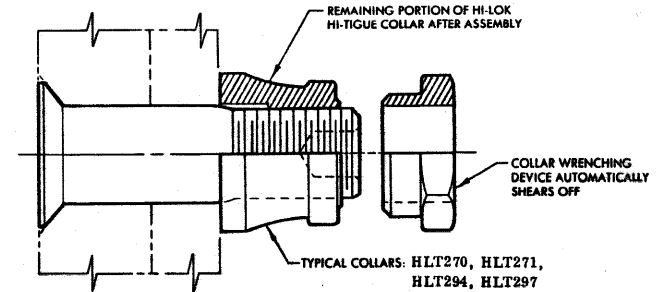
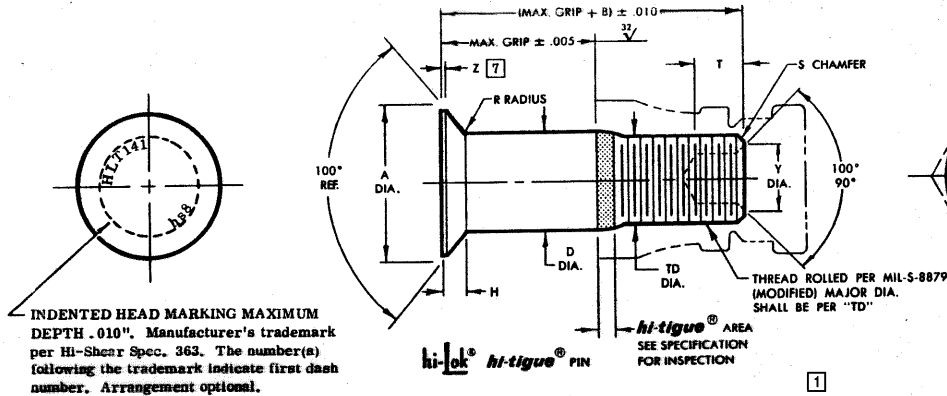


STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
 Division of Hi-Shear Industries Inc., U.S.A.
 AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S. & Canada) CAGE No. 06725
 HUCK INTERNATIONAL, INC., Deutsch Operation, U.S.A. (Licensee) CAGE No. 97928
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878
 FAIRCHILD Aerospace Fastener Division, U.S.A. (Licensee) CAGE No. 92216
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516
 (Pin & Sleeve Collars)

HI-SHEAR FASTENERS EUROPE, LTD., UK (Licensee) - CAGE No. 0LB88
 Division of Hi-Shear Industries Inc., U.S.A.
 HUCK INTERNATIONAL GMBH & CO., Germany (Licensee - EEC Countries)
 SAINT CHAMOND GRANAT, S.A. France (Licensee - EEC Countries)
 SIMMONDS S.A., France (Licensee - EEC Countries-Collars)
 TOKYO SCREW COMPANY, Japan (Licensee - Japan)



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

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 HI-KOTE™ LUBE	WITH HI-KOTE™ LUBE								W HEX.	T DEPTH	Y DIA.		
5																	
NOTE: Use HLT41-6																	
6	13/64	.3016 .2966	.360	.2026 .2021	.2026 .2016	.1840 .1810	.005	.0415 .0394	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	6,130	2,000
8	17/64	.3948 .3898	.435	.2651 .2646	.2651 .2641	.2440 .2410	.006	.0544 .0523	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	10,490	3,700
10	21/64	.4739 .4689	.545	.3276 .3271	.3276 .3266	.3060 .3020	.007	.0614 .0593	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	16,000	5,000
12	25/64	.5604 .5554	.590	.3901 .3896	.3901 .3891	.3680 .3640	.008	.0714 .0693	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	22,700	7,200
14	29/64	.6680 .6620	.690	.4526 .4521	.4526 .4516	.4310 .4260	.009	.0904 .0879	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	30,600	10,000
16	33/64	.7540 .7480	.740	.5151 .5146	.5151 .5141	.4930 .4880	.010	.1002 .0977	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	39,600	13,500
18	37/64	.8380 .8310	.825	.5771 .5766	.5771 .5761	.5550 .5500	.010	.1094 .1065	.050 .040	.022	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	49,700	17,000

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

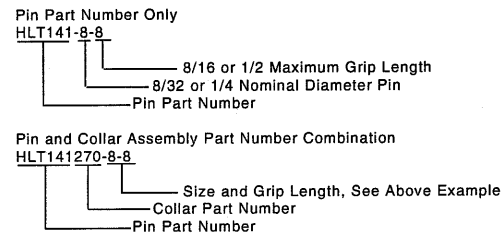
GENERAL NOTES:

- 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.
- Surface texture per ANSI B46. 1.
- Hole preparation per NAS618.
- Use HLT241 for oversize replacement.
- Curved or flat edge manufacturer's option.

CODE:

First dash number indicates nominal diameter in 1/32nds of the pin which HLT141 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER EXAMPLE:



MATERIAL: A-286 high temperature alloy per AMS5731 or AMS5737.

HEAT TREAT: 95,000 psi shear minimum at 70°F.

FINISH: HLT141(-)(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT141TB(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT141TC(-)(-) = 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.

"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 100° FLUSH SHEAR HEAD A-286 HIGH TEMPERATURE ALLOY 1/16" GRIP VARIATION, 1/64" OVERSIZE
APPROVED	DATE	DRAWING NUMBER
J. Wilcox	6-15-72	HLT141
REVISION	DATE	
③	J.F. Obispo 11-07-94	