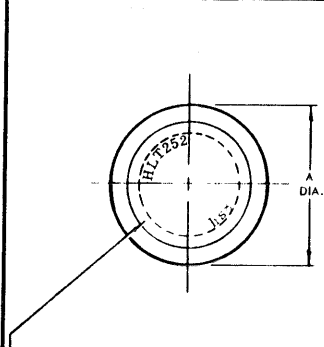


# STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

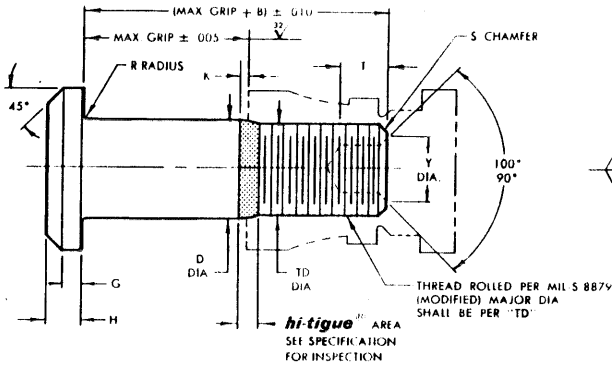
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

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.A. & Canada) CAGE No. 06726  
 HUCK INTERNATIONAL, INC., Dordrecht Operation, U.S.A. (Licensee) CAGE No. 97928  
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 86878  
 FAIRCHILD Aerospace Fastener Division, U.S.A. (Licensee) CAGE No. 82216  
 WEST COAST AEROSPACE INC, U.S.A. (Licensee) CAGE No. 80516  
 (Pins & Steel Collars)

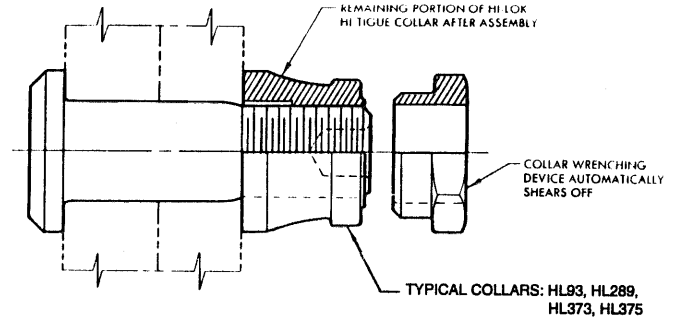
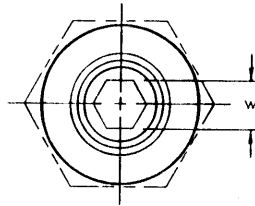
HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee) - CAGENO. 0LB88  
 A Subsidiary of GFI Industries, France  
 HUCK S.A. (Licensee - EEC Countries)  
 SAINT CHAMOND GRANAT, S.A. France (Licensee - EEC Countries)  
 SIMMONDS S.A., France (Licensee - EEC Countries-Collars)  
 TOKYO SCREW COMPANY, Japan (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 HLT52-6																
6	7/32	.390 .370	.360	.2182 .2177	.1840 .1810	.035	.074 .064	.016	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	9,400	4,350
8	9/32	.460 .435	.435	.2807 .2802	.2440 .2410	.045	.090 .080	.021	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	15,500	7,750
10	11/32	.520 .490	.545	.3432 .3427	.3060 .3020	.055	.112 .102	.026	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	23,200	12,300
12	13/32	.620 .550	.590	.4057 .4052	.3680 .3640	.075	.140 .130	.030	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	32,400	19,100
14	15/32	.695 .615	.690	.4682 .4677	.4310 .4260	.095	.160 .150	.035	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	43,100	25,800
16	17/32	.790 .740	.740	.5307 .5302	.4930 .4880	.095	.188 .178	.039	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	55,400	34,300

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

© GENERAL NOTES:

1. Concentricity: "A" to "D" diameter within .010 FIR.
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: HLT252-( )-( ) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HLT252DL( )-( ) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HLT252TB( )-( ) = 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 HLT252 oversize pin 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  
**HLT252TB-8-8**  
 8/16 or 1/2 Maximum Grip Length  
 8/32 or 1/4 Nominal Diameter Pin  
 Pin Part Number

"Hi-Lok", "HL", "Hi-Tigue", and "HLT" are internationally registered trademarks of Hi-Shear Corporation.

DRAWN DATE  
 D.P.S. 6-8-77

APPROVED DATE  
 RTing 6-8-77

REVISION DATE  
 ③ J.Henderson 5-12-98

TITLE  
**HI-LOK® HI-TIGUE® PIN**  
 PROTRUDING TENSION HEAD  
 PH13-8Mo STAINLESS STEEL  
 1/16" GRIP VARIATION - 1/32" OVS

DRAWING NUMBER  
**HLT252**