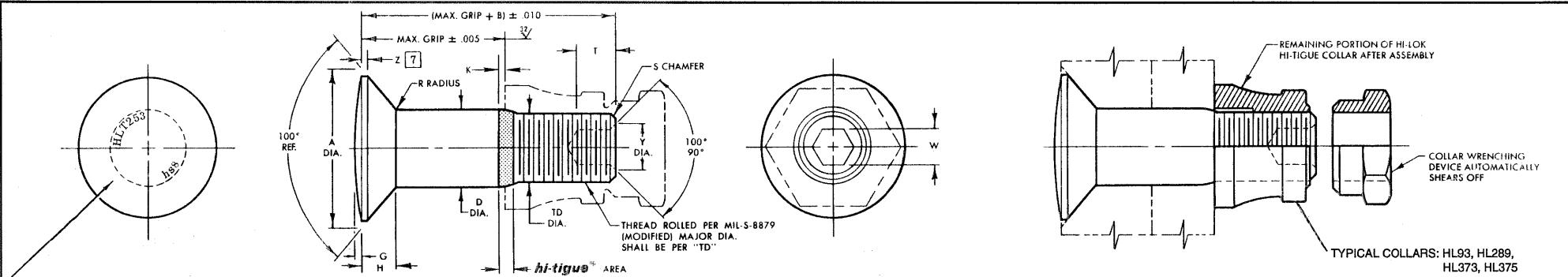


STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

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. 06725
 HUCK INTERNATIONAL, INC., Deutsch Operation, U.S.A. (Licensee) CAGE No. 97929
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 96979
 FAIRCHILD Aerospace Fastener Division, U.S.A. (Licensee) CAGE No. 92216
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 62618
 (Pins & Steel Collars)

HI-SHEAR FASTENERS EUROPE LTD., U.K. (Licensee) CAGE No. 0LB68
 A Subsidiary of GFI Industries, France
 HUCK 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)



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.	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 HLT153-6																		
6	7/32	.3813 .3765	.360	.2182 .2177	.1840 .1810	.005	.015 .010	.0684 .0664	.016	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	9,400	4,350
8	9/32	.5066 .5018	.435	.2807 .2802	.2440 .2410	.006	.015 .010	.0948 .0928	.021	.030 .030	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	15,500	7,750
10	11/32	.6335 .6287	.545	.3432 .3427	.3060 .3020	.007	.015 .010	.1218 .1198	.026	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	23,200	12,300
12	13/32	.7604 .7556	.590	.4057 .4052	.3680 .3640	.008	.015 .010	.1488 .1468	.030	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	32,400	19,100
14	15/32	.8884 .8812	.690	.4682 .4677	.4310 .4260	.009	.015 .010	.1763 .1733	.035	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	43,100	25,800
16	17/32	1.0139 1.0068	.740	.5307 .5302	.4930 .4880	.010	.015 .010	.2027 .1997	.039	.050 .040	.022	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:

- 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.

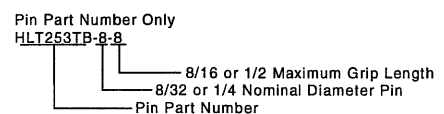
SPECIFICATION:

Hi-Lok Hi-Tigue Product Specification 342.

CODE:

First dash number indicates nominal diameter in 1/32nds which HLT253 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:

PH13-8Mo stainless steel per Spec. AMS5629.

HEAT TREAT:

125,000 psi shear minimum.

FINISH:

- HLT253(-)(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT253DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT253TB(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.

DRAWN DATE D.P.S. 6-8-77		TITLE HI-LOK® HI-TIGUE® PIN 100° FLUSH CROWN MS24694	
APPROVED DATE RTing 6-8-77		TENSION HEAD PH13-8Mo STAINLESS STEEL 1/16" GRIP VARIATION - 1/32" OVS	
REVISION DATE ③ J.Henderson 10-22-98		DRAWING NUMBER HLT253	

HLT253