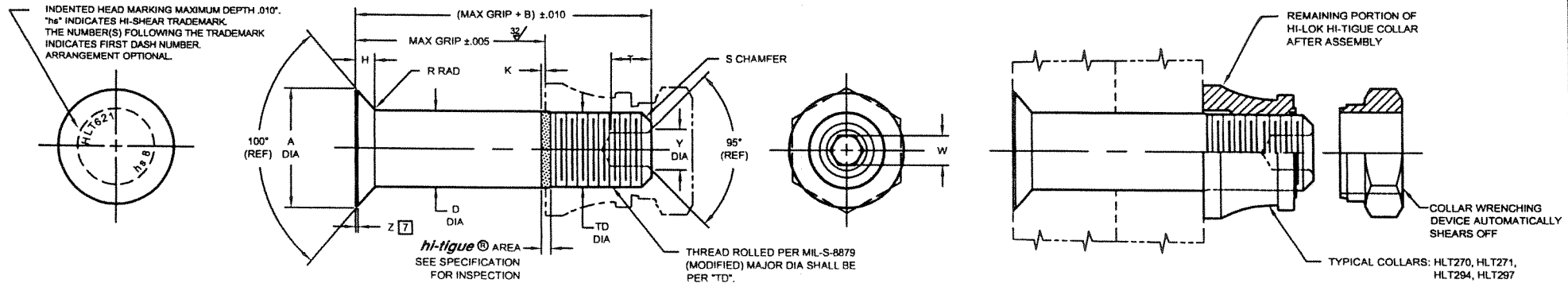


STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197	BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE No. OLB68
a LISI AEROSPACE Company	a LISI AEROSPACE Company
HUCK INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A. & Canada) CAGE No. 06725	HUCK S.A. France (Licensee - ECC Countries)
AIR INTERNATIONAL, INC., U.S.A. (Licensee) CAGE No. 97928	BLANC AERO S.A. France (Licensee - ECC Countries)
SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878	a LISI AEROSPACE Company
FAIRCHILD Aerospace Fastener Division (Licensee) CAGE No. 92215	TOKYO SCREW COMPANY, Japan (Licensee - Japan)
WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516	
(Pins & Steel Collars)	



HI-LOK® HI-TIGUE® PIN

HI-LOK® HI-TIGUE® PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	F	H	K REF	R RAD.	Z MAX.	S CHAMFER REF	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	
				WITHOUT PLATING S.F.L. OR COATING	WITH PLATING S.F.L. OR COATING									W HEX	T DEPTH	Y DIA			
NOTE: USE HLT421(-)6(-)																			
6	13/64	.3016 2966	.360	.2026 2021	.2026 2016	.1840 1810	.005	.0415 .0394	.016	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	8,100	2,600	
8	17/64	.3948 3898	.435	.2651 2646	.2651 2641	.2440 2410	.006	.0544 .0523	.021	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	13,800	4,400	
9	10	21/64	.4894 4844	.545	.3276 3271	.3276 3266	.3060 3020	.007	.0679 .0658	.026	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	21,100	7,000
9	12	25/64	.5760 5710	.590	.3901 3896	.3901 3891	.3680 3640	.008	.0780 .0759	.030	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	30,000	10,000
14	29/64	.6680 6620	.690	.4526 4521	.4526 4516	.4310 4260	.009	.0904 .0879	.035	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	40,300	13,500	
16	33/64	.7540 7480	.740	.5151 5146	.5151 5141	.4930 4880	.010	.1002 .0977	.039	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	52,500	18,000	
18	37/64	.8380 8310	.825	.5771 5766	.5771 5761	.5550	.010	.1094 .1065	.039	.050 .040	.022	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	65,600	22,500	
20	41/64	.9250 9180	.890	.6396 6391	.6396 6386	.6180 6120	.010	.1197 .1168	.044	.050 .040	.022	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	80,600	27,000	
24	45/64	1.0970 1.0850	1.115	.7646 7641	.7646 7636	.7430 7370	.012	.1394 .1344	.044	.050 .040	.022	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.330 .300	.398 .378	115,000	37,300	

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" diameter within .005 FIR.
- "H" is dimensioned from maximum "D" diameter.
- Dimensions to be met after finish.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- Curved or flat edge manufacturer's option.
- Use HLT715 for oversize replacement.
- Parts produced prior to 1 October 2002 may have "A" theoretical diameter and "H" dimension as follows: "A" for -10, 4689-4739, and -12, .5554-.5604; and "H" for -10, .0593-.0614, and -12, .0693-.0714.

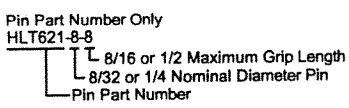
SPECIFICATION:

- Hi-Lok Hi-Tigue Product Specification 342.
- HLT621FJ(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, color red on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT621SK(-) = Grit blast top of head, passivate per Hi-Shear Spec 258, with color brown on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT621SP(-) = Hi-Kote 2 solid film per Hi-Shear Spec. 292, with color brown on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT621TB(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT621FF(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, with color red on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

CODE:

First dash number indicates nominal diameter in 1/32nds of the pin which HLT621 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER EXAMPLE:



MATERIAL:
HEAT TREAT:
FINISH:

- Nickel base alloy per AMS5662.
125,000 psi shear minimum (210,000 psi tensile minimum).
- HLT621(-)(-) = Passivate per Hi-Shear Spec. 258, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT621AP(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT621DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT621PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT421FB(-)(-) = Grit blast top of head, passivate per Hi-Shear Spec 258 and cetyl alcohol lube per Hi-Shear Spec. 305.

"Hi-Lok", "HL", Hi-Tigue, and "HLT" are internationally registered trademark of Hi-Shear Corporation.	
DRAWN S. Graphics DATE 6-2-83	TITLE HI-LOK® HI-TIGUE® PIN 100° FLUSH SHEAR HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16" GRIP VARIATION, 1/64" OVERSIZE
APPROVED R. Ting DATE 6-6-83	DRAWING NUMBER HLT621
REVISION (1)	DATE JO 8-20-02

HLT621