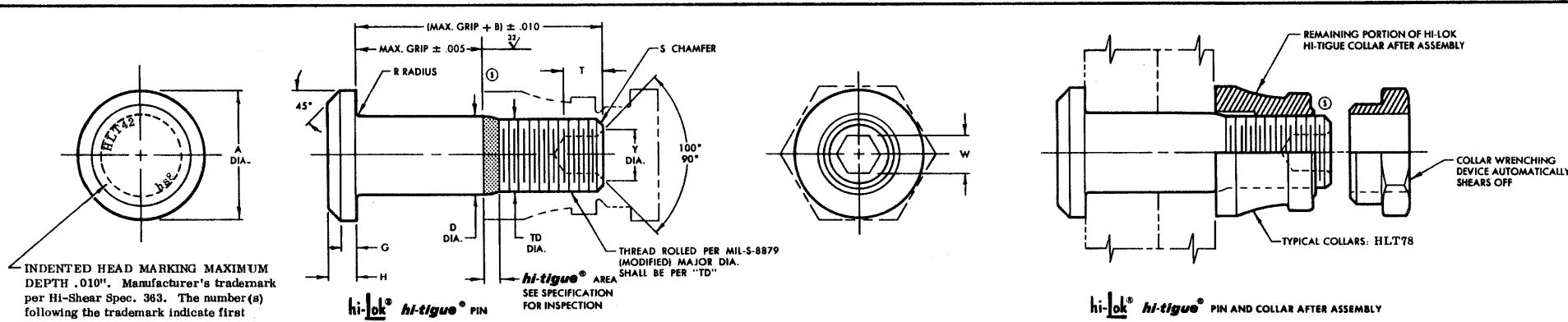


STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS
2800 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

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.
 AIRCRAFT FASTENERS (Forged Parts) LTD., U.K. (Licensee)
 Division of Hi-Shear Industries Inc., U.S.A.
 YDI-SNARK, Division of YDI Corp., U.S.A. (Licensee) U.S. Federal Code I.D. No. 92215
 SP3 TECHNOLOGIES, U.S.A. (Licensee) U.S. Federal Code I.D. No. 56878
 ST. CHAMOND-GRANAT, S.A. France (Licensee—EEC Countries)
 KAMAX-WERKE, Germany (Licensee—EEC Countries)
 Rudolph Kellerman GmbH & Co. (Licensee—EEC Countries—Collars)
 SIMMONDS, S.A. France (Licensee—Japan)
 TOKYO SCREW COMPANY, Japan (Licensee—Japan)
 WEST COAST AEROSPACE INC., U.S.A. (Licensee—Diversa Pins & Steel Collars)
 U.S. Federal Code I.D. No. 60516



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.

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
				WITHOUT HI-KOTE™ LUBE	WITH HI-KOTE™ LUBE							W HEX.	T DEPTH	Y DIA.		
-5	5/32	.322 .306	.312	.1640 .1635	.1640 .1630	.1595 .1570	.030 .055	.060	.025 .015	1/32" x 45°	8-32UNJC-3A Modified	.0645 .0635	.100 .080	.090 .075	4,010	2,180
-6	3/16	.377 .357	.325	.1895 .1890	.1895 .1885	.1840 .1810	.035 .064	.074	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	5,380	2,750
-8	1/4	.440 .415	.395	.2495 .2490	.2495 .2485	.2440 .2410	.045 .080	.090	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	9,300	5,000
-10	5/16	.505 ① .475	.500	.3120 .3115	.3120 .3110	.3060 .3020	.055 .102	.112	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	14,600	8,300
-12	3/8	.600 .565	.545	.3745 .3740	.3745 .3735	.3680 .3640	.075 .130	.140	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	21,000	12,700
-14	7/16	.676 .641	.635	.4370 .4365	.4370 .4360	.4310 .4260	.095 .150	.160	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	28,600	18,900
-16	1/2	.770 .735	.685	.4995 .4990	.4995 .4985	.4930 .4880	.095 .178	.188	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	37,300	25,500
-18	9/16	.877 .842	.770	.5615 .5610	.5615 .5605	.5550 .5500	.125 .200	.210	.040 .025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	47,200	32,400

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. Surface texture per ANSI B46.1.
 3. Hole preparation per NAS618.
 4. Use HLT42 for oversize replacement.

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.

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

HEAT TREAT: 160,000 psi tension minimum (95,000 psi shear minimum) at 70°F.

FINISH: HLT42-()-() = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.

HLT42TB-()-() = 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 and 342-2.

HOW TO ORDER EXAMPLES:

Pin Part Number Only

HLT42-8-8

8/16 or 1/2 Maximum Grip Length

8/32 or 1/4 Nominal Diameter Pin

Pin Part Number

HLT4278-8-8

Size and Grip Length, See Above Example

Collar Part Number

Pin Part Number

U.S. Patent 3,578,367 and international patents. "HI", "HI-LOK", "HLT", and "HI-TIGUE" are internationally registered trademarks of Hi-Shear Corporation.

DRAWN	DATE
Yay	1-18-71
APPROVED	DATE
JG Wilcox	11/3/71
REVISION	DATE
6	D. P. S. 5-15-87

hi-lok® hi-tigue® PIN
PROTRUDING TENSION HEAD
A-286 HIGH TEMPERATURE ALLOY
1/16" GRIP VARIATION

DRAWING NUMBER
HLT42

HLT42