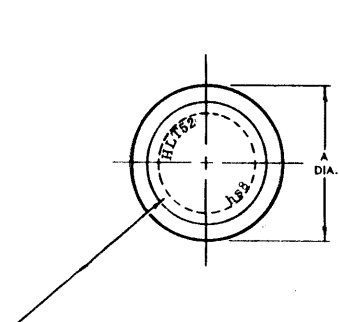


# STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

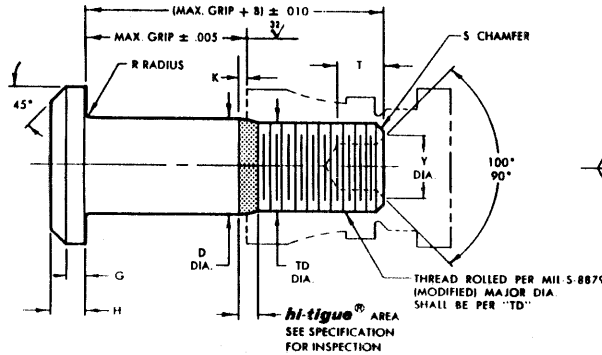
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

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. & Canada) CAGE No. 04726  
 HUCK INTERNATIONAL, INC., Deutch Operation, U.S.A. (Licensee) CAGE No. 97928  
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 66878  
 FAIRCHILD Aerospace Fastener Division, U.S.A. (Licensee) CAGE No. 82216  
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 80616  
 (Pins & Seal Collars)

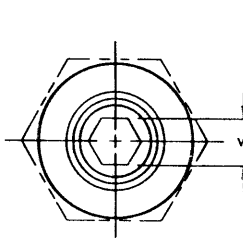
HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee) - CAGE NO. CL888  
 A Subsidiary of QFI Industries, France  
 HUCK S.A. (Licensee - EEC Countries)  
 SAINT CHAMOND GRANAT, S.A. France (Licensee - EEC Countries)  
 SMMONDS S.A., France (Licensee - EEC Countries-Collars)  
 TOKYO SCREW COMPANY, Japan (Licensee - Japan)



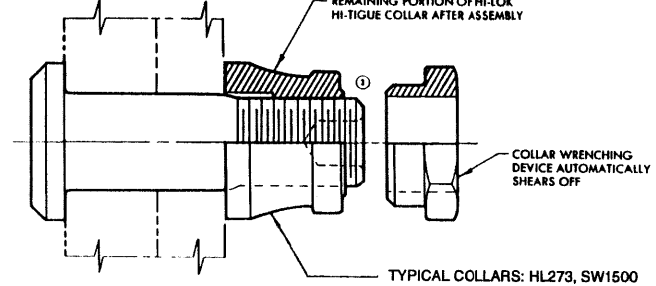
INDENTED HEAD MARKING MAXIMUM DEPTH .010".  
 MANUFACTURER'S TRADEMARK PER HI-SHEAR  
 SPEC. 363. THE NUMBER(S) FOLLOWING THE  
 TRADEMARK INDICATE FIRST DASH NUMBER.  
 ARRANGEMENT OPTIONAL.



HI-LOK HI-TIGUE PIN



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	5/32	.322 .306	.312	.1635 .1630	.1595 .1570	.030 .055	.065 .055	.013	.025 .015	1/32" x 45°	8-32UNJC-3A Modified	.0801 .0791	.135 .115	5	5,280	2,940
6	3/16	.377 .357	.325	.1895 .1890	.1840 .1810	.035 .064	.074 .064	.016	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	7,060	4,350
8	1/4	.440 .415	.395	.2495 .2490	.2440 .2410	.045 .080	.090 .080	.021	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	12,260	7,750
10	5/16	.505 .475	.500	.3120 .3115	.3060 .3020	.055 .102	.112 .102	.026	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	19,160	12,300
12	3/8	.600 .565	.545	.3745 .3740	.3680 .3640	.075 .130	.140 .130	.030	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	27,600	19,100
14	7/16	.676 .641	.635	.4370 .4365	.4310 .4260	.095 .150	.160 .150	.035	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	37,500	25,800
16	1/2	.770 .735	.685	.4995 .4990	.4930 .4880	.095 .178	.188 .178	.039	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	49,100	34,300

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

GENERAL NOTES:

- Concentricity: "A" to "D" diameter within .010 FIM.
- Dimensions to be met before finish.
- Surface texture per ANSI B46. 1.
- Hole preparation per NAS618.
- Evidence of broken edge across points.
- Use HLT152 for oversize replacement.

SPECIFICATION:

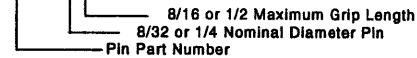
Hi-Lok Hi-Tigue Product Specification 342.

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  
 HLT52TB-8-8



MATERIAL:  
 HEAT TREAT:

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

FINISH:

- HLT52-( )-( ) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT52DL( )-( ) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT52TB( )-( ) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT52YB( )-( ) = 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.
- HLT52YC( )-( ) = Solid film lube per AS5272, Type I, white paint on head, and cetyl alcohol lube per Hi-Shear Spec. 305.

DRAWN DATE		TITLE	
D.P.S. 1-20-77		HI-LOK® HI-TIGUE® PIN PROTRUDING TENSION HEAD PH13-8Mo STAINLESS STEEL 1/16" GRIP VARIATION	
APPROVED DATE		DRAWING NUMBER	
JGW/icox 1-20-77		HLT52	
REVISION DATE		DRAWING NUMBER	
5 J.Henderson 4-30-98		HLT52	

HLT52