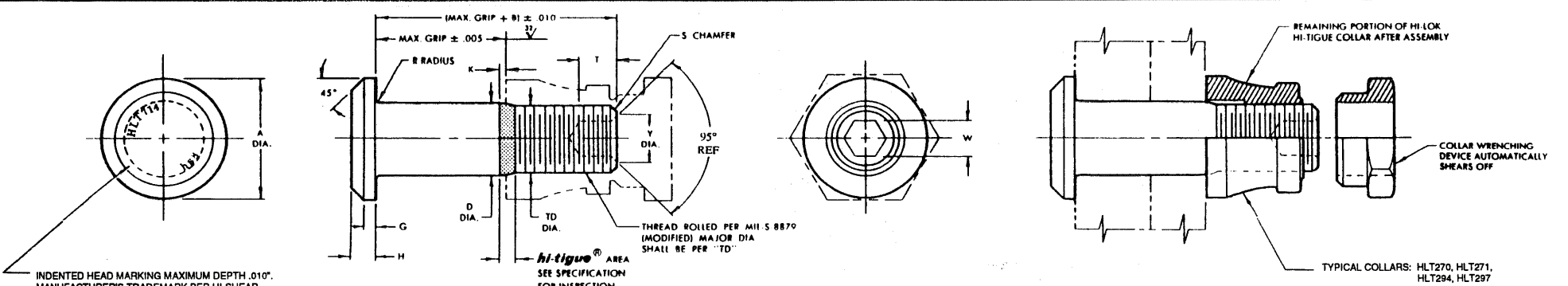


STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
 A Subsidiary of GFI Industrie, France.
 AIR INDUSTRIES CO., INC. (Licensee - U.S. & Canada) CAGE No. 06725
 HUCK INTERNATIONAL, INC., Lakewood Operation, U.S.A. (Licensee) CAGE No. 97528
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 65678
 FAIRCHILD Aerospace Fastener Division, U.S.A. (Licensee) CAGE No. 92215
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 80616
 (Pins & Steel Collars)

HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee) CAGE No. 0LB68
 A Subsidiary of GFI Industrie, France.
 HUCK INTERNATIONAL GmbH & Co. Germany (Licensee - EEC Countries)
 ST. 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.	G REF.	H	K REF.	R RAD.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT PLATING OR COATING	WITH PLATING OR COATING								W HEX.	T DEPTH	Y DIA.		
5																	
NOTE: USE HLT420-6(-)																	
6	7/32	.315 .295	.360	.2182 .2177	.2182 .2172	.1840 .1810	.025	.055 .045	.016	.025 .015		1/32" x 45° Modified	.0806 .0791	.100 .080	.119 .104	9,400	3,000
8	9/32	.412 .387	.435	.2807 .2802	.2807 .2797	.2440 .2410	.030	.069 .059	.021	.025 .015		1/32" x 45° Modified	.0967 .0947	.110 .090	.142 .122	15,500	5,100
10	11/32	.505 .475	.545	.3432 .3427	.3432 .3422	.3060 .3020	.035	.078 .068	.026	.030 .020		3/64" x 45° Modified	.1295 .1270	.130 .110	.180 .160	23,200	8,000
12	13/32	.600 .565	.590	.4057 .4052	.4057 .4047	.3680 .3640	.040	.088 .078	.030	.030 .020		3/64" x 45° Modified	.1617 .1582	.160 .140	.217 .197	32,400	11,300
14	15/32	.676 .641	.690	.4682 .4677	.4682 .4672	.4310 .4260	.045	.105 .093	.035	.030 .020		3/64" x 45° Modified	.1930 .1895	.190 .170	.253 .233	43,100	15,500
16	17/32	.770 .735	.740	.5307 .5302	.5307 .5297	.4930 .4880	.050	.115 .103	.039	.030 .020		3/64" x 45° Modified	.2242 .2207	.220 .200	.289 .269	55,400	20,000
18	19/32	.864 .829	.825	.5927 .5922	.5927 .5917	.5550 .5500	.055	.127 .112	.039	.040 .025		1/16" x 45° Modified	.2555 .2520	.260 .240	.326 .306	69,200	25,000
20	21/32	.953 .918	.890	.6552 .6547	.6552 .6542	.6180 .6120	.060	.137 .122	.044	.040 .025		1/16" x 45° Modified	.2555 .2520	.260 .240	.326 .306	84,500	30,200
24	25/32	1.108 1.068	1.115	.7802 .7797	.7802 .7792	.7430 .7370	.070	.151 .136	.044	.045 .030		1/16" x 45° Modified	.3185 .3150	.330 .300	.398 .378	120,000	40,200

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 after finish.
- Surface texture per ANSI B46. 1.
- Hole preparation per NAS618.
- Oversize pin for HLT420 and HLT620.

SPECIFICATION:

Hi-Lok Hi-Tigue Product Specification 342.

CODE:

First dash number indicates nominal diameter in 1/32nds of the pin which HLT714 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

**MATERIAL:
HEAT TREAT:**

Nickel base alloy per AMS5662.
 125,000 psi shear minimum (210,000 psi tensile minimum).

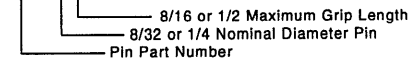
FINISH:

- HLT714(-)(-) = Passivate per Hi-Shear Spec. 258, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT714AP(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
- ③ HLT714DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT714FB(-)(-) = Grit blast top of head, passivate per Hi-Shear Spec. 258, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT714PB(-)(-) = Cadmium plate per QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT714SK(-)(-) = 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.
- HLT714SP(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, with color brown on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT714TB(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.

**HOW TO ORDER
EXAMPLE:**

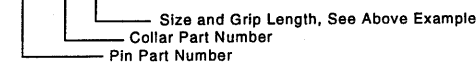
Pin Part Number Only

HLT714-8-8



Pin and Collar Assembly Part Number Combination

HLT714294-8-8



"Hi-Lok", "HL", "Hi-Tigue", and "HLT" are internationally registered trademarks of Hi-Shear Corporation.		
DRAWN	DATE	TITLE HI-LOK® HI-TIGUE® PIN PROTRUDING SHEAR HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16" GRIP VARIATION, 1/32" OVERSIZE
D.P.S.	2-8-85	
APPROVED	DATE	DRAWING NUMBER HLT714
JGWilcox	2-11-85	
REVISION	DATE	
⑥	J.Henderson 10-6-97	