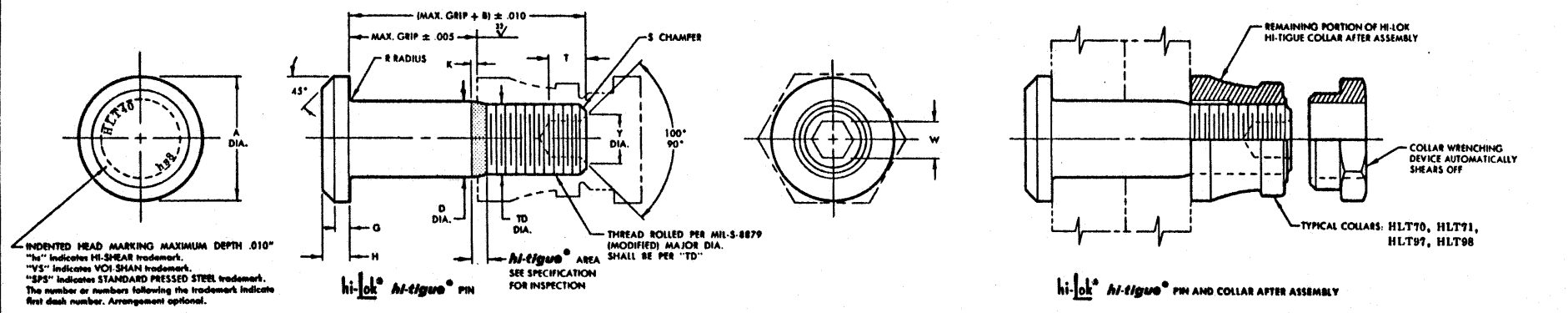


STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90508

HI-SHEAR CORPORATION U.S.A. (Patent Holder) U.S. Federal Code 19 No. 72197	HI-SHEAR PARTNER EUROPE LTD. U.K. (Licensee)
Branch of Hi-Shear Industries Inc. U.S.A.	Branch of Hi-Shear Industries Inc. U.S.A.
AKI INDUSTRIES CO. INC. (Licensee) U.S. Federal Code 19 No. 66729	KARAS-WEINE Germany (Licensee-EEC Countries)
DEUTSCH FASTENER CO. INC. (Licensee) U.S. Federal Code 19 No. 69226	Reinhold Kautmann GmbH & Co. (Licensee-EEC Countries)
SPR TECHNICAL SERVICES U.S.A. (Licensee) U.S. Federal Code 19 No. 66676	BY CHAMPION GRABMET S.A. France (Licensee-EEC Countries)
VOI SHAN Branch of VSI Corp. U.S.A. (Licensee) U.S. Federal Code 19 No. 62715	SHIMADZU S.A. France (Licensee-EEC Countries)
WEST COAST AIRSPACE INC. U.S.A. (Licensee) U.S. Federal Code 19 No. 68615	Colibri (Licensee-EEC Countries)
Pat. & Trade Marks	TOYOKI SCREW COMPANY Japan (Licensee-Japan)



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
				WITHOUT HI-KOTE™ LUBE	WITH HI-KOTE™ LUBE								W HEX.	T DEPTH	Y DIA.		
- 3	5/32	.262	.312	.1640	.1640	.1595	.020	.047	.013	.025	1/32" x 45°	8-32UNJC-3A Modified	.0645	.100	.090	4,010	1,940
		.242		.1635	.1630	.1570							.0635	.080	.075		
- 4	3/16	.315	.325	.1895	.1895	.1840	.025	.055	.016	.025	1/32" x 45°	10-32UNJF-3A Modified	.0806	.100	.119	5,380	2,500
		.295		.1890	.1885	.1810							.0791	.080	.104		
- 6	1/4	.412	.395	.2495	.2495	.2440	.030	.069	.021	.025	1/32" x 45°	1/4-28UNJF-3A Modified	.0907	.110	.142	9,300	4,300
		.387		.2490	.2485	.2410							.0897	.080	.122		
- 10	5/16	.505	.500	.3120	.3120	.3060	.035	.078	.026	.030	3/64" x 45°	5/16-24UNJF-3A Modified	.1295	.130	.180	14,600	6,300
		.475		.3115	.3110	.3020							.1270	.110	.160		
- 12	3/8	.600	.545	.3745	.3745	.3680	.040	.088	.030	.020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617	.160	.217	21,000	9,700
		.565		.3740	.3735	.3640							.1582	.140	.197		
- 14	7/16	.678	.635	.4370	.4370	.4310	.045	.105	.035	.020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930	.190	.263	28,600	12,100
		.641		.4365	.4360	.4260							.1895	.170	.233		
- 16	1/2	.770	.685	.4995	.4995	.4930	.050	.116	.039	.030	3/64" x 45°	1/2-20UNJF-3A Modified	.2242	.220	.289	37,300	16,300
		.735		.4990	.4985	.4880							.2207	.200	.269		
- 18	9/16	.864	.770	.5615	.5615	.5550	.055	.127	.038	.040	1/16" x 45°	9/16-18UNJF-3A Modified	.2555	.260	.320	47,200	19,000
		.828		.5610	.5605	.5500							.2520	.240	.306		

SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH SPIN OR COLLAR DETERMINES SYSTEM STRENGTH.

- GENERAL NOTES:**
- Concentricity: "A" to "D" diameter within .010 FIR.
 - Surface texture per ANSI B46.1.
 - Hot preparation per NAS818.
 - Use HLT140 for oversize replacement.

MATERIAL: A-286 high temperature alloy per AMS5731 or AMS5737.

HEAT TREAT: 95,000 psi shear minimum at 70°F.

- FINISH:**
- HLT40-()-() = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT40DL-()-() = Solid film lube per MIL-L-46010, Type 1, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT40TB-()-() = 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 32nds. Second dash number indicates maximum grip in 16ths. See finish note for explanation of code letters.

HOW TO ORDER EXAMPLES:

Pin Part Number Only
 HLT40-8-8
 ↳ 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
 HLT4070-8-8
 ↳ Size and Grip Length, See Above Example
 ↳ Collar Part Number
 ↳ Pin Part Number

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

DRAWN JG	DATE 1-11-77	 PROTRUDING SHEAR HEAD A-286 HIGH TEMPERATURE ALLOY 1/16" GRIP VARIATION
APPROVED JG	DATE 1-12-77	
REVISION 4	DATE D.P.S. 3-20-90	DRAWING NUMBER HLT40

HLT40