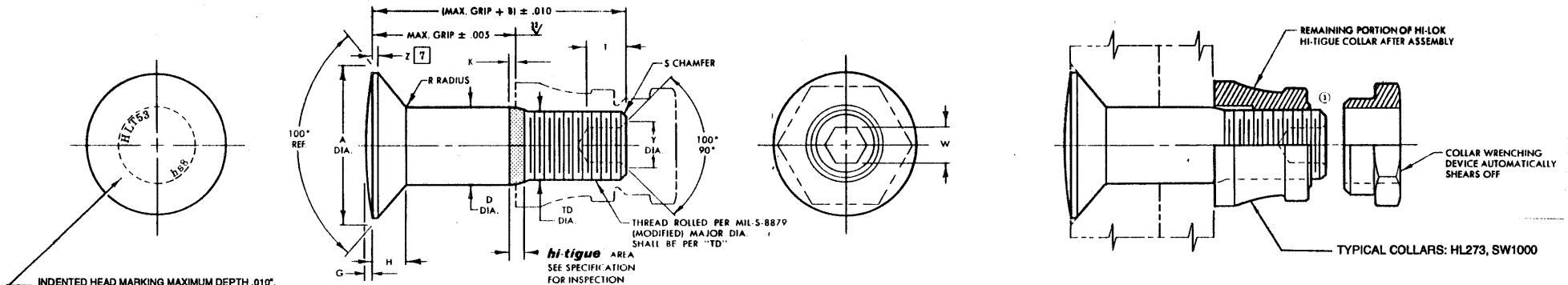


STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
 A Subsidiary of GR Industries, France
 AIR INDUSTRIES CO., INC. U.S.A. (Licensee - U.S. & Canada) CAGE No. 06725
 HUCK INTERNATIONAL, INC. U.S.A. (Licensee) CAGE No. 97228
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 88778
 FARRCHILD Aerospace Partner Division, U.S.A. (Licensee) CAGE No. 92218
 WEST COAST AEROSPACE INC. U.S.A. (Licensee) CAGE No. 80618
 (Pins & Steel Collars)

HI-SHEAR FASTENERS EUROPE LTD., U.K. (Licensee) - CAGE NO. CL868
 A Subsidiary of GR Industries, France
 HUCK INTERNATIONAL GmbH & Co., Germany (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)



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.	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	.3304 .3256	.312	.1635 .1630	.1595 .1570	.004	.015 .010	.0698 .0678	.013	.025 .015	.010	1/32" x 45°	8-32UNJC-3A Modified	.1801 .0791	.135 .115	[8]	5,280	2,940
6	3/16	.3813 .3765	.325	.1895 .1890	.1840 .1810	.005	.015 .010	.0805 .0785	.016	.025 .015	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	7,060	4,350
8	1/4	.5066 .5018	.395	.2495 .2490	.2440 .2410	.006	.015 .010	.1080 .1060	.021	.025 .015	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	12,260	7,750
10	5/16	.6335 .6287	.500	.3120 .3115	.3060 .3020	.007	.015 .010	.1350 .1330	.026	.030 .020	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	19,160	12,300
12	3/8	.7604 .7556	.545	.3745 .3740	.3680 .3640	.008	.015 .010	.1620 .1600	.030	.030 .020	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	27,600	19,100
14	7/16	.8884 .8812	.635	.4370 .4365	.4310 .4260	.009	.015 .010	.1895 .1865	.035	.030 .020	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	37,500	25,800
16	1/2	1.0139 1.0068	.685	.4995 .4990	.4930 .4880	.010	.015 .010	.2160 .2130	.039	.030 .020	.022	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:

- 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 HLT153 for oversize replacement.

MATERIAL:
HEAT TREAT:
FINISH:

- PH13-8Mo stainless steel per Spec. AMS5629.
 125,000 psi shear minimum.
 HLT53(-)(-) = Rassistate per Hi-Shear Spec. 258
 and cetyl alcohol lube per Hi-Shear Spec. 305.
 ④ HLT53DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT53TB(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT53YB(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, white paint on head, and cetyl alcohol lube per Hi-Shear Spec. 305.

④ HLT53YC(-)(-) = Solid film lube per AS5272, Type I, 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:

Pin Part Number Only
 HLT53TB-8-8
 8/16 or 1/2 Maximum Grip Length
 8/32 or 1/4 Nominal Diameter Pin
 Pin Part Number

DRAWN DATE		TITLE	
D.P.S. 1-20-77		HI-LOK® HI-TIGUE® PIN 100° FLUSH CROWN MS24694	
APPROVED DATE		TENSION HEAD	
JGWilcox 1-20-77		PH13-8Mo STAINLESS STEEL 1/16" GRIP VARIATION	
REVISION DATE		DRAWING NUMBER	
④ J.Henderson 10-7-97		HLT53	

HLT53