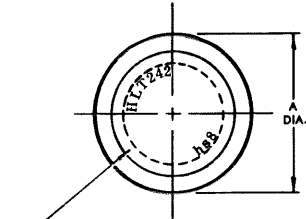
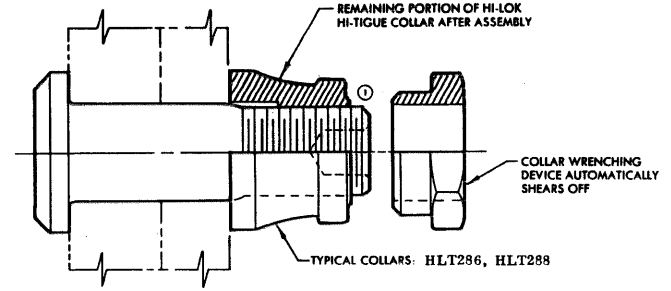
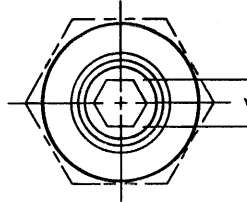
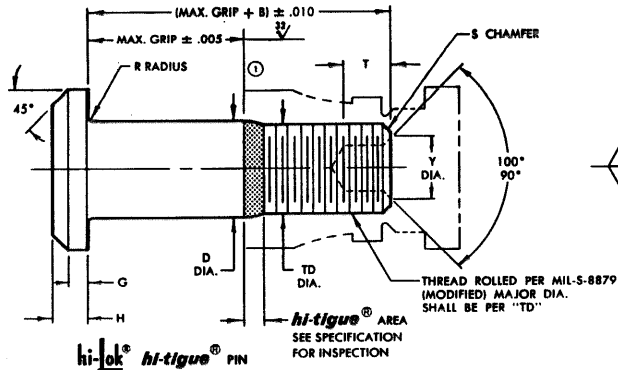


HI-SHEAR CORPORATION, U.S.A. (Patent Holder) U.S. Federal Code I.D. No. 73197
 Division of HI-Shear Industries Inc., U.S.A.
 AIRCRAFT FASTENERS (Forged Parts) LTD., U.K. (Licensee)
 Division of HI-Shear Industries Inc., U.S.A.
 YUI-SHIAN, Division of YUI Corp., U.S.A. (Licensee) U.S. Federal Code I.D. No. 92215
 SPS TECHNOLOGIES, U.S.A. (Licensee) U.S. Federal Code I.D. No. 96778

ST. CHAMOND-GRANAT, S.A. France (Countries)
 KAMAX-WERKE, Germany (Countries)
 Rudolf Ketterman GmbH & Co (Countries—Collars)
 SINMONDS, S.A. France (Countries—Collars)
 TOKYO SCREW COMPANY, Japan (Licensee—Japan)
 WEST COAST AEROSPACE INC., U.S.A. (Licensee—Oversize Plus & Steel Collars)
 U.S. Federal Code I.D. No. 60518



① 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 AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.		TD DIA.	G REF.	H	R RAD.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT HI-KOTE™ LUBE	WITH HI-KOTE™ LUBE							W HEX.	T DEPTH	Y DIA.		
-5				NOTE: Use HLT42-6												
-6	7/32	.390 .370	.360	.2182 .2177	.2182 .2172	.1840 .1810	.035	.074 .064	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	7,100	2,750
-8	9/32	.460 .435	.435	.2807 .2802	.2807 .2797	.2440 .2410	.045	.090 .080	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	11,800	5,820
-10	11/32	.520 .490	.545	.3432 .3427	.3432 .3422	.3060 .3020	.055	.112 .102	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	17,600	9,200
-12	13/32	.620 .585	.590	.4057 .4052	.4057 .4047	.3680 .3640	.075	.140 .130	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	24,600	14,000
-14	15/32	.695 .660	.690	.4682 .4677	.4682 .4672	.4310 .4260	.095	.160 .150	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	32,700	18,900
-16	17/32	.790 .755	.740	.5307 .5302	.5307 .5297	.4930 .4880	.095	.188 .178	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	42,000	25,500
-18	19/32	.900 .865	.825	.5927 .5922	.5927 .5917	.5550 .5500	.125	.210 .200	.040 .025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	52,400	32,400

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

- ① GENERAL NOTES:
1. Concentricity: "A" to "D" diameter within .010 FIR.
 2. Surface texture per ANSI B46.1.
 3. Hole preparation per NAS618.

① MATERIAL: A-286 high temperature alloy per AMS5731 or AMS5737.

HEAT TREAT: 95,000 psi shear minimum at 70°F.

① FINISH: HLT242-()-() = Passivate per HI-Shear Spec. 258 and cetyl alcohol lube per HI-Shear Spec. 305.
 HLT242TB-()-() = HI-Kote 2 solid film lube and cetyl alcohol lube per HI-Shear Spec. 305.

① SPECIFICATION: HI-Lok HI-Tigue Product Specification 342 and 342-2.

① CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HLT242 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths. See "Finish" note for explanation of code letters.

HOW TO ORDER EXAMPLES:

Pin Part Number Only
 HLT242-8-8
 ↳ 8/16 or 1/2 Maximum Grip Length
 ↳ Replaces 8/32 or 1/4 Nominal Diameter Pin
 ↳ Pin Part Number

Pin and Collar Assembly Part Number Combination
 HLT242286-8-8
 ↳ Size and Grip Length, See Above Example
 ↳ Collar Part Number
 ↳ Pin Part Number

U.S. Patent 3,578,367 and international patents. "HL", "HI-Lok", "HLT", and "HI-Tigue" are internationally registered trademarks of HI-Shear Corporation.	
DRAWN DATE VAN 6-16-77	hi-lok® hi-tigue® PIN PROTRUDING TENSION HEAD A-286 HIGH TEMPERATURE ALLOY 1/16" GRIP VARIATION - 1/32" OVERSIZE
APPROVED DATE J & Wilcox 6-20-77	
REVISION DATE ① D. P. S. 10-28-86	DRAWING NUMBER HLT242