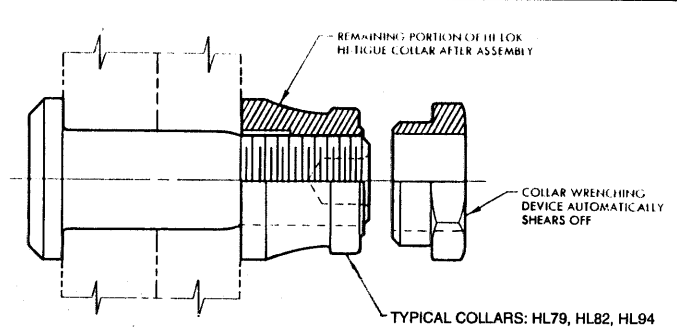
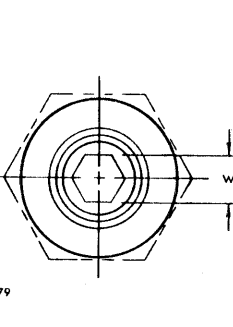
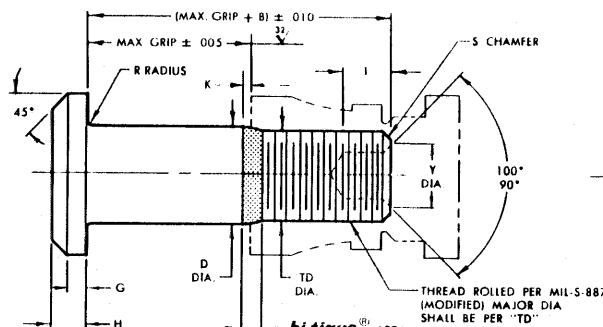
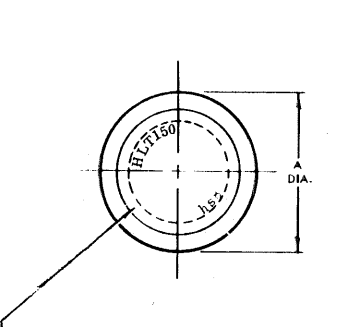


STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73 97
 A Subsidiary of GPI Industries, France
 AIR INDUSTRIES CO., INC. U.S.A. (Licensee - U.S. & Canada) CAGE No. 06726
 HUCK INTERNATIONAL, INC., Deutsch Operation, U.S.A. (Licensee) CAGE No. 97928
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 58878
 FAIRCILD Aerospace Fastener Division, U.S.A. (Licensee) CAGE No. 82216
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 86618
 (Pins & Steel Collars)

HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee) - CAGE No. 0LB88
 A Subsidiary of GPI Industries, France
 HUCK S.A. (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)



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.

HI-LOK HI-TIGUE PIN

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
												W HEX.	T DEPTH	Y DIA.		
5	3/16															
NOTE: Use HLT50-6																
6	13/64	.315 .295	.360	.2026 .2021	.1840 .1810	.025	.055 .045	.016	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	8,100	3,000
8	17/64	.412 .387	.435	.2651 .2646	.2440 .2410	.030	.069 .059	.021	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	13,800	5,100
10	21/64	.505 .475	.545	.3276 .3271	.3060 .3020	.035	.078 .068	.026	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	21,100	8,000
12	25/64	.600 .565	.590	.3901 .3896	.3680 .3640	.040	.088 .078	.030	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	30,000	11,300
14	29/64	.676 .641	.690	.4526 .4521	.4310 .4260	.045	.105 .093	.035	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	40,300	15,500
16	33/64	.770 .735	.740	.5151 .5146	.4930 .4880	.050	.116 .103	.039	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	52,200	20,000

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

④ GENERAL NOTES:

- Concentricity: "A" to "D" diameter within .010 FIM.
- Dimensions to be met before finish
- Surface texture per ANSI B46. 1.
- Hole preparation per NAS618.
- Use HLT250 for oversize replacement.

CODE:

First dash number indicates nominal diameter in 1/32nds which HLT150 oversize replaces.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

MATERIAL:

PH13-8Mo stainless steel per Spec. AMS5629.

HEAT TREAT:

125,000 psi shear minimum.

FINISH:

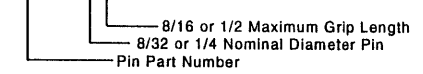
- HLT150(-)(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT150DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT150TB(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION:

Hi-Lok Hi-Tigue Product Specification 342.

HOW TO ORDER EXAMPLE:

Pin Part Number Only
HLT150TB-8-8



"Hi-Lok", "HL", "Hi-Tigue", and "HLT" are internationally registered trademarks of Hi-Shear Corporation.	
DRAWN DATE D.P.S. 6-8-77	TITLE HI-LOK® HI-TIGUE® PIN PROTRUDING SHEAR HEAD PH13-8Mo STAINLESS STEEL 1/16" GRIP VARIATION - 1/64" OVS
APPROVED DATE RTing 6-8-77	DRAWING NUMBER HLT150
REVISION DATE ④ J.Henderson 4-29-98	

HLT150