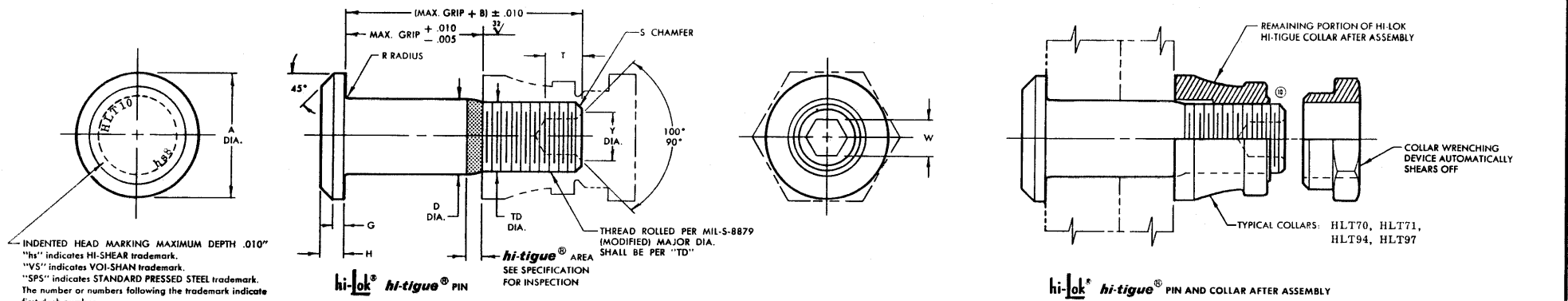


**STANDARDS COMMITTEE FOR
HI-LOK® HI-TIGUE® PRODUCTS**
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

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.
 AIRCRAFT FASTENERS (Forged Parts) LTD., U.K. (Licensee)
 Division of Hi-Shear Industries Inc., U.S.A.
 YOK-SHAN, Division of VSI Corp., U.S.A. (Licensee) U.S. Federal Code I.D. No. 92215
 SPS TECHNOLOGIES, U.S.A. (Licensee) U.S. Federal Code I.D. No. 56879
 LITTON FASTENING SYSTEMS, U.S.A. (Licensee) U.S. Federal Code I.D. No. 87928
 Division of Litton Systems Inc., U.S.A.
 ST. CHAMOND-GRANAT, S.A. France (Licensee—EEC Countries)
 KAMAX-WERKE, Germany (Licensee—EEC Countries)
 Rudolph Kellerman GmbH & Co.
 SHIMMONDS, S.A. France (Licensee—EEC Countries—Collars)
 TOKYO SCREW COMPANY, Japan (Licensee—Japan)
 WEST COAST AEROSPACE INC., U.S.A. (Licensee—Oversize Pins & Steel Collars)
 U.S. Federal Code I.D. No. 60516



| FIRST DASH NO. | 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 OR SOLID FILM LUBE | WITH COATING OR SOLID FILM LUBE | | | | | | | W HEX. | T DEPTH | Y DIA. | | |
| -5 | 5/32 | .262 .242 | .312 | .1695 .1690 | .1695 .1685 | .1595 .1570 | .020 | .047 .037 | .025 .015 | 1/32" x 37° | 8-32UNJC-3A Modified | .0645 .0635 | .100 .080 | .090 .075 | 4,210 | 1,940 |
| -6 | 3/16 | .315 .295 | .325 | .1955 .1950 | .1955 .1945 | .1840 .1810 | .025 | .055 .045 | .025 .015 | 1/32" x 37° | 10-32UNJF-3A Modified | .0806 .0791 | .100 .080 | .119 .104 | 5,550 | 2,500 |
| -8 | 1/4 | .412 .387 | .395 | .2555 .2550 | .2555 .2545 | .2440 .2410 | .030 | .069 .059 | .025 .015 | 1/32" x 37° | 1/4-28UNJF-3A Modified | .0967 .0947 | .110 .090 | .142 .122 | 9,620 | 4,300 |
| -10 | 5/16 | .505 .475 | .500 | .3180 .3175 | .3180 .3170 | .3060 .3020 | .035 | .078 .068 | .030 .020 | 3/64" x 37° | 5/16-24UNJF-3A Modified | .1295 .1270 | .130 .110 | .180 .160 | 14,890 | 6,300 |
| -12 | 3/8 | .600 .565 | .545 | .3805 .3800 | .3805 .3795 | .3680 .3640 | .040 | .088 .078 | .030 .020 | 3/64" x 37° | 3/8-24UNJF-3A Modified | .1617 .1582 | .160 .140 | .217 .197 | 21,430 | 8,700 |
| -14 | 7/16 | .676 .641 | .635 | .4430 .4425 | .4430 .4420 | .4310 .4260 | .045 | .105 .093 | .030 .020 | 3/64" x 37° | 7/16-20UNJF-3A Modified | .1930 .1895 | .190 .170 | .253 .233 | 29,000 | 12,100 |
| -16 | 1/2 | .770 .735 | .685 | .5055 .5050 | .5055 .5045 | .4930 .4880 | .050 | .115 .103 | .030 .020 | 3/64" x 37° | 1/2-20UNJF-3A Modified | .2242 .2207 | .220 .200 | .289 .269 | 37,900 | 15,300 |

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 (Column "B") for interference application.
 5. Use HLT110 for oversize replacement.
 6. Install per Hi-Shear Spec. 299.

MATERIAL: 6Al-4V titanium alloy per Spec. AMS4928 or AMS4967.

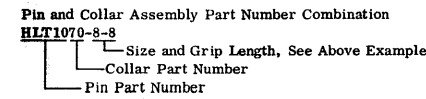
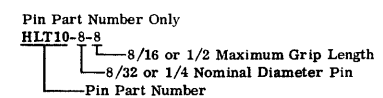
HEAT TREAT: 95,000 psi shear minimum.

- FINISH:
- HLT10-()-() = Cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT10AP-()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT10BJ-()-() = I. V. D. aluminum coating per MIL-C-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT10BV-()-() = I. V. D. aluminum coating per MIL-C-83488, Type II, Class 3, with color code blue on thread end.
 - HLT10TB-()-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lok Hi-Tigue Product Specification 342.

CODE: First dash number indicates nominal diameter in 32nds. Second dash number indicates maximum grip in 16ths. See "Finish" note for explanation of code letters.

HOW TO ORDER EXAMPLES:



U.S. patents 3,390,906; 3,578,367; and foreign patents. "Hi-Lok," "HL," "Hi-Tigue," and "HLT" are Registered Trademarks of Hi-Shear Corporation.

| | | |
|----------|---------------------|---|
| DRAWN | DATE | hi-lok hi-tigue PIN PROTRUDING SHEAR HEAD TITANIUM 1/16" GRIP VARIATION |
| VAN | 6-28-68 | |
| APPROVED | DATE | DRAWING NUMBER HLT10 |
| R. TING | 7-25-68 | |
| REVISION | DATE | |
| (10) | D. P. S. 5-22-84 | |

HLT10