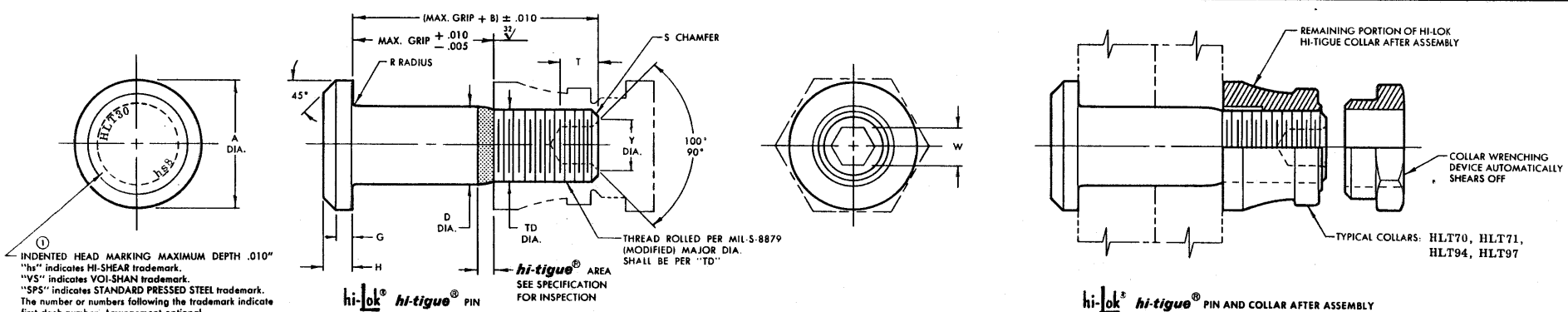


**STANDARDS COMMITTEE FOR  
HI-LOK® HI-TIGUE® PRODUCTS**  
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

① 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. (Licensee—EEC Countries)  
 AIRCRAFT FASTENERS (Forged Parts) LTD., U.K. (Licensee)  
 Division of HI-Shear Industries Inc., U.S.A. (Licensee—EEC Countries)  
 VOI-SHAN, Division of VSI 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. 96878  
 LITTON FASTENING SYSTEMS, U.S.A. (Licensee) U.S. Federal Code I.D. No. 97928  
 Division of Litton Systems Inc., U.S.A. (Licensee—EEC Countries)  
 KAMAJ-WERKE, Germany (Licensee—EEC Countries)  
 Rudolph Kellerman GmbH & Co. (Licensee—EEC Countries)  
 SIMMONDS, S.A. France (Licensee—EEC Countries—Collars)  
 TOKYO SCREW COMPANY, Japan (Licensee—Japan)  
 WEST COAST AEROSPACE INC., U.S.A. (Licensee—Oversize Pins & Steel Collars)  
 U.S. Federal Code I.D. No. 60516



① INDENTED HEAD MARKING MAXIMUM DEPTH .010"  
 "hs" indicates HI-SHEAR trademark.  
 "VS" indicates VOI-SHAN trademark.  
 "SPS" indicates STANDARD PRESSED STEEL trademark.  
 The number or numbers 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	R RAD.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
											W HEX.	T DEPTH	Y DIA.		
-5	5/32	.262 .242	.312	.1635 .1630	.1595 .1570	.020	.047 .037	.025 .015	1/32" x 45°	8-32UNJC-3A Modified	.0801 .0791	.100 .080	.119 .104	5,280	2,200
-6	3/16	.315 .295	.325	.1895 .1890	.1840 .1810	.025	.055 .045	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	7,060	3,000
-8	1/4	.412 .387	.395	.2495 .2490	.2440 .2410	.030	.069 .059	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	12,260	5,100
-10	5/16	.505 .475	.500	.3120 .3115	.3060 .3020	.035	.078 .068	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	19,160	8,000
-12	3/8	.600 .565	.545	.3745 .3740	.3680 .3640	.040	.088 .078	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	27,600	11,300
-14	7/16	.676 .641	.635	.4370 .4365	.4310 .4260	.045	.105 .093	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	37,500	15,500
-16	1/2	.770 .735	.685	.4995 .4990	.4930 .4880	.050	.115 .103	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	49,100	20,000
-18	9/16	.864 .829	.770	.5615 .5610	.5550 .5500	.055	.127 .112	.040 .025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	62,100	25,000
-20	5/8	.953 .918	.825	.6240 .6235	.6180 .6120	.060	.137 .122	.040 .025	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	76,700	30,200

① SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH.

- GENERAL NOTES:**
- Concentricity: "A" to "D" diameter within .010 FIR.
  - Dimensions of solid film lubed parts to be met after lube.
  - ③ Surface texture per ANSI B46.1.
  - Hole preparation per NAS618.
  - ⑤ Maximum "D" diameter may be increased by .0004 to allow for solid film application (code "LP" only).
  - Use HLT130 for oversize replacement.

**MATERIAL:** Type 431 stainless steel per AMS5628 and MIL-S-18732.

**HEAT TREAT:** 125,000 psi shear minimum.

**FINISH:** HLT30-( )-( ) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HLT30LP-( )-( ) = Solid film lube per MIL-L-46010 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.  
 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  
 HLT30-8-8  
 — 8/16 or 1/2 Maximum Grip Length  
 — 8/32 or 1/4 Nominal Diameter Pin  
 — Pin Part Number

Pin and Collar Assembly Part Number Combination  
 HLT3070-8-8  
 — Size and Grip Length, See Above Example  
 — Collar Part Number  
 — Pin Part Number

U.S. patents 3,390,906; 3,578,367 and foreign patents. "Hi-Lok," "HL," "Hi-Tigue" and "HLT" are Registered Trademarks of Hi-Shear Corporation.

DRAWN	DATE	hi-lok® hi-tigue® PIN PROTRUDING SHEAR HEAD TYPE 431 STAINLESS STEEL 1/16" GRIP VARIATION
VAN	10-27-71	
APPROVED	DATE	DRAWING NUMBER <b>HLT30</b>
JGW/boof	10/27/71	
REVISION	DATE	
①	D. P. S. 10-14-83	

HLT30