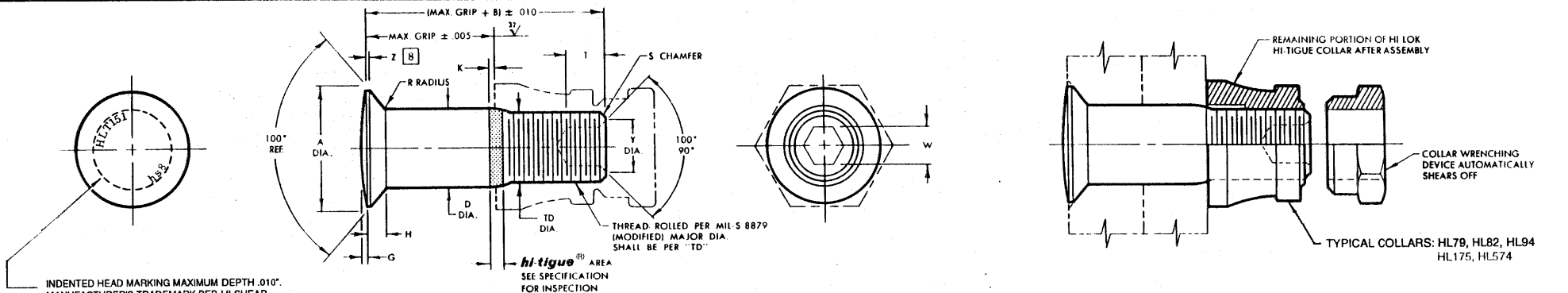


STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder)	CAGE No. 73197	WEST COAST AEROSPACE INC., U.S.A. (Licensee - U.S. & Canada)	CAGE No. 60516
AIR INDUSTRIES CORPORATION, U.S.A. (Licensee - U.S. & Canada)	CAGE No. 06725	HI-SHEAR FASTENERS EUROPE LTD., U.K. (Licensee)	CAGE No. U8300
FAIRCHILD FASTENERS, Industry Operations, U.S.A. (Licensee - Pins)	CAGE No. 06950	FAIRCHILD FASTENERS, Simmonds, France (Licensee - Collars - EEC Countries)	
FAIRCHILD FASTENERS, South Bay Operations, U.S.A. (Licensee - Collars)	CAGE No. SM902	FAIRCHILD FASTENERS, VSD GmbH, Germany (Licensee - EEC Countries)	
HICK INTERNATIONAL, INC., Aerospace Fasteners, U.S.A. (Licensee)	CAGE No. 17448	HJCK S.A., France (Licensee - EEC Countries)	
HICK INTERNATIONAL, INC., Lakewood Operations, U.S.A. (Licensee)	CAGE No. 87928	SAINT CHAMOND GRANAT, S.A., France (Licensee - EEC Countries)	
SPS TECHNOLOGIES, U.S.A. (Licensee)	CAGE No. 56878	TOKYO SCREW DIVISION, Minebea Co., Ltd., 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.	F	G	H	K REF.	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
														W HEX.	T DEPTH	Y DIA.		
5	3/16																	
NOTE: Use HLT51-6																		
6	13/64	.3016 .2966	.360	.2026 .2021	.1840 .1810	.005	.015 .010	.0415 .0394	.016	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	8,100	2,600
8	17/64	.3948 .3898	.435	.2651 .2646	.2440 .2410	.006	.015 .010	.0544 .0523	.021	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	13,800	4,400
10	21/64	.4739 .4689	.545	.3276 .3271	.3060 .3020	.007	.015 .010	.0614 .0593	.026	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	21,100	7,000
12	25/64	.5604 .5554	.590	.3901 .3896	.3680 .3640	.008	.015 .010	.0714 .0693	.030	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	30,000	10,000
14	29/64	.6680 .6620	.690	.4526 .4521	.4310 .4260	.009	.015 .010	.0904 .0879	.035	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	40,300	12,500
16	33/64	.7540 .7480	.740	.5151 .5146	.4930 .4880	.010	.015 .010	.1002 .0977	.039	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	52,200	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" dia within .005 FIM.
- "H" dimensioned from maximum dia.
- Dimensions to be met before finish.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- Use HLT251 for oversize replacement.
- Curved or flat edgr manufacturer's option.

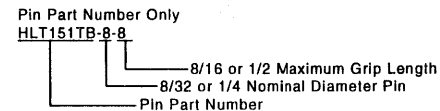
SPECIFICATION:

Hi-Lok Hi-Tigue Product Specification 342.

CODE:

First dash number indicates nominal diameter in 1/32nds which HLT151 oversize replaces.
Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER EXAMPLE:



MATERIAL:

PH13-8Mo stainless steel per Spec. AMS5629.

HEAT TREAT:

125,000 psi shear minimum.

FINISH:

- HLT151-()-() = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT151DL()-() = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT151TB()-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.

"Hi-Lok", "HL", "Hi-Tigue", and "HLT" are internationally registered trademarks of Hi-Shear Corporation.		
DRAWN	DATE	TITLE
D.P.S.	6-8-77	HI-LOK® HI-TIGUE® PIN 100° FLUSH CROWN SHEAR HEAD PH13-8Mo STAINLESS STEEL 1/16" GRIP VARIATION - 1/64" OVS
APPROVED	DATE	
RTing	6-8-77	
REVISION	DATE	DRAWING NUMBER
⑤	J.Henderson 2-24-99	HLT151