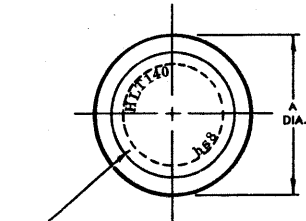


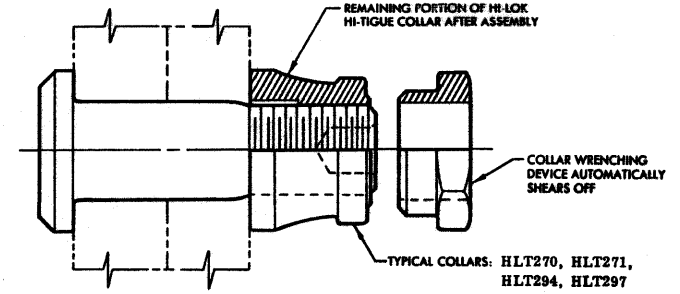
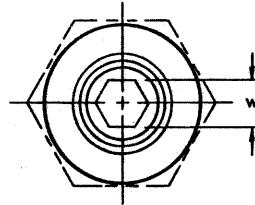
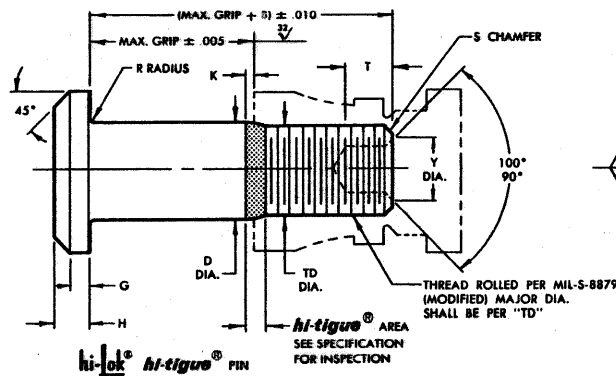
STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) -- U.S. Federal Code No. 73197 Division of Hi-Shear Industries Inc., U.S.A.	HUCK International, GmbH & Co. Germany (Licensee) EEC Countries (Licensee - EEC Countries)
AIR INDUSTRIES CO., INC. (Licensee - U.S. & Canada) -- U.S. Federal Code No. 06726	ST. CHAMOND GRANAT, S.A. France (Licensee - EEC Countries)
SPS TECHNOLOGIES, U.S.A. (Licensee) -- U.S. Federal Code No. 66878	SIMMONDS, S.A. France (Licensee - EEC Countries-Collars)
VOI-SHAN, Division of VSI Corp., U.S.A. (Licensee) -- U.S. Federal Code No. 92215	TOKYO SCREW COMPANY, Japan (Licensee - Japan)
WEST COAST AEROSPACE INC., U.S.A. (Licensee) -- U.S. Federal Code No. 60516 (Pins & Steel Collars)	



INDENTED HEAD MARKING MAXIMUM DEPTH .010"
"ht" or "H" or no letter indicates HI-SHEAR trademark.
"vys" indicates VOI-SHAN trademark.
"SPS" indicates STANDARD PRESSED STEEL trademark.
The number or numbers following the trademark indicate first dash number.

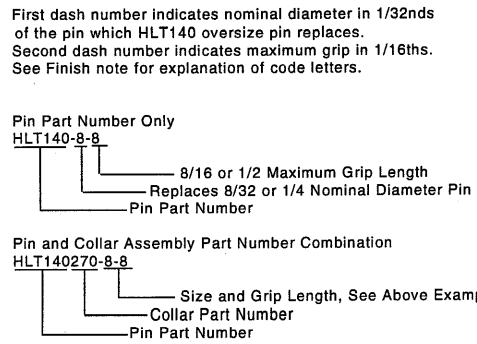


hi-lok hi-tigue® PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.		TD DIA.	G REF.	H	K REF.	R RAD.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT HI-KOTE™ LUBE	WITH HI-KOTE™ LUBE								W HEX.	T DEPTH	Y DIA.		
5																	
NOTE: Use HLT40-6																	
6	13/64	.315 .295	.360	.2026 .2021	.2026 .2016	.1840 .1810	.025	.055 .045	.020	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	6,130	2,500
8	17/64	.412 .387	.435	.2651 .2646	.2651 .2641	.2440 .2410	.030	.069 .059	.025	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	10,490	4,300
10	21/64	.505 .475	.545	.3276 .3271	.3276 .3266	.3060 .3020	.035	.078 .068	.031	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	16,000	6,300
12	25/64	.600 .565	.590	.3901 .3896	.3901 .3891	.3680 .3640	.040	.088 .078	.037	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	22,700	8,700
14	29/64	.676 .641	.690	.4526 .4521	.4526 .4516	.4310 .4260	.045	.105 .093	.039	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	30,600	12,100
16	33/64	.770 .735	.740	.5151 .5146	.5151 .5141	.4930 .4880	.050	.116 .103	.045	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	39,600	15,300
18	37/64	.864 .829	.825	.5771 .5766	.5771 .5761	.5550 .5500	.055	.127 .112	.043	.040 .025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	49,700	19,000

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

- GENERAL NOTES:**
- Concentricity: "A" to "D" diameter within .010 FIR.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - Use HLT240 for oversize replacement.
- MATERIAL:** A-286 high temperature alloy per AMS5731 or AMS5737.
- HEAT TREAT:** 95,000 psi shear minimum at 70°F.
- FINISH:** HLT140-(-)(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT140TB-(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT140TC-(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, except top surface of head shall be uncoated, and cetyl alcohol lube per Hi-Shear Spec. 305.
- SPECIFICATION:** Hi-Lok Hi-Tigue Product Specification 342 and 342-2.
- HOW TO ORDER EXAMPLE:**



"Hi-Lok", "HL", "Hi-Tigue", and "HLT" are internationally registered trademarks of Hi-Shear Corporation.		
DRAWN	DATE	TITLE
Van	6-10-72	HI-LOK® HI-TIGUE® PIN PROTRUDING SHEAR HEAD A-286 HIGH TEMPERATURE ALLOY 1/16" GRIP VARIATION, 1/64" OVERSIZE
APPROVED	DATE	DRAWING NUMBER
J. Wilcox	6-16-72	HLT140
REVISION	DATE	
②	J.F. Obispo 11-07-94	

HLT140