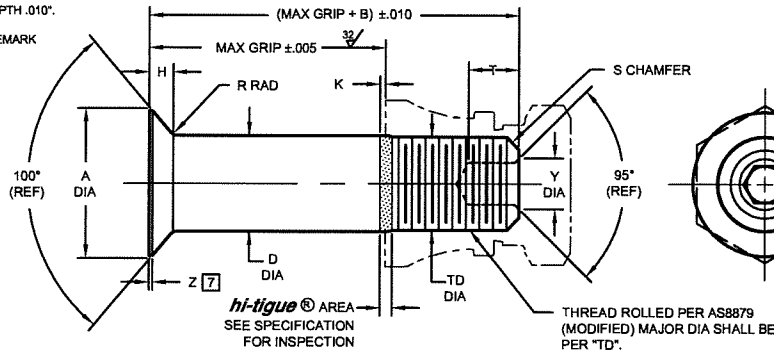
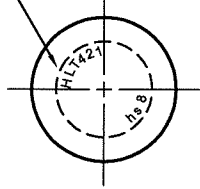


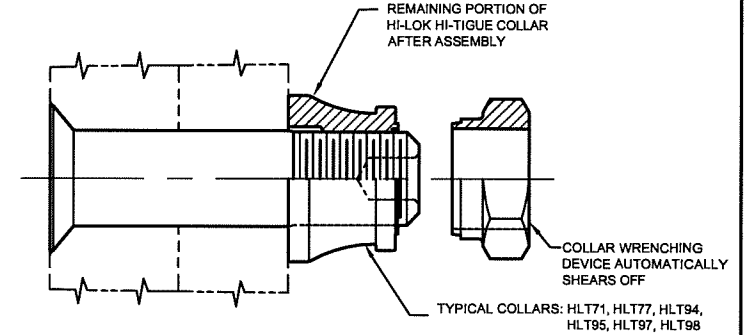
HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197	BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE No. OLB68
a LISI AEROSPACE Company	a LISI AEROSPACE Company
AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A. & Canada) CAGE No. 06725	HUICK S.A. France (Licensee - ECC Countries)
HUCK INTERNATIONAL, INC., U.S.A. (Licensee) CAGE No. 97928	BLANC AERO S.A. France (Licensee - ECC Countries)
SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878	a LISI AEROSPACE Company
FAIRCHILD Aerospace Fastener Division (Licensee) CAGE No. 92215	LISI AEROSPACE CANADA (Licensee) CAGE No. L4528
WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516	a LISI AEROSPACE Company
(Pins & Steel Collars)	TOKYO SCREW COMPANY, Japan (Licensee - Japan)

FT BESTAS, Izmir (Licensee) CAGE No. T0802
a LISI AEROSPACE Company
LISI AEROSPACE CANADA (Licensee) CAGE Code L4528
a LISI AEROSPACE Company

INDENTED HEAD MARKING MAXIMUM DEPTH .010".
"hts" INDICATES HI-SHEAR TRADEMARK.
THE NUMBER(S) FOLLOWING THE TRADEMARK
INDICATES FIRST DASH NUMBER.
ARRANGEMENT OPTIONAL.



HI-LOK® HI-TIGUE® PIN



HI-LOK® HI-TIGUE® PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA.	F	H	K REF	R RAD.	Z MAX.	S CHAMFER REF	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT PLATING S.F.L. OR COATING	WITH PLATING S.F.L. DR COATING									W HEX	T DEPTH	Y DIA		
5	5/32	.2612 .2564	.312	.1635 .1630	.1635 .1625	.1595 .1570	.004	.0408 .0388	.013	.025 .015	.012	1/32" x 45°	8-32UNJC-3A Modified	.0801 .0791	.100 .080	[8]	5,280	1,700
6	3/16	.3016 .2966	.325	.1895 .1890	.1895 .1885	.1840 .1810	.005	.0470 .0449	.016	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	7,060	2,600
8	1/4	.3948 .3898	.395	.2495 .2490	.2495 .2485	.2440 .2410	.006	.0610 .0589	.021	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	12,260	4,400
10	5/16	.4739 .4689	.500	.3120 .3115	.3120 .3110	.3060 .3020	.007	.0679 .0658	.026	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	19,160	7,000
12	3/8	.5604 .5554	.545	.3745 .3740	.3745 .3735	.3680 .3640	.008	.0780 .0759	.030	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	27,600	10,000
14	7/16	.6680 .6620	.635	.4370 .4365	.4370 .4360	.4310 .4260	.009	.0969 .0944	.035	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	37,500	13,500
16	1/2	.7540 .7480	.685	.4995 .4990	.4995 .4985	.4930 .4880	.010	.1068 .1043	.039	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	49,100	18,000
18	9/16	.8380 .8310	.770	.5615 .5610	.5615 .5605	.5550 .5500	.010	.1160 .1131	.039	.050 .040	.022	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	62,100	22,500
20	5/8	.9250 .9180	.825	.6240 .6235	.6240 .6230	.6180 .6120	.010	.1260 .1230	.044	.050 .040	.022	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	76,700	27,000
24	3/4	1.0970 1.0850	1.050	.7490 .7485	.7490 .7480	.7430 .7370	.012	.1460 .1410	.044	.050 .040	.022	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.330 .300	.398 .378	110,400	37,300

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" diameter within .005 FIM.
- "H" is dimensioned from maximum "D" diameter.
- Dimensions to be met after finish.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- Curved or flat edge manufacturer's option.
- Evidence of broken edge across points.
- Use HLT621 for oversize replacement.

MATERIAL:

HEAT TREAT:

FINISH:

- Nickel base alloy per AMS5662.
125,000 psi shear minimum (210,000 psi tensile minimum).
- HLT421(-)(-) = Grit blast top of head, passivate per Hi-Shear Spec. 258, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT421AP(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT421DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT421PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT421PZ(-)(-) = Passivate per Hi-Shear Spec 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT421SJ(-)(-) = Grit blast top of head, passivate per Hi-Shear Spec. 258, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION:

CODE:

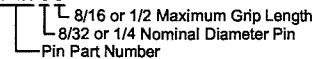
HOW TO ORDER EXAMPLE:

- HLT421SN(-)(-) = Hi-Kote 2 solid film per Hi-Shear Spec. 292, with color orange on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT421TB(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT421MA(-)(-) = Solid film lube per Kal-Gard RA.

Hi-Lok Hi-Tigue Product Specification 342.

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.

Pin Part Number Only
HLT421-8-8



"Hi-Lok", "HL", Hi-Tigue, and "HLT" are internationally registered trademark of Hi-Shear Corporation.			
DRAWN	DATE	TITLE	
D.P.S.	4-22-83	HI-LOK® HI-TIGUE® PIN	
APPROVED	DATE	100° FLUSH SHEAR HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16" GRIP VARIATION	
R. Ting	4-22-83		
REVISION	DATE	DRAWING NUMBER	
[12]	J0 3-19-09	HLT421	