	.188 .178	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	49,100	34,300
18	9/16	.877 .842	.770	.5615 .5610	.5615 .5605	.5550 .5500	.125	.210 .200	.040 .025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	62,100	43,500
20	5/8	.953 .918	.825	.6240 .6235	.6240 .6230	.6180 .6120	.140	.238 .228	.040 .025	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	76,700	54,600
24	3/4	1.150 1.110	1.050	.7490 .7485	.7490 .7480	.7430 .7370	.200	.335 .320	.045 .030	1/16" x 45°	3/4-UNJF-3A Modified	.3185 .3150	.330 .300	.398 .378	110,400	79,200
28	7/8	1.330 1.290	1.210	.8740 .8735	.8740 .8730	.8680 .8610	.250	.385 .370	.050 .035	5/64" x 45°	7/8-14UNJF-3A Modified	.3820 .3780	.400 .370	.471 .451	150,300	117,000
32	1	1.510 1.470	1.390	.9990 .9985	.9990 .9980	.9930 .9860	.300	.435 .420	.060 .045	5/64" x 45°	1-12UNJF-3A Modified	.5100 .5040	.520 .490	.618 .598	196,300	143,000

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

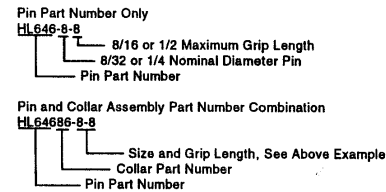
GENERAL NOTES:

- Concentricity: "A" to "D" diameter within .010 FIR.
- Dimensions to be met after finish.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- Maximum "D" diameter may be increased by .0002 to allow for Hi-Kote application.
- Evidence of broken edge across points.
- Use HL746 for oversize replacement.

CODE:

First dash number indicates nominal diameter in 1/32nd. 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	
Van	12-22-69	<b>HI-LOK® PIN</b> PROTRUDING TENSION HEAD PH13-8Mo STAINLESS STEEL 1/16" GRIP VARIATION	
APPROVED	DATE	DRAWING NUMBER	
J.M.	12-23-69	<b>HL646</b>	
REVISION	DATE		
(12)	J.F.Obispo 02-05-96		

HL646