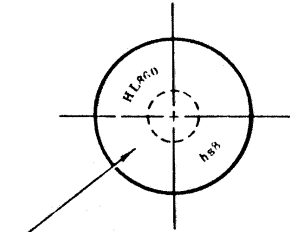


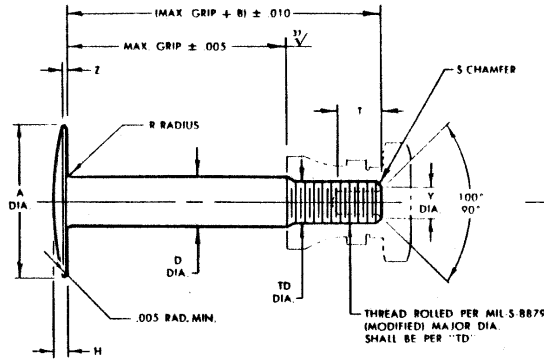
STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

HI-SHEAR CORPORATION U.S.A. (Patent Holder) U.S. Federal Code No. 73197	HI-SHEAR FASTENERS EUROPE LTD. U.K. (Licensee) Division of Hi-Shear Industries Inc. U.S.A.
AIR INDUSTRIES CO. INC. (Licensee) U.S. & Canada U.S. Federal Code No. 08725	KAMAX WERKE, Germany (Licensee - EEC Countries) Rudolph Kallmann GmbH & Co.
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WEST COAST AEROSPACE INC. U.S.A. (Licensee) U.S. Federal Code No. 62516	TOKYO SCREW COMPANY, Japan (Licensee - Japan)

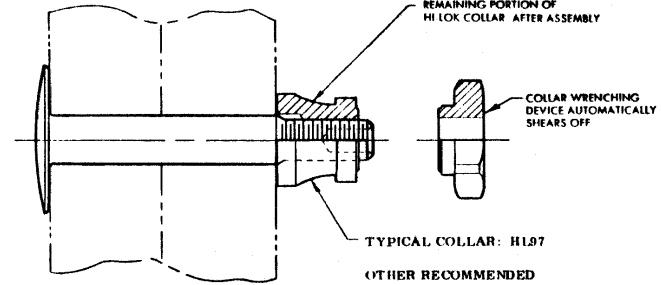
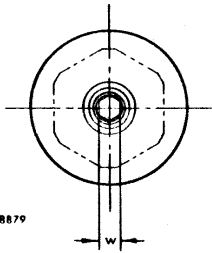


INDENTED HEAD MARKING MAXIMUM DEPTH .010"
"h" indicates HI-SHEAR trademark.
The number(s) following the trademark indicate first dash number. Arrangement optional.



HI-LOK PIN

1



TYPICAL COLLAR: HL97

OTHER RECOMMENDED HI-LOK COLLARS:
HCL74, HCL174, HLN1, HL195, HL276, HL29R.

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA. 6		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	.530 .490	.312	.1635 .1630	.1635 .1625	.1595 .1570	.004	.045 .041	.025 .015	.025	1/32" x 37°	8-32UNJ(-)3A Modified	.0801 .0791	.135 .115	5	4,010	1,940
-6	3/16	.620 .565	.325	.1895 .1890	.1895 .1885	.1840 .1810	.005	.053 .047	.025 .015	.025	1/32" x 37°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	5,380	2,500
-8	1/4	.805 .750	.395	.2495 .2490	.2495 .2485	.2440 .2410	.006	.068 .062	.025 .015	.030	1/32" x 37°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	9,300	4,300
-10	5/16	.980 .920	.500	.3120 .3115	.3120 .3110	.3060 .3020	.007	.080 .074	.030 .020	.030	3/64" x 37°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	14,600	6,300
-12	3/8	1.185 1.125	.545	.3745 .3740	.3745 .3735	.3680 .3640	.008	.096 .089	.030 .020	.030	3/64" x 37°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	21,000	8,700

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
 - "H" dimensioned from maximum "D" diameter.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - Evidence of broken edges across points.
 - Dimensions to be met after finish.

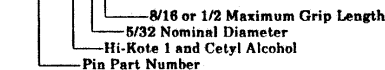
MATERIAL: 6A1-4V titanium alloy per Spec. AMS4928 or AMS4987.
HEAT TREAT: 95,000 psi shear minimum.

- FINISH:**
- HL860-(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL860AP-(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL860BA-(-)(-) = I.V.D. aluminum plating per BAC5315 with color red on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL860AZ-(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lok Product Specification 342.

HOW TO ORDER EXAMPLE:

Pin Part Number
HL860AP-5-8



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.

NOTE!
GRIP LENGTH IN 16th INCH INCREMENTS.

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

DRAWN DATE D.P.S 12-11-80	TITLE HI-LOK® PIN PROTRUDING SHEAR HEAD TITANIUM COMPOSITE APPLICATIONS 1/16" GRIP VARIATION
APPROVED DATE T. Craine 1-8-93	DRAWING NUMBER HL860
REVISION 1	

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HL860