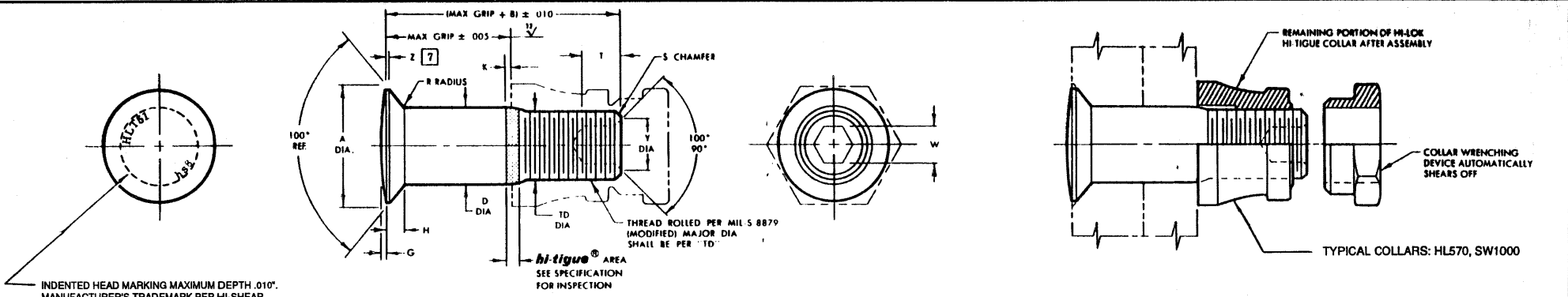


# STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197  
 A Subsidiary of QFI Industries, France  
 AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A. Canada) CAGE No. 06726  
 HUKK INTERNATIONAL, INC., Deutch Operation, U.S.A. (Licensee) CAGE No. 87823  
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 88878  
 FAIRCHILD Aerospace Fastener Division, U.S.A. (Licensee) CAGE No. 82218  
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 80818  
 (Pin & Stud Collars)

HI-SHEAR FASTENERS EUROPE LTD., U.K. (Licensee) - CAGE No. 0LB68  
 A Subsidiary of QFI Industries, France  
 HUKK INTERNATIONAL GMBH & CO., Germany (Licensee - EEC Countries)  
 SAINT CHAMOND GRAMAT, S.A. France (Licensee - EEC Countries)  
 SIMMONDS S.A., France (Licensee - EEC Countries-Collars)  
 TOKYO SCREW COMPANY, Japan (Licensee - Japan)



HI-LOK HI-TIGUE PIN

HI-LOK HI-TIGUE PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.	TD DIA.	F	G	H	K REF.	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
														W HEX.	T DEPTH	Y DIA.		
5	5/32	.2612 .2564	.312	.1635 .1630	.1595 .1570	.004	.015 .010	.0410 .0390	.013	.025 .015	.10	1/32" x 45°	8-32UNJC-3A Modified	.0801 .0791	.135 .115	.119	5,280	1,700
6	3/16	.3016 .2966	.325	.1895 .1890	.1840 .1810	.005	.015 .010	.0470 .0450	.016	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.104	7,060	2,600
8	1/4	.3948 .3898	.395	.2495 .2490	.2440 .2410	.006	.015 .010	.0610 .0590	.021	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	12,260	4,400
10	5/16	.4739 .4689	.500	.3120 .3115	.3060 .3020	.007	.015 .010	.0680 .0660	.026	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	19,160	7,000
12	3/8	.5604 .5554	.545	.3745 .3740	.3680 .3640	.008	.015 .010	.0780 .0760	.030	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	27,600	10,000
14	7/16	.6680 .6620	.635	.4370 .4365	.4310 .4260	.009	.015 .010	.0969 .0944	.035	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	37,500	12,500
16	1/2	.7540 .7480	.685	.4995 .4990	.4930 .4880	.010	.015 .010	.1068 .1043	.039	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	49,100	18,000

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

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.

GENERAL NOTES:

- Head edge out of roundness shall not exceed "F".
- Concentricity: Conical surface of head to "D" dia within .005 FIM.
- "H" dimensioned from maximum dia.
- Dimensions to be met before 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 HLT51 for oversize replacement.

MATERIAL:  
HEAT TREAT:  
FINISH:

PH13-8Mo stainless steel per Spec. AMS5629.  
 125,000 psi shear minimum.  
 HLT51(-)(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HLT51DL(-)(-) = Solid film lube per AS5272, Type 1, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HLT51TB(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HLT51YB(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, white paint on head, and cetyl alcohol lube per per Hi-Shear Spec. 305.

HLT51YC(-)(-) = Solid film lube per AS5272, Type 1, white paint on head, and cetyl alcohol lube per Hi-Shear Spec. 305.

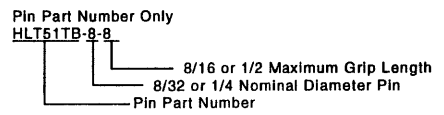
SPECIFICATION:

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:



"Hi-Lok", "HL", "Hi-Tigue", and "HLT" are internationally registered trademarks of Hi-Shear Corporation.	
DRAWN DATE D.P.S. 1-20-77	TITLE <b>HI-LOK® HI-TIGUE® PIN</b> 100° FLUSH CROWN SHEAR HEAD PH13-8Mo STAINLESS STEEL 1/16" GRIP VARIATION
APPROVED DATE JGWilcox 1-20-77	DRAWING NUMBER <b>HLT51</b>
REVISION DATE ⑤ J.Henderson 1-6-98	

HLT51