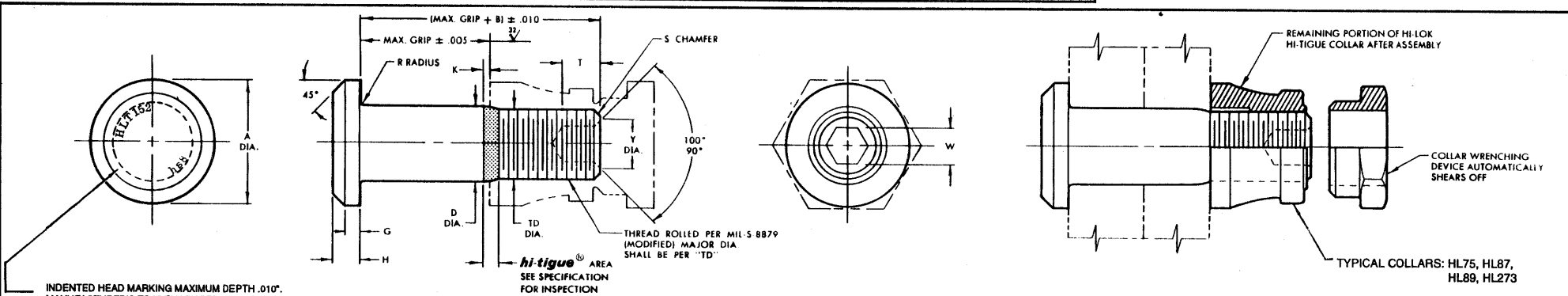


STANDARDS COMMITTEE
FOR HI-LOK® HI-TIGUE® PRODUCTS
 2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
 A Subsidiary of GFI Industries, France
 AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A. Canada) CAGE No. 06725
 HUCK INTERNATIONAL, INC., Deutch 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. 82216
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 80616
 (Pins & Steel Collars)

HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee) - CAGE No. CL868
 A Subsidiary of GFI Industries, France
 HUCK S.A. (Licensee - EEC Countries)
 SAINT CHAMOND GRANAT, S.A. France (Licensee - EEC Countries)
 SIMMONDS S.A. France (Licensee - EEC Countries)
 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 HLT52-6 | | | | | | | | | | | | | | | | |
| 6 | 13/64 | .377 .357 | .360 | .2026 .2021 | .1840 .1810 | .035 | .074 .064 | .016 | .025 .015 | 1/32" x 45° | 10-32UNJF-3A Modified | .0806 .0791 | .135 .115 | .119 .104 | 8,100 | 4,350 |
| 8 | 17/64 | .440 .415 | .435 | .2651 .2646 | .2440 .2410 | .045 | .090 .080 | .021 | .025 .015 | 1/32" x 45° | 1/4-28UNJF-3A Modified | .0967 .0947 | .150 .130 | .142 .122 | 13,800 | 7,750 |
| 10 | 21/64 | .505 .475 | .545 | .3276 .3271 | .3060 .3020 | .055 | .112 .102 | .026 | .030 .020 | 3/64" x 45° | 5/16-24UNJF-3A Modified | .1295 .1270 | .170 .150 | .180 .160 | 21,100 | 12,300 |
| 12 | 25/64 | .600 .565 | .590 | .3901 .3896 | .3680 .3640 | .075 | .140 .130 | .030 | .030 .020 | 3/64" x 45° | 3/8-24UNJF-3A Modified | .1617 .1582 | .200 .180 | .217 .197 | 30,000 | 19,100 |
| 14 | 29/64 | .676 .641 | .690 | .4526 .4521 | .4310 .4260 | .095 | .160 .150 | .035 | .030 .020 | 3/64" x 45° | 7/16-20UNJF-3A Modified | .1930 .1895 | .230 .210 | .253 .233 | 40,300 | 25,800 |
| 16 | 33/64 | .770 .735 | .740 | .5151 .5146 | .4930 .4880 | .095 | .188 .178 | .039 | .030 .020 | 3/64" x 45° | 1/2-20UNJF-3A Modified | .2242 .2207 | .260 .240 | .289 .269 | 52,200 | 34,300 |

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

③ GENERAL NOTES:

- Concentricity: "A" to "D" diameter within .010 FIR.
- Dimensions to be met before finish
- Surface texture per ANSI B46. 1.
- Hole preparation per NAS618.
- Use HLT52 for oversize replacement.

SPECIFICATION:

Hi-Lok Hi-Tigue Product Specification 342.

CODE:

First dash number indicates nominal diameter in 1/32nds which HLT152 oversize pin 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:

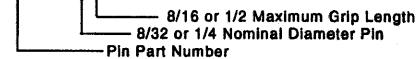
125,000 psi shear minimum.

FINISH:

- HLT152(-)(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT152DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT152TB(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.

HOW TO ORDER EXAMPLE:

Pin Part Number Only
HLT152TB-8-8



| | | |
|---------------|------------------------|--|
| DRAWN DATE | | TITLE HI-LOK® HI-TIGUE® PIN PROTRUDING TENSION HEAD PH13-8Mo STAINLESS STEEL 1/16" GRIP VARIATION - 1/64" OVS |
| D.P.S. | 6-8-77 | |
| APPROVED DATE | | DRAWING NUMBER HLT152 |
| RTing | 6-8-77 | |
| REVISION | DATE | |
| ③ | J.Henderson 4-29-98 | |