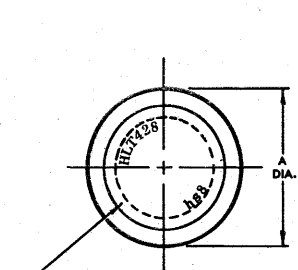


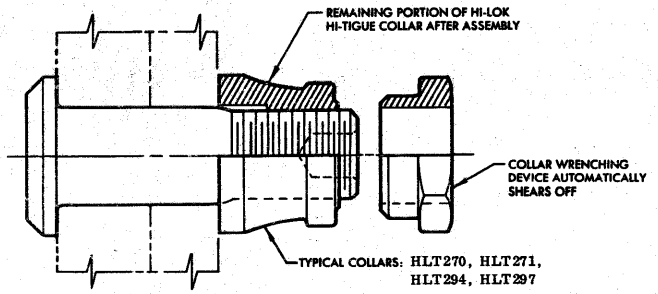
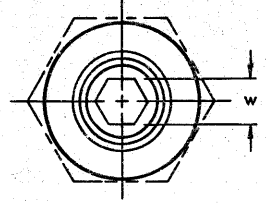
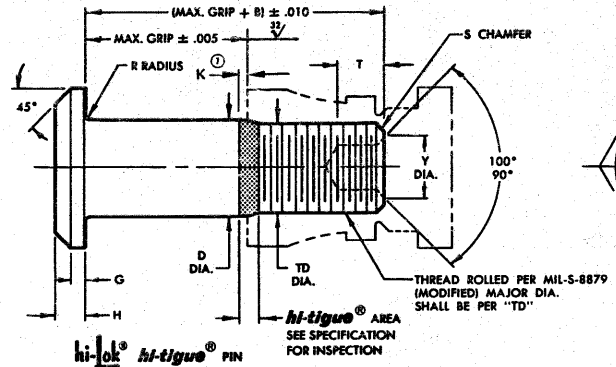
**STANDARDS COMMITTEE FOR
HI-LOK® HI-TIGUE® PRODUCTS**
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

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)
 AIRCRAFT FASTENERS (Foreign Parts) LTD., U.K. (Licensee)
 Division of Hi-Shear Industries Inc., U.S.A. (Licensee)
 HI-SHEAR, 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. 94979

ST. CHAMOND-GRANAT, S.A. France (EEC Countries)
 KAMAX-WERKE, Germany (EEC Countries)
 Rudolph Kellerman GmbH & Co. (Licensee-EEC Countries-Collars)
 SHIMADZU, S.A. France (Licensee-Japan)
 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. 90918



① 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.



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	K REF.	R RAD.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
												W HEX.	T DEPTH	Y DIA.		
-5	3/16			NOTE: Use HL328-6												
-6	13/64	.315 .295	.360	.2026 .2016	.1840 .1810	.025 .045	.055 .020	.025 .015	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	6,970	2,900
-8	17/64	.412 .387	.435	.2651 .2641	.2440 .2410	.030 .059	.069 .059	.025 .015	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0987 .0947	.110 .090	.142 .122	11,920	5,100
-10	21/64	.505 .475	.545	.3276 .3266	.3060 .3020	.035 .068	.078 .068	.031 .020	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .180	18,200	7,100
-12	25/64	.600 .565	.590	.3901 .3891	.3680 .3640	.040 .078	.088 .078	.037 .020	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	25,800	9,800
-14	29/64	.676 .641	.690	.4526 .4516	.4310 .4260	.045 .093	.105 .093	.039 .020	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	34,800	14,000
-16	33/64	.770 .735	.740	.5151 .5141	.4930 .4880	.050 .116	.116 .103	.045 .020	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	45,000	17,800
-18	37/64	.864 .829	.825	.5771 .5761	.5550 .5500	.055 .112	.127 .112	.043 .025	.040 .025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	56,500	21,500

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. Dimensions to be met after plating.
 3. Surface texture per ANSI B46.1.
 4. Hole preparation per NAS618.
 5. Use HLT628 for oversize replacement.

① CODE: First dash number indicates nominal diameter in 32nds of the pin which HLT428 oversize pin replaces. Second dash number indicates maximum grip in 16ths. See "Finish" note for explanation of code letters.

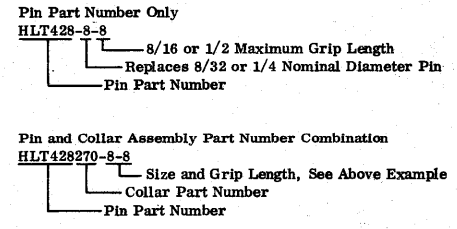
MATERIAL: Alloy steel per Spec. MIL-S-5000, MIL-S-5626 or MIL-S-6049.

HEAT TREAT: 108,000 psi shear minimum (180,000-200,000 psi tensile per Spec. MIL-H-6875).

FINISH: HLT428-()-() = Cadmium plate per Spec. QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT428TB-()-() = Cadmium plate per QQ-P-416, Type II, Class 2; 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.

HOW TO ORDER
EXAMPLES:



U.S. Patent 3,578,367 and international patents. "HL", "Hi-Lok", "HLT", and "Hi-Tigue" are internationally registered trademarks of Hi-Shear Corporation.

DRAWN	DATE	
Van	6-21-69	
APPROVED	DATE	PROTRUDING SHEAR HEAD ALLOY STEEL 1/16" GRIP VARIATION - 1/64" OVERSIZE
V. Miller	6-24-69	
REVISION	DATE	DRAWING NUMBER
①	D.P.S. 11-3-87	HLT428

HLT428