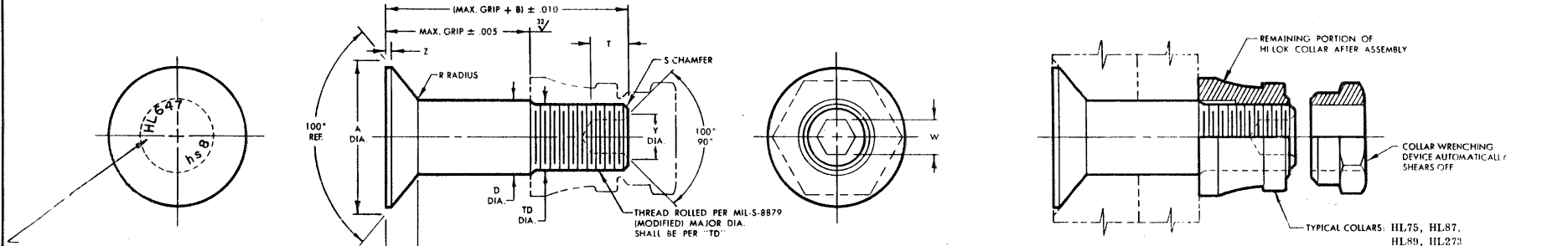


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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. 97926
 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. 60516
 (Pins & Steel Collars)

HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee) CAGE No. 0LB68
 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. [7]		TD DIA.	F	H REF.	R RAD.	Z MAX	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	.3304 .3256	.312	.1635 .1630	.1635 .1570	.1595 .1570	.004	.0700 .0680	.025 .015	.010	1/32" x 45°	8-32UNJC-3A Modified	.0801 .0791	.100 .080	[8]	5,280	2,940
6	3/16	.3813 .3765	.325	.1895 .1890	.1895 .1810	.1840 .1810	.005	.0805 .0785	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	7,060	4,350
8	1/4	.5066 .5018	.395	.2495 .2490	.2495 .2410	.2440 .2410	.006	.1080 .1060	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	12,260	7,750
10	5/16	.6335 .6287	.500	.3120 .3115	.3120 .3020	.3060 .3020	.007	.1350 .1330	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	19,160	12,300
12	3/8	.7604 .7556	.545	.3745 .3740	.3745 .3640	.3680 .3640	.008	.1620 .1600	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	27,800	19,100
14	7/16	.8884 .8812	.635	.4370 .4365	.4370 .4260	.4310 .4260	.009	.1895 .1865	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	37,500	25,800
16	1/2	1.0139 1.0068	.685	.4995 .4990	.4995 .4880	.4930 .4880	.010	.2160 .2130	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	49,100	34,300
18	9/16	1.1408 1.1337	.770	.5615 .5610	.5615 .5500	.5550 .5500	.010	.2430 .2400	.050 .040	.025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	62,100	43,500
20	5/8	1.2723 1.2651	.825	.6240 .6235	.6240 .6120	.6180 .6120	.010	.2720 .2690	.050 .040	.025	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	76,700	54,600
24	3/4	1.5308 1.5236	1.050	.7490 .7485	.7490 .7370	.7430 .7370	.012	.3280 .3250	.050 .040	.025	1/16" x 45°	3/4-UNJF-3A Modified	.3185 .3150	.330 .300	.398 .378	110,400	79,200
28	7/8	1.7845 1.7773	1.210	.8740 .8735	.8740 .8610	.8680 .8610	.014	.3820 .3790	.050 .040	.025	5/64" x 45°	7/8-14UNJF-3A Modified	.3820 .3780	.400 .370	.471 .451	150,300	117,000
32	1	2.0405 2.0310	1.390	.9990 .9985	.9990 .9860	.9930 .9860	.014	.4370 .4330	.050 .040	.025	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.

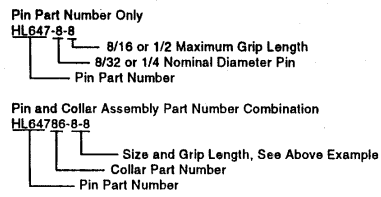
GENERAL NOTES:

- 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 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 HL753 for oversize replacement.
 - Curved or flat edge manufacturer's option.
- PH13-8Mo stainless steel per AMS5629.
 125,000 psi shear minimum.
 HL647-(-)(-) = Solid film lube per MIL-L-46010, Type I.
 HL647AP-(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL647LL-(-)(-) = Passivate per Hi-Shear Spec. 262 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL647PB-(-)(-) = Cadmium plate per QQ-P-416, Type II, Class 2 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL647TB-(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.

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:



MATERIAL:
 HEAT TREAT:
 FINISH:

SPECIFICATION:

Hi-Lok Product Specification 342.

"Hi-Lok" and "HL" are internationally registered trademarks of Hi-Shear Corporation.		
DRAWN	DATE	TITLE
Van	12-22-69	HI-LOK® PIN
APPROVED	DATE	100° FLUSH MS24694 TENSION HEAD PH13-8Mo STAINLESS STEEL 1/16" GRIP VARIATION
J.M.	12-23-69	
REVISION	DATE	DRAWING NUMBER
(12)	J.F. Obispo 02-05-96	HL647

HL647