STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

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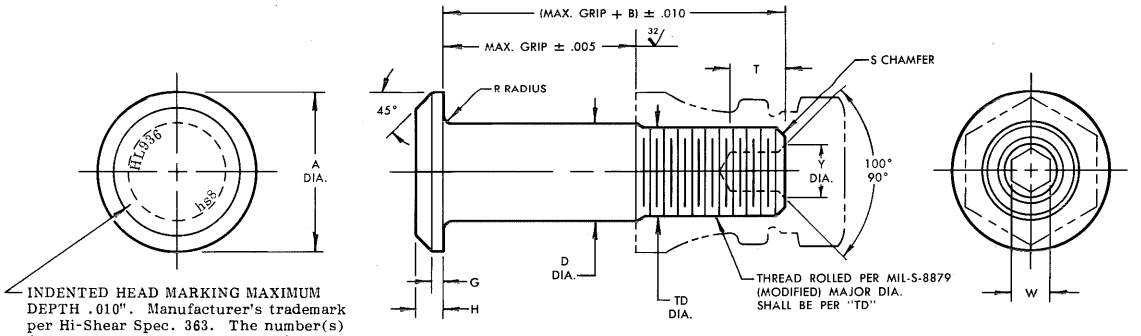
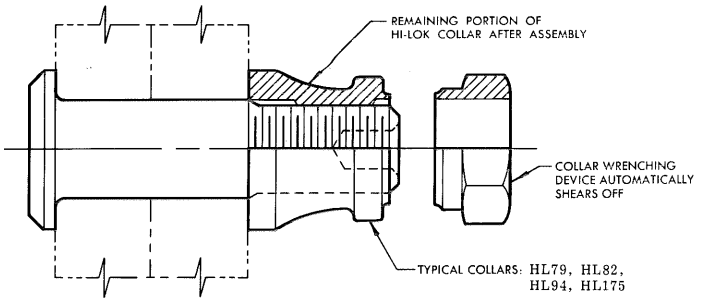
HI-SHEAR CORPORATION, U.S.A. (Patent Holder) — U.S. Federal Code No. 73197 Division of Hi-Shear Industries Inc., U.S.A.	HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee) Division of Hi-Shear Industries Inc., U.S.A.
AIR INDUSTRIES CO., INC. (Licensee - U.S. & Canada) — U.S. Federal Code No. 06725	KAMAX-WERKE, Germany — (Licensee - EEC Countries)
DEUTSCH FASTENER CO., INC. — (Licensee) — U.S. Federal Code No. 97928	Rudolph Kellerman GmbH & Co.
SPS TECHNOLOGIES, U.S.A. — (Licensee) — U.S. Federal Code No. 56878	ST. CHAMOND GRANAT, S.A. France — (Licensee - EEC Countries)
VOI-SHAN, Division of VSI Corp., U.S.A. (Licensee) — U.S. Federal Code No. 92215	SIMMONDS, S.A. France — (Licensee - EEC Countries-Collars)
WEST COAST AEROSPACE INC., U.S.A. (Licensee-Pins & Steel Collars) — U.S. Federal Code No. 80516	TOKYO SCREW COMPANY, Japan — (Licensee - Japan)



HI-LOK PIN



HI-LOK PIN AND COLLAR AFTER ASSEMBLY

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FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA. WITHOUT PLATING OR COATING	D DIA. WITH PLATING OR COATING	TD DIA.	G REF.	H	R RAD.		S CHAMFER REF.	THREAD	SOCKET W HEX.	SOCKET T DEPTH	SOCKET Y DIA.	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
–5				NOTE: Use HL754-6													
–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	.0806 .0791	.100 .080	.119 .104	8,100	3,000
–8	17/64	.412 .387	.395	.2651 .2646	.2651 .2641	.2440 .2410	.030	.069 .059	.025 .015		1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.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	.130 .110	.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 .1582	.160 .140	.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	.190 .170	.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	.220 .200	.289 .269	52,200	20,000

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

GENERAL NOTES:
1. Concentricity: "A" to "D" diameter within .010 FIR.
2. Dimensions to be met after finish.
3. Surface texture per ANSI B46.1.
4. Hole preparation per NAS618.
5. Use HL946 for oversize replacement.

MATERIAL: Nickel base alloy per AMS5662.

HEAT TREAT: 125,000 psi shear minimum (220,000 psi tension minimum).

FINISH:
HL936-( )-( ) = Passivate per Hi-Shear Spec. 258, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL936AP-( )-( ) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL936JT-( )-( ) = Passivate per Hi-Shear Spec. 258, with light blue identification on top of head, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL936PB-( )-( ) = Cadmium plate per 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 HL936 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See "Finish" note for explanation of code letters.

HOW TO ORDER EXAMPLES:

Pin Part Number Only
HL936AP-8-8
- 8/16 or 1/2 Maximum Grip Length
- Replaces 8/32 or 1/4 Nominal Diameter Pin
- Pin Part Number with Hi-Kote 1

Pin and Collar Assembly Part Number Combination
HL936AP79-8-8
- Size and Grip Length, See Above Example
- Collar Part Number
- Pin Part Number

DRAWN	DATE
D. P. S.	2-3-87
APPROVED	DATE
JG Wilcox	2-4-87
REVISION	DATE
②	T. Craine 11-23-93

hi-Lok® PIN

PROTRUDING SHEAR HEAD
NICKEL BASE ALLOY (INCONEL 718)
1/16" GRIP VARIATION—1/64" OVERSIZE

DRAWING NUMBER
HL936

HL936