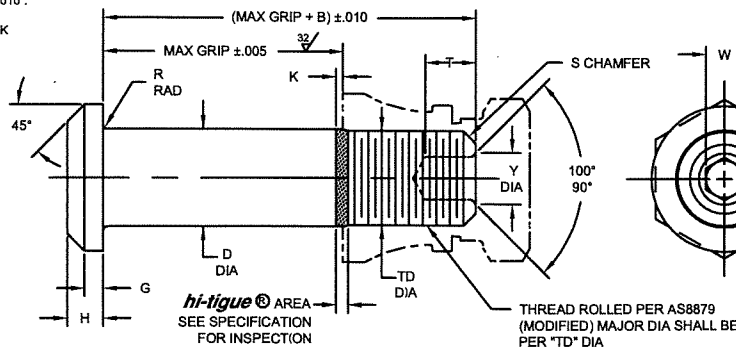
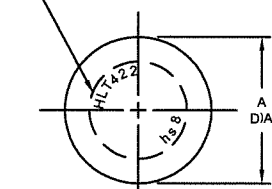
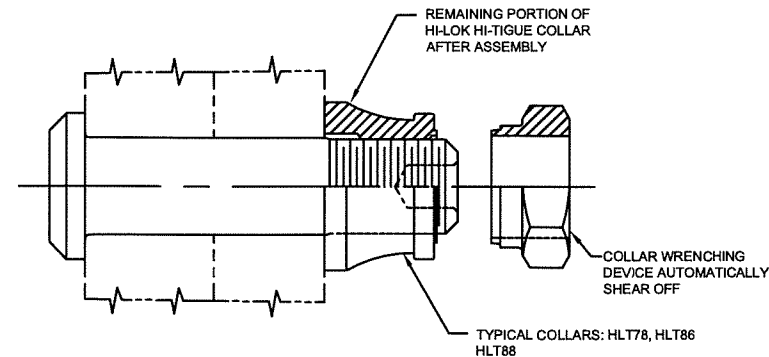


15	HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197 a LISI AEROSPACE Company	BLANC AERO INDUSTRIES RUGBY (Licensee) CAGE No. U6300 a LISI AEROSPACE Company
	AIR INDUSTRIES CO., INC. U.S.A. (Licensee - U.S.A. & Canada) CAGE No. 06725	BLANC AERO S.A. France (Licensee) CAGE NO. F0188 a LISI AEROSPACE Company
	ALCOA FASTENING SYSTEMS, U.S.A. (Licensee) CAGE No. 15653	LISI AEROSPACE CANADA (Licensee) CAGE No. L4528 a LISI AEROSPACE Company
	SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878	FT BESTAS, Izmer (Licensee) CAGE No. T0802 a LISI AEROSPACE Company
	WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516	
	MINEBEA CO., LTD. Japan (Pins & Steel Collars) (Licensee-Japan)	

INDENTED HEAD MARKING MAXIMUM DEPTH .010".
"hs" 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.	G REF	H	K REF	R RAD	S CHAMFER REF	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT PLATING S.F.L. OR COATING	WITH PLATING S.F.L. OR COATING								W HEX	T DEPTH	Y DIA		
5	5/32	.322 .306	.312	.1635 .1630	.1635 .1625	.1595 .1570	.030	.065 .055	.013	.025 .015	1/32" x 45°	8-32UNJF-3A Modified	.0801 .0791	.100 .080	5	5,280	2,490
6	3/16	.377 .357	.325	.1895 .1890	.1895 .1885	.1840 .1810	.035	.074 .064	.016	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	7,060	4,350
8	1/4	.440 .415	.395	.2495 .2490	.2495 .2485	.2440 .2410	.045	.090 .080	.021	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	12,260	7,750
10	5/16	.505 .475	.500	.3120 .3115	.3120 .3110	.3060 .3020	.055	.112 .102	.026	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	1295 .1270	.130 .110	.180 .160	19,160	12,300
12	3/8	.600 .565	.545	.3745 .3740	.3745 .3735	.3680 .3640	.075	.140 .130	.030	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	27,600	19,100
14	7/16	.676 .641	.635	.4370 .4365	.4370 .4360	.4310 .4260	.095	.160 .150	.035	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	37,500	25,800
16	1/2	.770 .735	.685	.4995 .4990	.4995 .4985	.4930 .4880	.095	.188 .178	.039	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	49,100	34,300
18	9/16	.877 .842	.770	.5615 .5610	.5615 .5605	.5550 .5500	.125	.210 .200	.039	.040 .025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	62,100	43,500
20	5/8	.953 .918	.825	.6240 .6235	.6240 .6230	.6180 .6120	.175	.265 .255	.044	.040 .025	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	76,700	54,600
24	3/4	1.150 1.110	1.050	.7490 .7485	.7490 .7480	.7430 .7370	.200	.335 .320	.044	.045 .030	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.330 .300	.398 .378	110,400	79,200

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

GENERAL NOTES:

1. Concentricity: "A" to "D" diameter within .010 FIM.
2. Dimensions to be met after finish.
3. Surface texture per ANSI B46.1.
4. Hole preparation per NAS618.
- 5 Evidence of broken edge across points.
6. Use HLT622 for oversize replacement.

MATERIAL:

Nickel base alloy per AMS5662.

HEAT TREAT:

125,000 psi shear minimum (210,000 psi tensile minimum).

FINISH:

- HLT422(-)(-) = Passivate per Hi-Shear Spec. 258, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT422AP(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT422DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT422PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT422SC(-)(-) = Grit blast top of head, passivate per Hi-Shear Spec. 258, with color green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT422FB(-)(-) = Grit blast top of head, passivate per Hi-Shear Spec. 258, 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

EXAMPLE:

Pin Part Number Only
HLT422-8-8
┌ 8/16 or 1/2 Maximum Grip Length
└ 8/32 or 1/4 Nominal Diameter Pin
Pin Part Number

"Hi-Lok" and "HL" are internationally registered trademark of Hi-Shear Corporation.		
DRAWN	DATE	TITLE
D.P.S.	4-22-83	HI-LOK® HI-TIGUE® PIN
APPROVED	DATE	PROTRUDING TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16" GRIP VARIATION
R.Ting	4-22-83	
REVISION	DATE	DRAWING NUMBER
15	LV 5-18-09	HLT422