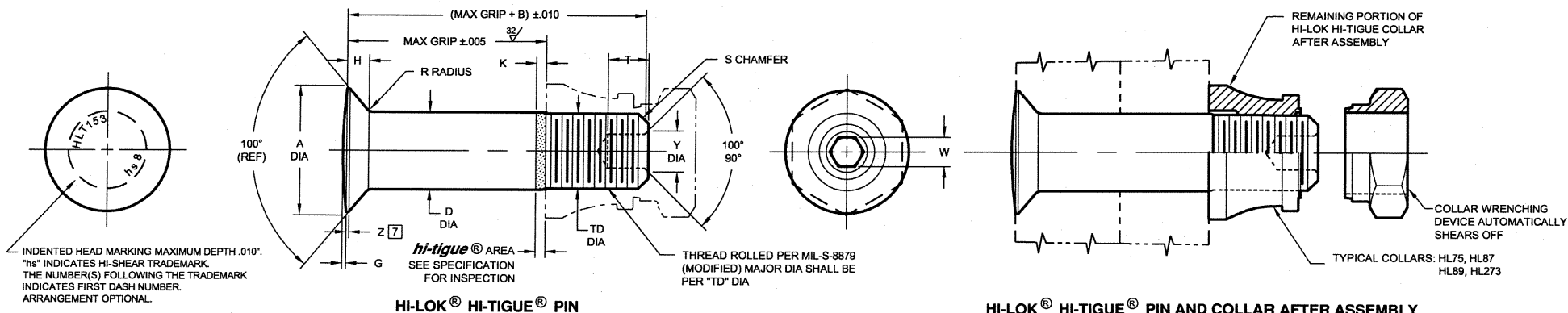


STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
 a LISI AEROSPACE Company
 AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A. & Canada) CAGE No. 06725
 HUCK INTERNATIONAL, INC., U.S.A. (Licensee) CAGE No. 97928
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 55878
 FAIRCHILD Aerospace Fastener Division (Licensee) CAGE No. 92215
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516
 (Pins & Steel Collars)

BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE No. 0LB68
 a LISI AEROSPACE Company
 HUCK S.A. France (Licensee - ECC Countries)
 BLANC AERO S.A. France (Licensee - ECC Countries)
 a LISI AEROSPACE Company
 TOKYO SCREW COMPANY, Japan (Licensee - Japan)



HI-LOK® HI-TIGUE® PIN

HI-LOK® HI-TIGUE® PIN AND COLLAR AFTER ASSEMBLY

| FIRST DASH NO. | PIN 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 HLT153-6(-) | | | | | | | | | | | | | | | | | | |
| 6 | 13/64 | .3813 .3765 | .360 | .2026 .2021 | .1840 .1810 | .005 | .015 .010 | .0750 .0730 | .016 | .030 .020 | .015 | 1/32" x 45° | 10-32UNJF-3A Modified | .0806 .0791 | .135 .115 | .119 .104 | 8,100 | 4,350 |
| 8 | 17/64 | .5066 .5018 | .435 | .2651 .2646 | .2440 .2410 | .006 | .015 .010 | .1013 .0993 | .021 | .030 .020 | .015 | 1/32" x 45° | 1/4-28UNJF-3A Modified | .0967 .0947 | .150 .130 | .142 .122 | 13,800 | 7,750 |
| 10 | 21/64 | .6335 .6287 | .545 | .3276 .3271 | .3060 .3020 | .007 | .015 .010 | .1283 .1263 | .026 | .040 .030 | .015 | 3/64" x 45° | 5/16-24UNJF-3A Modified | .1295 .1270 | .170 .150 | .180 .160 | 21,100 | 12,300 |
| 12 | 25/64 | .7604 .7556 | .590 | .3901 .3896 | .3680 .3640 | .008 | .015 .010 | .1553 .1533 | .030 | .040 .030 | .015 | 3/64" x 45° | 3/8-24UNJF-3A Modified | .1617 .1582 | .200 .180 | .217 .197 | 30,000 | 19,100 |
| 14 | 29/64 | .8884 .8812 | .690 | .4526 .4521 | .4310 .4260 | .009 | .015 .010 | .1828 .1798 | .035 | .050 .040 | .022 | 3/64" x 45° | 7/16-20UNJF-3A Modified | .1930 .1895 | .230 .210 | .253 .233 | 40,300 | 25,800 |
| 16 | 33/64 | 1.0139 1.0068 | .740 | .5151 .5146 | .4930 .4880 | .010 | .015 .010 | .2093 .2063 | .039 | .050 .040 | .022 | 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.

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.
- Dimensions to be met before finish.
- Hole preparation per NAS618.
- Curved or flat edge manufacturer's option.
- Use HLT253 for oversize replacement.

MATERIAL: PH13-8Mo stainless steel per AMS5629.

HEAT TREAT: 125,000 psi shear minimum.

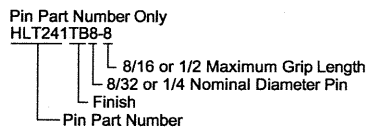
- ③ **FINISH:**
- HLT153(-)(-) = Passivate per Hi-Shear Spec.258 and cetyl alcohol luber per Hi-Shear Spec. 305.
 - HLT153DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT153TB(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec.292, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lok Hi-Tigue Product Specification 342.

CODE:

First dash number indicates nominal diameter in 1/32nds of the pin which HLT153 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER EXAMPLE:



| | | |
|---|---------------|---|
| "Hi-Lok", "HL", Hi-Tigue, and "HLT" are internationally registered trademark of Hi-Shear Corporation. | | |
| DRAWN | DATE | TITLE |
| D.P.S. | 6-8-77 | HI-LOK® HI-TIGUE® PIN 100° FLUSH CROWN MS24694 TENSION HEAD PH13-8Mo STAINLESS STEEL 1/16" GRIP VARIATION, 1/64 OVERSIZE |
| APPROVED | DATE | |
| R.Ting | 6-8-77 | |
| REVISION | DATE | DRAWING NUMBER |
| ③ | JO 5-17-04 | HLT153 |