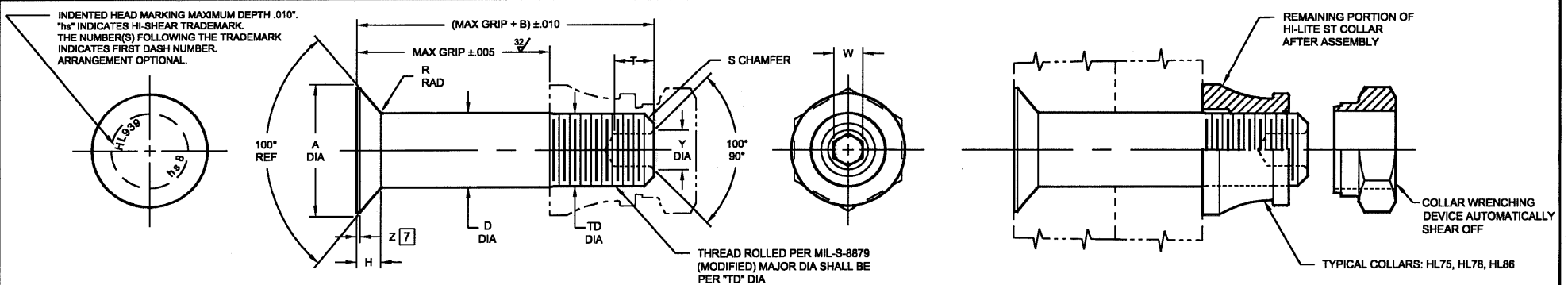


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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

| | |
|---|---|
| HI-SHEAR CORPORATION, U.S.A.—(Patent Holder) CAGE No. 73197 | HI-SHEAR FASTENERS EUROPE, LTD., U.K.—(Licensee) CAGE No. 0LB68 |
| a GFI AEROSPACE Company | 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. 87828 | BLANC AERO S.A. France—(Licensee - ECC Countries) |
| SBS 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. 60616 | |
| (Pins & Steel Collars) | |



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 | | | | | | | | | | | | | | | | |
| NOTE: USE HL731-6(-). | | | | | | | | | | | | | | | | | |
| 6 | 13/64 | .3813 .3785 | .325 | .2026 .2021 | .2026 .2016 | .1840 .1810 | .005 | .0750 .0730 | .030 .020 | .015 | 1/32" x 45° | 10-32UNJF-3A Modified | .0806 .0791 | .135 .115 | .119 .104 | 8,100 | 4,350 |
| 8 | 17/64 | .5066 .5018 | .395 | .2651 .2646 | .2651 .2641 | .2440 .2410 | .006 | .1013 .0993 | .030 .020 | .015 | 1/32" x 45° | 1/4-28UNJF-3A Modified | .0967 .0947 | .150 .130 | .142 .122 | 13,800 | 7,750 |
| 10 | 21/64 | .6335 .6287 | .500 | .3276 .3271 | .3276 .3266 | .3060 .3020 | .007 | .1283 .1263 | .040 .030 | .015 | 3/64" x 45° | 5/16-24UNJF-3A Modified | .1295 .1270 | .170 .150 | .180 .160 | 21,100 | 12,300 |
| 12 | 25/64 | .7604 .7556 | .545 | .3901 .3896 | .3901 .3891 | .3680 .3640 | .008 | .1563 .1533 | .040 .030 | .015 | 3/64" x 45° | 3/8-24UNJF-3A Modified | .1617 .1582 | .200 .180 | .217 .197 | 30,000 | 19,100 |
| 14 | 29/64 | .8884 .8812 | .635 | .4526 .4521 | .4526 .4516 | .4310 .4260 | .009 | .1828 .1798 | .050 .040 | .022 | 3/64" x 45° | 7/16-20UNJF-3A Modified | .1930 .1895 | .230 .210 | .253 .233 | 40,300 | 25,800 |
| 16 | 33/64 | 1.0139 1.0068 | .685 | .5151 .5146 | .5151 .5141 | .4930 .4880 | .010 | .2093 .2063 | .050 .040 | .022 | 3/64" x 45° | 1/2-20UNJF-3A Modified | .2242 .2207 | .260 .240 | .289 .269 | 52,500 | 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.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - Curved or flat edge manufacturer's option.
 - Use H949 for oversize replacement.
 - Non-lubed pin must be used with wet sealant or with lubed collars.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL939 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER EXAMPLE:

Pin Part Number Only
HL939-8-8
|
| 8/16 or 1/2 Maximum Grip Length
| Replaces 8/32 or 1/4 Nominal Diameter Pin
| Pin Part Number

Pin and Collar Assembly Part Number Combination
HL93986-8-8
|
| Size and Grip Length, See Above Example
| Collar Part Number
| Pin Part Number

MATERIAL: Nickel base alloy per AMS5662.

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

- FINISH:**
- HL939-(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL939AP(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL939JT(-) = Passivate per Hi-Shear Spec. 258, with light blue identification on top of head, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL939PB(-) = Cadmium plate per QQ-P-416, Type II, Class 2., and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL939PY(-) = Passivate per Hi-Shear Spec. 258.

SPECIFICATION: HI-Lok Product Specification 342.

| | | |
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| "Hi-Lok" and "HL" are internationally registered trademark of Hi-Shear Corporation. | | |
| DRAWN JF.Obispo | DATE 6-5-00 | TITLE HI-LOK® PIN |
| APPROVED <i>G. Rowland</i> | DATE 6/5/00 | 100° FLUSH MS24694 TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16" GRIP VARIATION, 1/64" OVERSIZE |
| REVISION - | DATE - | DRAWING NUMBER HL939 |

HL939