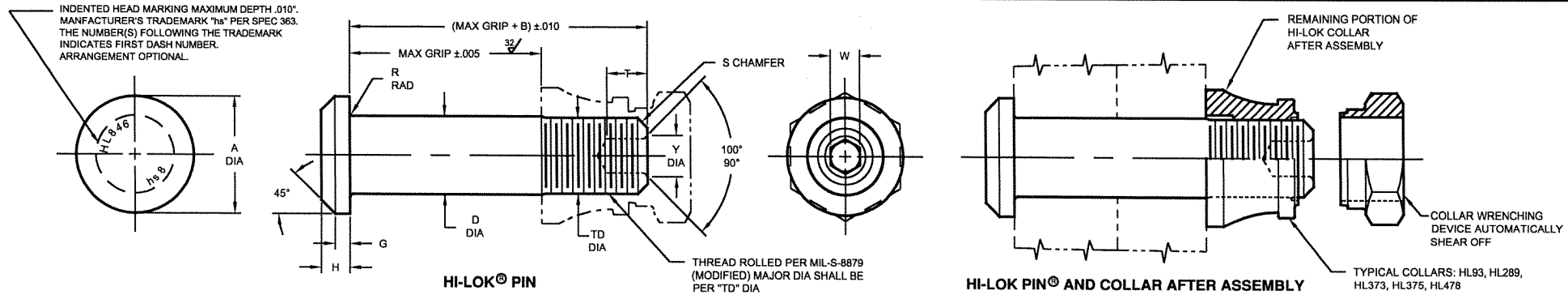


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197 a GFI AEROSPACE Company	BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE No. OLB66 a GFI AEROSPACE Company
AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A. & Canada) CAGE No. 06725	HUCK S.A. France (Licensee - ECC Countries)
HUCK INTERNATIONAL, INC., U.S.A. (Licensee) CAGE No. 97928	BLANC AERO S.A. France (Licensee - ECC Countries)
SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878	a GFI AEROSPACE Company
FAIRCHILD Aerospace Fastener Division (Licensee) CAGE No. 92215	TOKYO SCREW COMPANY, Japan (Licensee - Japan)
WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516 (Pins & Steel Collars)	



FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING, PLATING, S.F.L.	AFTER COATING, PLATING, S.F.L.							W HEX	T DEPTH	Y DIA		
5	13/64			NOTE: USE HL746-6(-)												
6	7/32	.390 .370	.325	.2182 .2177	.2182 .2172	.1840 .1810	.035	.074 .064	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	9,400	4,350
8	9/32	.460 .435	.395	.2807 .2802	.2807 .2797	.2440 .2410	.045	.090 .080	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	15,500	7,750
10	11/32	.520 .490	.500	.3432 .3427	.3432 .3422	.3060 .3020	.055	.112 .102	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	23,200	12,300
12	13/32	.620 .585	.545	.4057 .4052	.4057 .4047	.3680 .3640	.075	.140 .130	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	32,400	19,100
14	15/32	.695 .660	.635	.4682 .4677	.4682 .4672	.4310 .4260	.095	.160 .150	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	43,100	25,800
16	17/32	.790 .755	.685	.5307 .5302	.5307 .5297	.4930 .4880	.095	.188 .178	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	55,400	34,300
18	19/32	.905 .870	.770	.5927 .5922	.5927 .5917	.5550 .5500	.125	.210 .200	.040 .025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	69,200	43,500
20	21/32	.975 .940	.825	.6552 .6547	.6552 .6542	.6180 .6120	.140	.238 .228	.040 .025	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	84,500	54,600
24	25/32	1.185 1.145	1.050	.7802 .7797	.7802 .7792	.7430 .7370	.200	.335 .320	.045 .030	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.330 .300	.398 .378	120,000	79,200
28	29/32	1.375 1.335	1.210	.9052 .9047	.9052 .9042	.8680 .8610	.250	.385 .370	.050 .035	5/64" x 45°	7/8-14UNJF-3A Modified	.3820 .3780	.400 .370	.471 .451	161,000	117,000
32	1-1/32	1.550 1.510	1.390	1.0302 1.0297	1.0302 1.0292	.9930 .9860	.300	.435 .420	.060 .045	5/64" x 45°	1-12UNJF-3A Modified	.5100 .5040	.520 .490	.618 .598	209,000	143,000

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

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 2. Dimensions to be met after finish.
 3. Surface texture per ANSI B46.1.
 4. Hole preparation per NAS618.
 5. Oversize pin for HL846 and HL746.

MATERIAL: PH13-8Mo stainless steel per AMS5629.

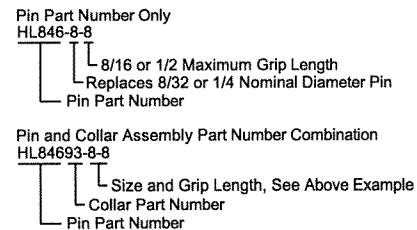
HEAT TREAT: 125,000 psi shear minimum.

- FINISH:**
- HL846-(-)(-) = Solid film lube per AS5272.
 - HL846AP(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL846LL(-)(-) = Passivate per Hi-Shear Spec. 262, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL846TB(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL846PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lok Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL846 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER EXAMPLE:



"Hi-Lok" and "HL" are internationally registered trademark of Hi-Shear Corporation.		
DRAWN	DATE	TITLE
Van	11-22-71	HI-LOK® PIN
APPROVED	DATE	PROTRUDING TENSION HEAD PH13-8Mo STAINLESS STEEL 1/16" GRIP VARIATION, 1/32" OVERSIZE
R.Ting	11-23-71	
REVISION	DATE	DRAWING NUMBER
⑥	JFO 3-14-01	HL846

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HL846