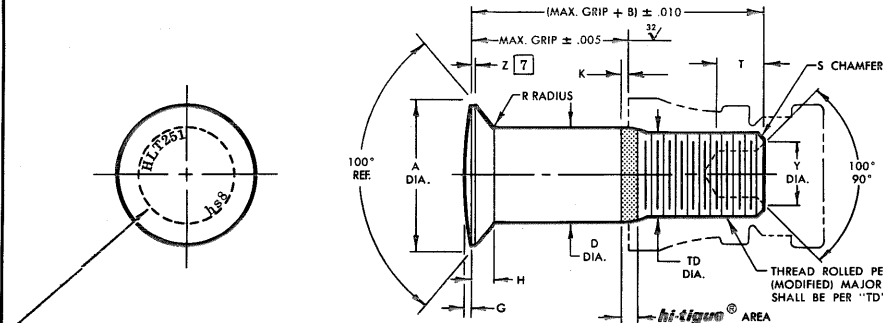


# STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

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

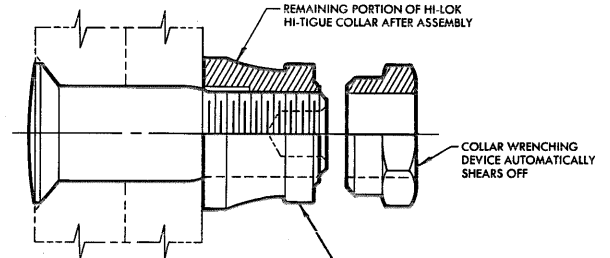
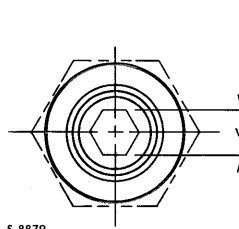
HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197  
 A Subsidiary of GFI Industries, France  
 AIR INDUSTRIES CO., INC. U.S.A. (Licensee - U.S. & Canada) CAGE No. 06725  
 HICK INTERNATIONAL, INC., Deutsch Operation, U.S.A. (Licensee) CAGE No. 97928  
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878  
 FAIRCHILD Aerospace Fastener Division, U.S.A. (Licensee) CAGE No. 92215  
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516  
 (Fine & Steel Collars)

HI-SHEAR FASTENERS EUROPE LTD., U.K. (Licensee) - CAGE No. 0LB68  
 A Subsidiary of GFI Industries, France  
 HICK INTERNATIONAL GMBH & CO, Germany (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



TYPICAL COLLARS: HL84, HL294, HL382  
 HL674, HL675

HI-LOK HI-TIGUE PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	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	13/64																	
NOTE: Use HLT151-6																		
6	7/32	.3303 .3253	.360	.2182 .2177	.1840 .1810	.005	.015 .010	.0470 .0449	.016	.030 .020	.010	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	9,400	2,600
8	9/32	.4260 .4210	.435	.2807 .2802	.2440 .2410	.006	.015 .010	.0610 .0589	.021	.030 .020	.010	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	15,500	4,400
10	11/32	.5051 .5001	.545	.3432 .3427	.3060 .3020	.007	.015 .010	.0679 .0658	.026	.040 .030	.010	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	23,200	7,000
12	13/32	.5916 .5866	.590	.4057 .4052	.3680 .3640	.008	.015 .010	.0780 .0759	.030	.040 .030	.010	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	32,400	10,000
14	15/32	.6992 .6932	.690	.4682 .4677	.4310 .4260	.009	.015 .010	.0969 .0944	.035	.050 .040	.015	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	43,100	12,500
16	17/32	.7852 .7792	.740	.5307 .5302	.4930 .4880	.010	.015 .010	.1068 .1043	.039	.050 .040	.015	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	55,400	18,000

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" dia within .005 FIM.
- "H" dimensioned from maximum dia.
- Dimensions to be met before finish.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- Curved or flat edge manufacturer's option.

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

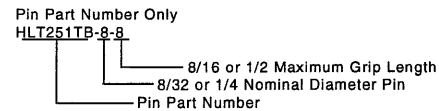
MATERIAL: PH13-8Mo stainless steel per Spec. AMS5629.

CODE: First dash number indicates nominal diameter in 1/32nds, which HLT251 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HEAT TREAT: 125,000 psi shear minimum.

HOW TO ORDER  
 EXAMPLE:

- FINISH: HLT251(-)(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.  
 ② HLT251DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HLT251TB(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.



"Hi-Lok", "HL", "Hi-Tigue", and "HLT" are internationally registered trademarks of Hi-Shear Corporation.		TITLE <b>HI-LOK® HI-TIGUE® PIN</b> 100° FLUSH CROWN SHEAR HEAD PH13-8Mo STAINLESS STEEL 1/16" GRIP VARIATION - 1/32" OVS	
DRAWN	DATE	APPROVED	
D.P.S.	6-8-77	RTing 6-8-77	
REVISION	DATE	DRAWING NUMBER	
②	J.Henderson 10-13-97	<b>HLT251</b>	

HLT251