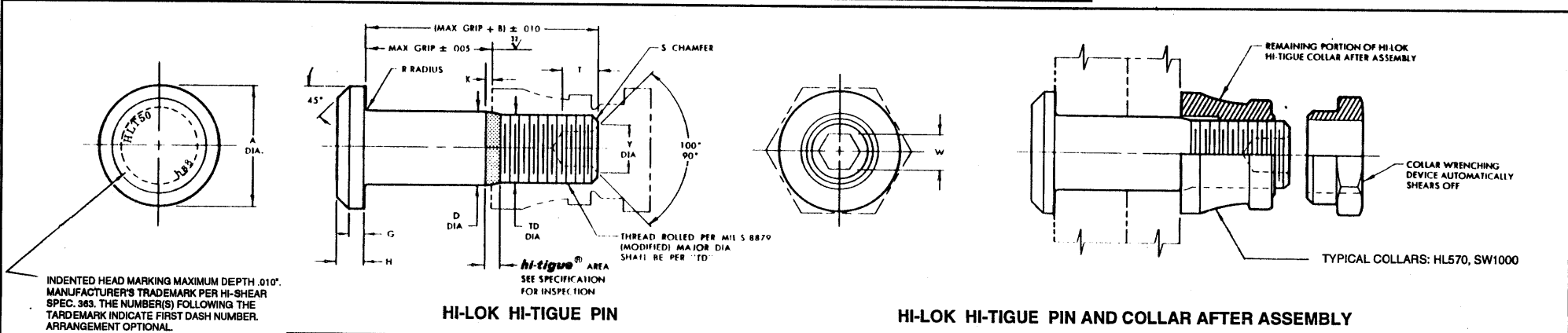


STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
 A Subsidiary of GI Industries, France
 AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S. & Canada) CAGE No. 08725
 HUCK INTERNATIONAL, INC., Deutsch Operation, U.S.A. (Licensee) CAGE No. 97928
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 58878
 FAIRCHILD Aerospace Fastener Division, U.S.A. (Licensee) CAGE No. 92215
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 80516
 (Pins & Steel Collars)

HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee) - CAGE NO. CL868
 A Subsidiary of GI Industries, France
 HUCK S.A. (Licensee - EEC Countries)
 SAINT CHAMOND GRANAT, S.A. France (Licensee - EEC Countries)
 SIMMONDS S.A., France (Licensee - EEC Countries-Collars)
 TOKYO 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
												W HEX.	T DEPTH	Y DIA.		
5	5/32	.262 .242	.312	.1635 .1630	.1595 .1570	.020	.047 .037	.013	.025 .015	1/32" x 45°	8-32UNJC-3A Modified	.0801 .0791	.135 .115	[5]	5,280	2,200
6	3/16	.315 .295	.325	.1895 .1890	.1840 .1810	.025	.055 .045	.016	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	7,060	3,000
8	1/4	.412 .387	.395	.2495 .2490	.2440 .2410	.030	.069 .059	.021	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	12,260	5,100
10	5/16	.505 .475	.500	.3120 .3115	.3060 .3020	.035	.078 .068	.026	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	19,160	8,000
12	3/8	.676 .641	.545	.3745 .3740	.3680 .3640	.040	.088 .078	.030	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	27,600	11,300
14	7/16	.876 .841	.635	.4370 .4365	.4310 .4260	.045	.105 .093	.035	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	37,500	15,500
16	1/2	.970 .935	.685	.4995 .4990	.4930 .4880	.050	.115 .103	.039	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	49,100	20,000

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

GENERAL NOTES:

- Concentricity: "A" to "D" diameter within .010 FIR.
- Dimensions to be met before finish
- Surface texture per ANSI B46. 1.
- Hole preparation per NAS618.
- Evidence of broken edge across points.
- Use HLT150 for oversize replacement.

SPECIFICATION:

Hi-Lok Hi-Tigue Product Specification 342.

CODE:

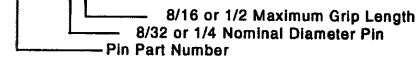
First dash number indicates nominal diameter in 1/32nds. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER

EXAMPLE:

Pin Part Number Only

HLT50TB-8-8



MATERIAL:
HEAT TREAT:

PH13-8Mo stainless steel per Spec. AMS5629.
125,000 psi shear minimum.

FINISH:

- HLT50-()-() = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT50DL()-() = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT50TB()-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT50YB()-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, white paint on head, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT50YC()-() = Solid film lube per AS5272, Type I, white paint on head, and cetyl alcohol lube per Hi-Shear Spec. 305.

"Hi-Lok", "HL", "Hi-Tigue", and "HLT" are internationally registered trademarks of Hi-Shear Corporation.		
DRAWN	DATE	TITLE
D.P.S.	1-20-77	HI-LOK® HI-TIGUE® PIN PROTRUDING SHEAR HEAD PH13-8Mo STAINLESS STEEL 1/16" GRIP VARIATION
APPROVED	DATE	
JGWilcox	1-20-77	
REVISION	DATE	DRAWING NUMBER
5	J.Henderson 4-30-98	HLT50