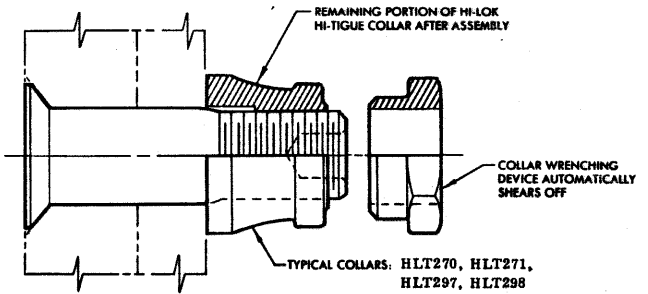
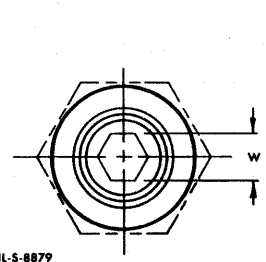
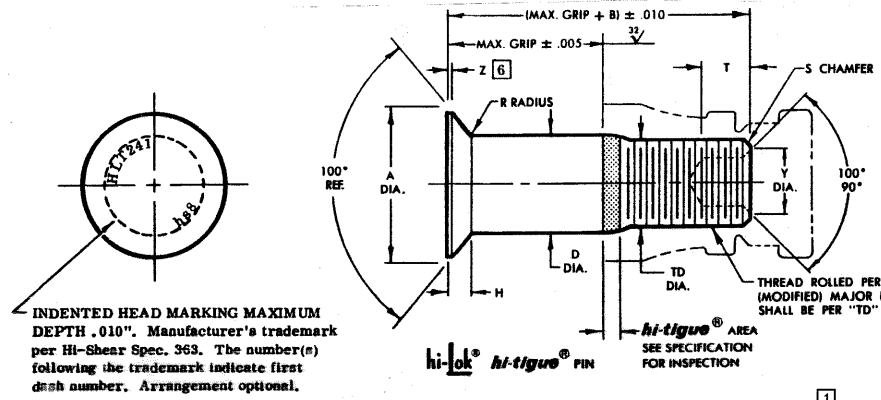


STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) -- Division of Hi-Shear Industries Inc., U.S.A.	U.S. Federal Code No. 73197	HI-SHEAR FASTENERS EUROPE, LTD., U.K. -- Division of Hi-Shear Industries Inc., U.S.A.	(Licensee)
AIR INDUSTRIES CO., INC. (Licensee) U.S. & Canada)---	U.S. Federal Code No. 06725	Huck International, GmbH & Co. Germany	EEC Countries)
HUCK International, Deutsch Operations (Licensee)---	U.S. Federal Code No. 97928	ST. CHAMOND GRANAT, S.A. France-----	(Licensee -
SPS TECHNOLOGIES, U.S.A. (Licensee)---	U.S. Federal Code No. 56878	SIMMONDS, S.A. France -----	EEC Countries)
VOI-SHAN, Division of VSI Corp., U.S.A. --	U.S. Federal Code No. 92216	TOKYO SCREW COMPANY, Japan-----	(Licensee -
WEST COAST AEROSPACE INC., U.S.A. -- (Licensee)---	U.S. Federal Code No. 60516		EEC Countries-Collars)
(Pins & Steel Collars)			(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
SEE SPECIFICATION FOR INSPECTION

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			TENSION 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	7/32	.3303 .3253	.360	.2182 .2177	.2182 .2172	.1840 .1810	.005	.0470 .0449	.030 .020	.010	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	7,100	2,000
8	9/32	.4260 .4210	.435	.2807 .2802	.2807 .2797	.2440 .2410	.006	.0610 .0589	.030 .020	.010	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	11,800	3,700
10	11/32	.5051 .5001	.545	.3432 .3427	.3432 .3422	.3060 .3020	.007	.0679 .0658	.040 .030	.010	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	17,600	5,000
12	13/32	.5916 .5866	.590	.4057 .4052	.4057 .4047	.3680 .3640	.008	.0780 .0759	.040 .030	.010	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	24,600	7,200
14	15/32	.6992 .6932	.690	.4682 .4677	.4682 .4672	.4310 .4260	.009	.0969 .0944	.050 .040	.015	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	32,700	10,000
16	17/32	.7852 .7792	.740	.5307 .5302	.5307 .5297	.4930 .4880	.010	.1068 .1043	.050 .040	.015	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	42,000	13,500
18	19/32	.8692 .8622	.825	.5927 .5922	.5927 .5917	.5550 .5500	.010	.1160 .1131	.050 .040	.015	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	52,000	17,000

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

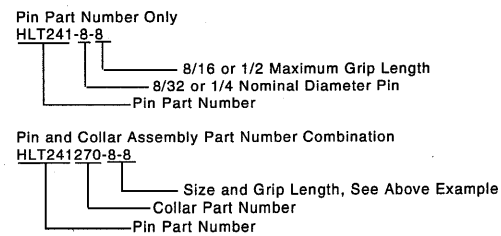
GENERAL NOTES:

- 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.
- Curved or flat edge manufacturer's option.

CODE:

First dash number indicates nominal diameter in 1/32nds of the pin which HLT241 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:**
- HLT241-(-)(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT241TB-(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT241TC-(-)(-) = 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.

DRAWN DATE		TITLE	
Van	6-14-72	HI-LOK® HI-TIGUE® PIN 100° FLUSH SHEAR HEAD A-286 HIGH TEMPERATURE ALLOY 1/16" GRIP VARIATION, 1/32 OVERSIZE	
APPROVED DATE		DRAWING NUMBER	
J. Wilcox	6-19-72	HLT241	
REVISION DATE			
②	J.F.Obispo 8-21-94		

HLT241