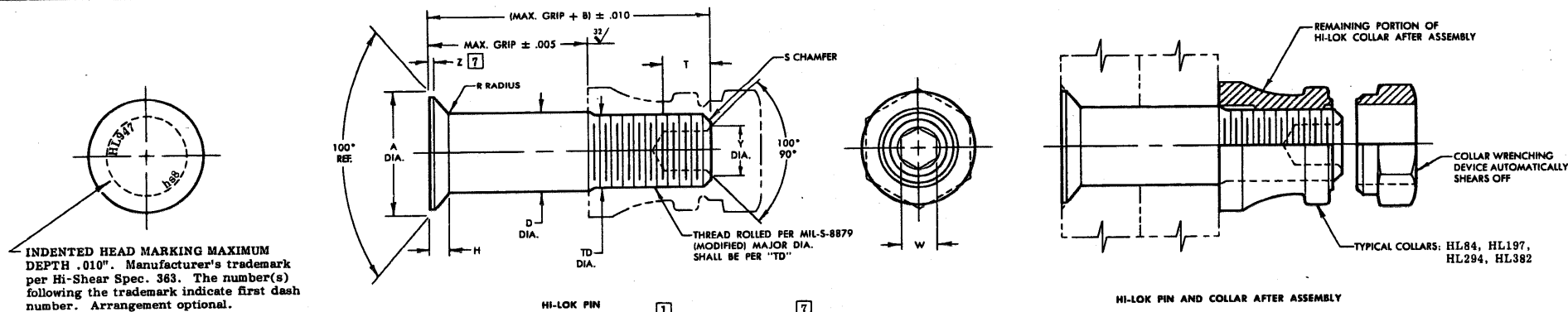


**STANDARDS COMMITTEE  
FOR HI-LOK® PRODUCTS**  
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) U.S. Federal Code I.D. No. 73197  
 Division of Hi-Shear Industries Inc., U.S.A. (Licensee) — EEC Countries)  
 AIRCRAFT FASTENERS (Forged Parts) LTD., U.K. (Licensee) — EEC Countries)  
 Division of Hi-Shear Industries Inc., U.S.A. (Licensee) — EEC Countries—Collars)  
 HI-SHEAR, Division of VSI Corp., U.S.A. (Licensee) — EEC Countries—Japan)  
 SPS TECHNOLOGIES, U.S.A. (Licensee) — EEC Countries—OverSize Pins & Steel Collars)  
 ST. CHAMOND-GRANAT, S.A. France (Licensee) — EEC Countries)  
 KANAX-WERKE, Germany (Licensee) — EEC Countries)  
 Rudolph Kötterman GmbH & Co. (Licensee) — EEC Countries—Collars)  
 SIMMONDS, S.A. France (Licensee) — EEC Countries—Japan)  
 TOKYO SCREW COMPANY, Japan (Licensee) — EEC Countries—OverSize Pins & Steel Collars)  
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) — EEC Countries—OverSize Pins & Steel Collars)  
 U.S. Federal Code I.D. No. 60516



INDENTED HEAD MARKING MAXIMUM DEPTH .010". Manufacturer's trademark per Hi-Shear Spec. 363. The number(s) following the trademark indicate first dash number. Arrangement optional.

FIRST DASH NO.	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 PLATING OR COATING	WITH PLATING OR COATING								W HEX.	T DEPTH	Y DIA.		
-5				NOTE: Use HL937-6													
-6	7/32	.3308 .3253	.325	.2182 .2177	.2182 .2172	.1840 .1810	.005	.0472 .0449	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	9,400	2,600
-8	9/32	.4265 .4210	.395	.2807 .2802	.2807 .2797	.2440 .2410	.006	.0612 .0589	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0987 .0947	.110 .090	.142 .122	15,500	4,400
-10	11/32	.5056 .5001	.500	.3432 .3427	.3432 .3422	.3060 .3020	.007	.0681 .0658	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	23,200	7,000
-12	13/32	.5921 .5866	.545	.4057 .4052	.4057 .4047	.3680 .3640	.008	.0782 .0759	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	32,400	10,000
-14	15/32	.6997 .6932	.635	.4682 .4677	.4682 .4672	.4310 .4260	.009	.0971 .0944	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	43,100	13,500
-16	17/32	.7857 .7792	.685	.5307 .5302	.5307 .5297	.4930 .4880	.010	.1070 .1043	.060 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	55,400	18,000

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 FIR.
  - "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.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL947 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  
 HL947AP-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  
 HL947AP84-8-8  
 — 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 (220,000 psi tension minimum).
- FINISH: HL947-( )-( ) = Passivate per Hi-Shear Spec. 258, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HL947AP-( )-( ) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HL947JT-( )-( ) = Passivate per Hi-Shear Spec. 258, with light blue identification on top of head, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HL947PB-( )-( ) = 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.

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

DRAWN	DATE	 100° FLUSH SHEAR HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16" GRIP VARIATION-1/32" OVERSIZE
D. P. S.	2-3-87	
APPROVED	DATE	DRAWING NUMBER
<i>J. Swilley</i>	2-4-87	
REVISION	DATE	
①	D. P. S. 4-14-87	