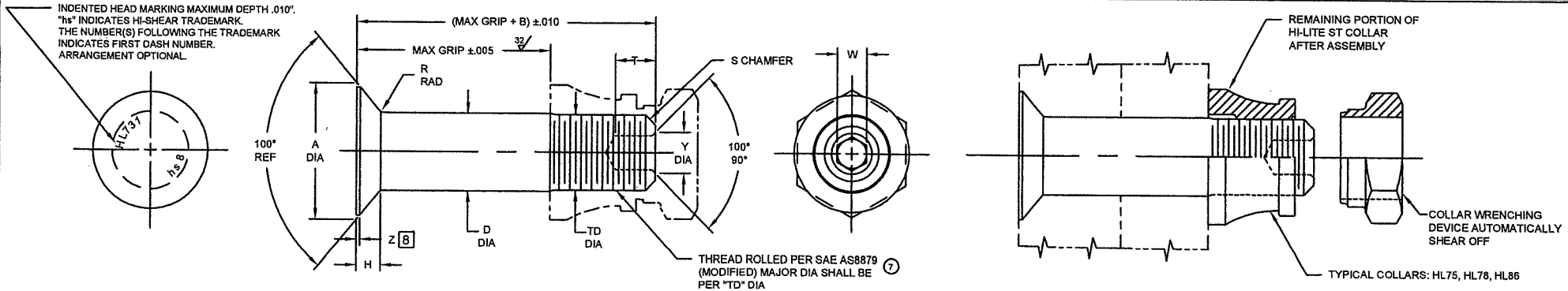


HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197	BLANC AERO INDUSTRIES RUGBY (Licensee) CAGE No. U6300
a LISI AEROSPACE Company	a LISI AEROSPACE Company
AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A & Canada) CAGE No. 06725	BLANC AERO S.A. France (Licensee) CAGE NO. F0188
ALCOA FASTENING SYSTEMS, U.S.A. (Licensee) CAGE No. 15653	a LISI AEROSPACE Company
SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 58878	LISI AEROSPACE CANADA (Licensee) CAGE No. L4528
WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516	a LISI AEROSPACE Company
(Pins & Steel Collars)	FT BETA S, Izmer (Licensee) CAGE No. T0802
MINEBEA CO., LTD. Japan (Licensee-Japan)	a LISI AEROSPACE Company



HI-LOK® PIN

HI-LOK® PIN AND COLLAR AFTER ASSEMBLY

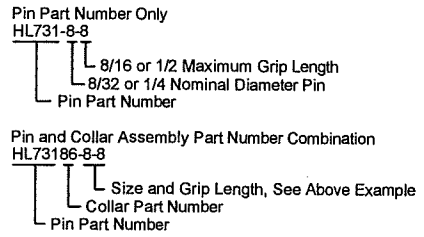
FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING OR PLATING	WITH COATING OR PLATING								W HEX	T DEPTH	Y DIA		
5	5/32	.3304 .3256	.312	.1635 .1630	.1635 .1625	.1595 .1570	.004	.0700 .0680	.025 .015	.015	1/32" x 45°	8-32UNJC-3A Modified	.0801 .0791	.135 .115	[5]	5,280	2,940
6	3/16	.3813 .3765	.325	.1895 .1890	.1895 .1885	.1840 .1810	.005	.0805 .0785	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	7,060	4,350
8	1/4	.5066 .5018	.395	.2495 .2490	.2495 .2485	.2440 .2410	.006	.1079 .1059	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	12,260	7,750
10	5/16	.6335 .6287	.500	.3120 .3115	.3120 .3110	.3060 .3020	.007	.1349 .1329	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	19,160	12,300
12	3/8	.7604 .7556	.545	.3745 .3740	.3745 .3735	.3680 .3640	.008	.1619 .1599	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	27,600	19,100
14	7/16	.8884 .8812	.635	.4370 .4365	.4370 .4360	.4310 .4260	.009	.1894 .1864	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	37,500	25,800
16	1/2	1.0139 1.0068	.685	.4995 .4990	.4995 .4985	.4930 .4880	.010	.2158 .2128	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	49,100	34,300

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 finish.
 - Evidence of broken edge across point.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - Curved or flat edge manufacturer's option.
 - Use HL939 for oversize replacement.
 - Non-lubed pin must be used with wet sealant or with lubed collars.

HOW TO ORDER EXAMPLE:

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.



MATERIAL: Nickel base alloy per AMS5662.

HEAT TREAT: 125,000 psi shear minimum (210,000 psi tensile minimum).

- FINISH:**
- HL731(-)(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL731AP(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL731JT(-)(-) = Passivate per Hi-Shear Spec. 258, with light blue identification on top of head, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL731PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL731PY(-)(-) = Passivate per Hi-Shear Spec. 258.

SPECIFICATION: Hi-Lok Product Specification 342.

DRAWN DATE		"Hi-Lok" and "HL" are internationally registered trademark of Hi-Shear Corporation.	
D.P.S.	2-9-83	TITLE HI-LOK® PIN	
APPROVED DATE		100° FLUSH MS24694 TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16" GRIP VARIATION	
Cessna	8-2-82	DRAWING NUMBER HL731	
REVISION DATE			
[7]	L.G.V 5-5-09		

HL731