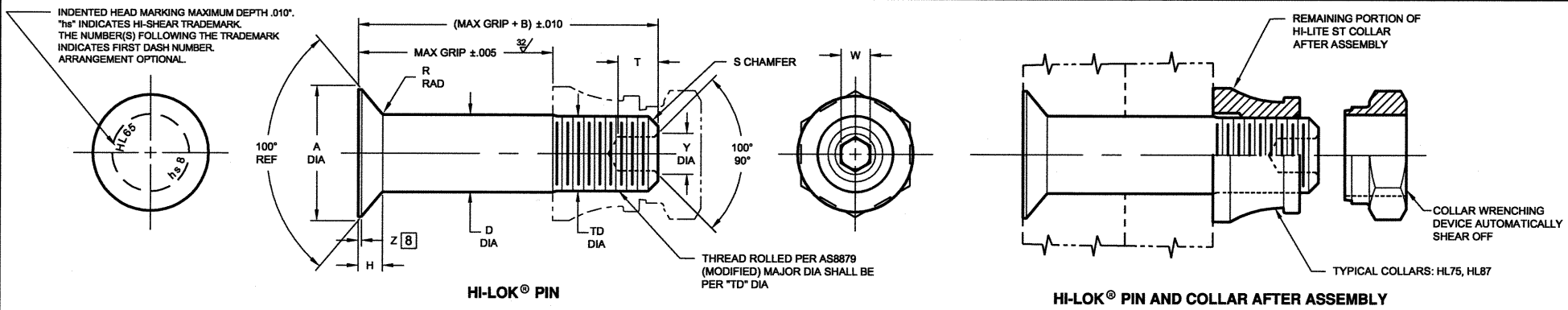


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

15 HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
 a LISI AEROSPACE Company
 AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A. & Canada) CAGE No. 06725
 HUCK INTERNATIONAL, INC., U.S.A. (Licensee) CAGE No. 97928
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878
 FAIRCHILD Aerospace Fastener Division (Licensee) CAGE No. 92215
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516
 (Pins & Steel Collars)

BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE No. 0LB68
 a LISI AEROSPACE Company
 HUCK S.A. France (Licensee - ECC Countries)
 BLANC AERO S.A. France (Licensee - ECC Countries)
 a LISI AEROSPACE Company
 TOKYO SCREW COMPANY, Japan (Licensee - Japan)



FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
												W HEX	T DEPTH	Y DIA		
5						NOTE: USE HL21-6(-) or HL421-6(-)										
6	13/64	.3813 .3765	.325	.2026 .2016	.1840 .1810	.005	.0750 .0730	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	6,130	3,180
8	17/64	.5066 .5018	.395	.2651 .2641	.2440 .2410	.006	.1013 .0993	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	10,490	5,820
10	21/64	.6335 .6287	.500	.3276 .3266	.3060 .3020	.007	.1283 .1263	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	16,000	9,200
12	25/64	.7604 .7556	.545	.3901 .3891	.3680 .3640	.008	.1553 .1533	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	22,700	14,000
14	29/64	.8884 .8812	.635	.4526 .4516	.4310 .4260	.009	.1828 .1798	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	30,600	18,900
16	33/64	1.0139 1.0068	.685	.5151 .5141	.4930 .4880	.010	.2093 .2063	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	39,600	25,600
18	37/64	1.1408 1.1337	.770	.5771 .5761	.5550 .5500	.010	.2365 .2335	.050 .040	.022	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.290 .270	.326 .306	49,700	32,400
20	41/64	1.2723 1.2561	.825	.6396 .6386	.6180 .6120	.010	.2654 .2624	.050 .040	.022	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.330 .305	.326 .306	61,000	41,000
24	49/64	1.5308 1.5236	1.050	.7646 .7636	.7430 .7370	.012	.3214 .3184	.050 .040	.022	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.395 .365	.398 .378	87,200	59,500

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 FIM.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions to be met after plating.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - Non-lubed pins must be used with wet sealant or with lubed collars.
 - Curved or flat edge manufacturer's option.
 - Use HL221 for oversize replacement.

MATERIAL: Alloy steel per AMS6415, AMS6349, or AMS-S-6049.

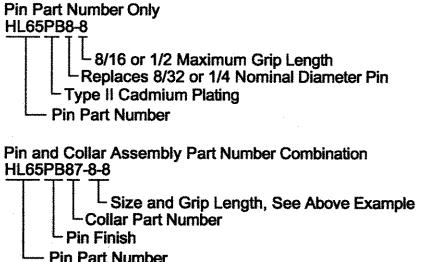
HEAT TREAT: 160,000-180,000 psi tensile per AMS-H-6875.

FINISH: HL65(-)(-) = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL65A(-)(-) = Cadmium plate per AMS2400-3 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL65PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL65PN(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.

SPECIFICATION: Hi-Lok Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL65 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER EXAMPLE:



HL65

"Hi-Lok" and "HL" are internationally registered trademark of Hi-Shear Corporation.		
DRAWN	DATE	TITLE
Brij	7-29-64	HI-LOK® PIN
APPROVED	DATE	100° FLUSH MS24694 TENSION HEAD ALLOY STEEL
Cessna	7-30-64	1/16" GRIP VARIATION, 1/64" OVERSIZE
REVISION	DATE	DRAWING NUMBER
15	JMO 12-1-04	HL65
		SHEET 1 OF 1