

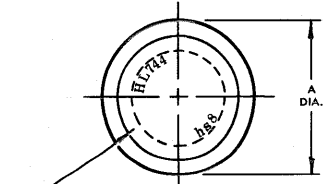
STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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

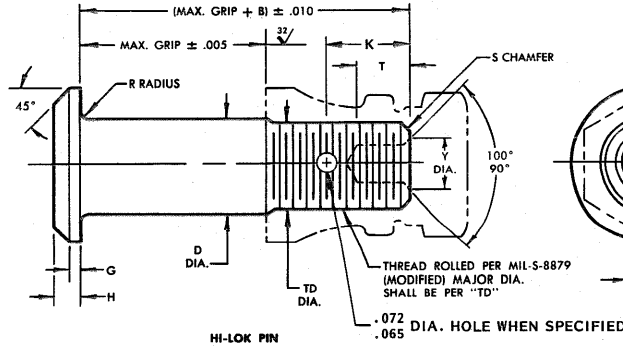
HI-SHEAR CORPORATION, U.S.A. (Patent Holder) U.S. Federal Code No. 79197
 Division of Hi-Shear Industries Inc., U.S.A.
 AIR INDUSTRIES CO., INC. (Licensee - U.S. & Canada) U.S. Federal Code No. 06725
 DEUTSCH FASTENER CO., INC. (Licensee) U.S. Federal Code No. 07828
 SPS TECHNOLOGIES, U.S.A. (Licensee) U.S. Federal Code No. 66878
 VOI-SHAN, Division of Fairchild Corp., U.S.A. (Licensee) U.S. Federal Code No. 02216
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) U.S. Federal Code No. 60616
 (Pins & Steel Collars)

HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee)
 Division of Hi-Shear Industries Inc., U.S.A.
 HUCK INTERNATIONAL GmbH & Co. Germany (Licensee - EEC Countries)
 ST. CHAMOND GRANAT, S.A. France (Licensee - EEC Countries)
 SIMMONDS, S.A. France (Licensee - EEC Countries)
 Collars
 TOKYO SCREW COMPANY, Japan (Licensee - Japan)

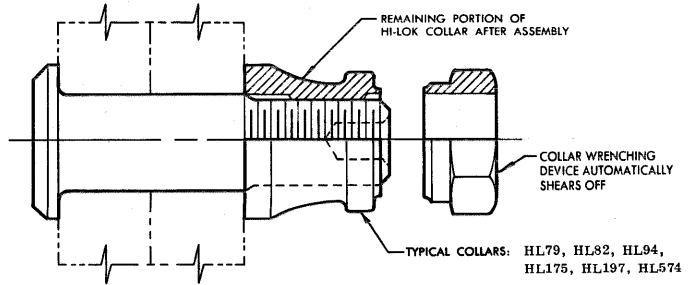
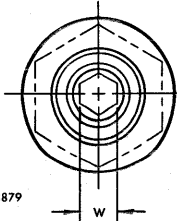
933010



INDENTED HEAD MARKING MAXIMUM DEPTH .010"
 "hs" indicates HI-SHEAR trademark.
 "VS" indicates VOI-SHAN trademark.
 "SPS" indicates STANDARD PRESSED STEEL trademark.
 The number or numbers 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	K	R RAD.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM		
				WITH-OUT SOLID FILM LUBE	WITH SOLID FILM LUBE								W HEX.	T DEPTH	Y DIA.				
-5	3/16			NOTE: Use HL644-6															
-6	13/64	.315 295	.325	.2026 2021	.2026 2016	.1840 1810	.025	.055 .045	----	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.1806 0791	.135 .115	.119 .104	8,100	3,000		
-8	17/64	.412 387	.395	.2651 2646	.2651 2641	.2440 2410	.030	.069 .059	.155 .135	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 0947	.150 .130	.142 .122	13,800	5,100		
-10	21/64	.505 475	.500	.3276 3271	.3276 3266	.3060 3020	.035	.078 .068	----	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 1270	.170 .150	.180 .160	21,100	8,000		
-12	25/64	.600 565	.545	.3901 3896	.3901 3891	.3680 3640	.040	.088 .078	----	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 1592	.200 .180	.217 .197	30,000	11,300		
-14	29/64	.676 641	.635	.4526 4521	.4526 4516	.4310 4260	.045	.105 .093	----	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 1895	.230 .210	.253 .233	40,300	15,500		
-16	33/64	.770 735	.685	.5151 5146	.5151 5141	.4930 4880	.050	.115 .103	----	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 2207	.260 .240	.269 .269	52,200	20,000		
-18	37/64	.864 829	.770	.5771 5766	.5771 5761	.5550 5500	.055	.127 .112	----	.040 .025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 2520	.260 .240	.326 .306	65,600	25,000		
-20	41/64	.953 918	.825	.6396 6391	.6396 6386	.6180 6120	.060	.137 .122	----	.040 .025	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 2520	.260 .240	.326 .306	80,600	30,200		
-24	49/64	1.108 1.066	1.050	.7646 7641	.7646 7636	.7430 7370	.070	.151 .136	----	.045 .030	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 3150	.330 .300	.398 .378	115,000	40,200		
-28	57/64	1.285 1.241	1.210	.8896 8891	.8896 8886	.8680 8610	.090	.187 .172	----	.050 .035	5/64" x 45°	7/8-14UNJF-3A Modified	.3820 3780	.400 .370	.471 .451	158,000	59,100		
-32	1-1/64	1.468 1.424	1.390	1.0146 1.0141	1.0146 1.0136	.9930 9860	.110	.218 .203	----	.060 .045	5/64" x 45°	1-12UNJF-3A Modified	.5100 5040	.520 .490	.618 .598	202,000	80,000		

GENERAL NOTES:

1. Concentricity: "A" to "D" diameter within .010 FIR.
2. Dimensions to be met after finish.
3. Surface texture per ANSI B46.1.
4. Hole preparation per NAS618.
5. Maximum "D" diameter may be increased by .0002 to allow for solid film application.
6. Use HL844 for oversize replacement.

MATERIAL:

PH13-8Mo stainless steel per Spec. AMS5629.

HEAT TREAT:

125,000 psi shear minimum.

FINISH:

- HL744-() () = Solid film lube per Spec. MIL-L-8937.
- HL744-() () () = Solid film lube per Spec. MIL-L-8937 and drilled hole.
- HL744LL-() () () = Passivate per Hi-Shear Spec. 258, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL744LL-() () () = Passivate per Hi-Shear Spec. 258, and cetyl alcohol lube per Hi-Shear Spec. 305, with drilled thread.
- HL744TB-() () () = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION:

Hi-Lok Product Specification 342.

HOW TO ORDER

EXAMPLES:

Pin Part Number Only

HL744-8-8

- 8/16 or 1/2 Maximum Grip Length
- 8/32 or 1/4 Nominal Diameter Pin
- Pin Part Number

Pin and Collar Assembly Part Number Combination

HL74479-8-8

- Size and Grip Length, see above example.
- Collar Part Number
- Pin Part Number

First dash number indicates nominal diameter in 1/32nds of the pin which HL744 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.
 "D" after second dash number indicates drilled thread.

** The Double Shear values shown are based on cross sectional area for nominal diameter pin.

"Hi-Lok" and "HL" are internationally registered trademarks of Hi-Shear Corporation.

DRAWN		DATE		TITLE	
Van		2-19-71		HI-LOK® PIN	
APPROVED		DATE		PROTRUDING SHEAR HEAD	
R.Ting		2-19-71		PH13-8Mo STAINLESS STEEL	
REVISION		DATE		DRAWING NUMBER	
5		11-19-93		HL744	