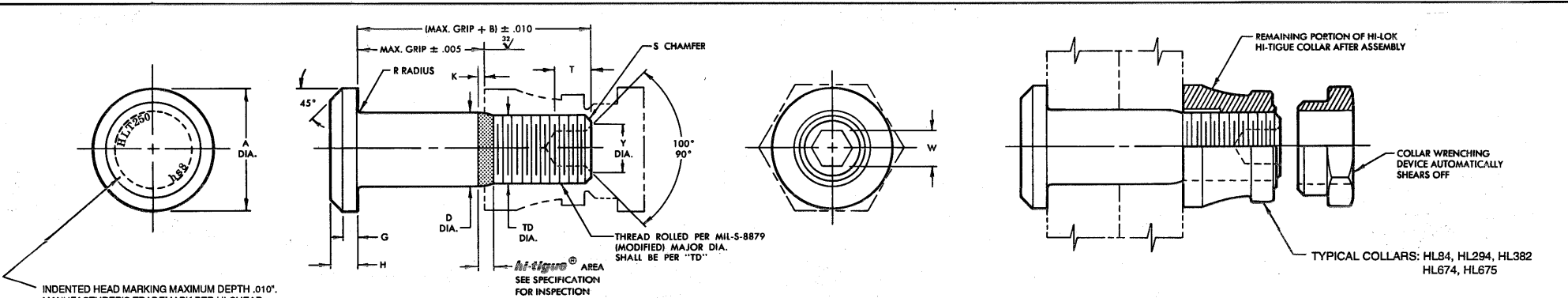


# STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

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. & Canada) CAGE No. 06725  
 HUCK INTERNATIONAL, INC., Deutsch Operation, U.S.A. (Licensee) CAGE No. 07928  
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878  
 FAIRCHILD Aerospace Fastener Division, U.S.A. (Licensee) CAGE No. 82215  
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516  
 (Pins & Steel Collars)

HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee) - CAGE No. 0LB68  
 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 - Collars)  
 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	13-64															
NOTE: Use HLT150-6																
6	7/32	.315 .295	.360	.2182 .2177	.1840 .1810	.025 .045	.055 .069	.016 .021	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	9,400	3,000
8	9/32	.412 .387	.435	.2807 .2802	.2440 .2410	.030 .059	.069 .078	.021 .026	.025 .030	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	15,500	5,100
10	11/32	.505 .475	.545	.3432 .3427	.3060 .3020	.035 .068	.078 .068	.026 .030	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	23,200	8,000
12	13/32	.600 .565	.590	.4057 .4052	.3680 .3640	.040 .078	.088 .078	.030 .030	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	32,400	11,300
14	15/32	.676 .641	.690	.4682 .4677	.4310 .4260	.045 .093	.105 .093	.035 .035	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	43,100	15,500
16	17/32	.770 .735	.740	.5307 .5302	.4930 .4880	.050 .103	.115 .103	.039 .039	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	55,400	20,000

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

- ③ GENERAL NOTES:
1. Concentricity: "A" to "D" diameter within .010 FIM .
  2. Dimensions to be met before finish
  3. Surface texture per ANSI B46. 1.
  4. Hole preparation per NAS618.

MATERIAL: PH13-8Mo stainless steel per Spec. AMS5629.

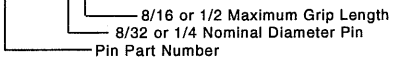
HEAT TREAT: 125,000 psi shear minimum.

FINISH: HLT250-( )-( ) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HLT250DL( )-( ) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HLT250TB( )-( ) = 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 which HLT250 oversize replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER EXAMPLE: Pin Part Number Only HLT250TB-8-8



DRAWN DATE D.P.S. 6-8-77		TITLE <b>HI-LOK® HI-TIGUE® PIN</b> PROTRUDING SHEAR HEAD PH13-8Mo STAINLESS STEEL 1/16" GRIP VARIATION - 1/32" OVS
APPROVED DATE RTing 6-8-77		
REVISION DATE ③ J.Henderson 5-12-98		DRAWING NUMBER <b>HLT250</b>