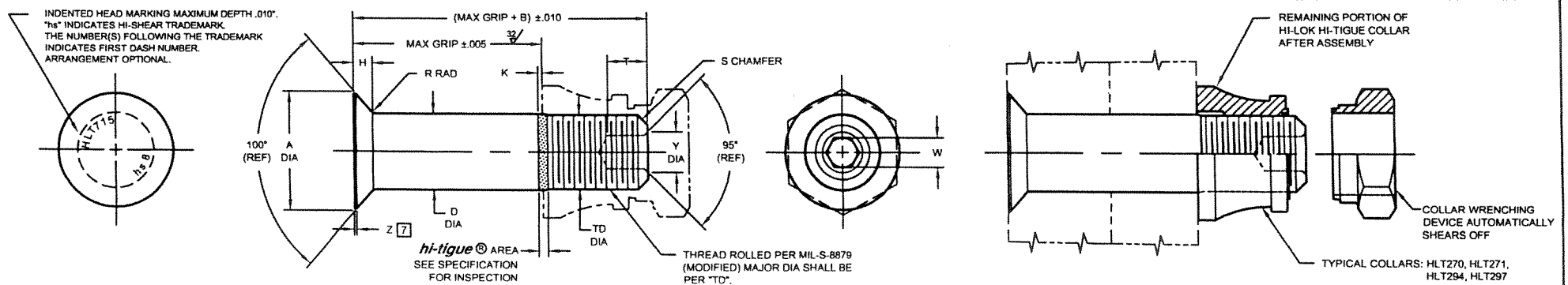


# STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

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. 0LB68
a LISI AEROSPACE Company	a LISI AEROSPACE Company
AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A. & Canada) CAGE No. 06725	HUCK S.A. France (Licensee - ECC Countries)
HUCK 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	7/32	.3308 .3253	.360	.2182 .2177	.2182 .2172	.1840 .1810	.005	.0472 .0449	.016	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	9,400	2,600
8	9/32	.4265 .4210	.435	.2807 .2802	.2807 .2797	.2440 .2410	.006	.0612 .0589	.021	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	15,500	4,400
10	11/32	.5056 .5001	.545	.3432 .3427	.3432 .3422	.3060 .3020	.007	.0681 .0658	.026	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	23,200	7,000
12	13/32	.5921 .5866	.590	.4057 .4052	.4057 .4047	.3680 .3640	.008	.0782 .0759	.030	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	32,400	10,000
14	15/32	.6997 .6932	.690	.4682 .4677	.4682 .4672	.4310 .4260	.009	.0971 .0944	.035	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	43,100	13,500
16	17/32	.7857 .7792	.740	.5307 .5302	.5307 .5297	.4930 .4880	.010	.1070 .1043	.039	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	55,400	18,000
18	19/32	.8692 .8622	.825	.5927 .5922	.5927 .5917	.5550 .5500	.010	.1160 .1130	.039	.050 .040	.022	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	69,200	22,500
20	21/32	.9562 .9492	.890	.6552 .6547	.6552 .6542	.6180 .6120	.010	.1260 .1230	.044	.050 .040	.022	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	84,500	27,000
24	25/32	1.1282 1.1162	1.115	.7802 .7797	.7802 .7792	.7430 .7370	.012	.1460 .1410	.044	.050 .040	.022	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.330 .300	.398 .378	120,000	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.
  - Oversize pin for HLT421 and HLT621. Nickel base alloy per AMS5662.

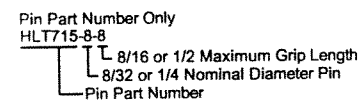
- MATERIAL:** Nickel base alloy per AMS5662.
- HEAT TREAT:** 125,000 psi shear minimum (210,000 psi tensile minimum).
- FINISH:**
- HLT715(-)(-) = Passivate per Hi-Shear Spec. 258, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HLT715AP(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HLT715DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HLT715PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HLT715FB(-)(-) = Grit blast top of head, passivate per Hi-Shear Spec 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HLT715FJ(-)(-) = 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.
  - HLT715SK(-)(-) = 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.

**SPECIFICATION:** Hi-Lok Hi-Tigue Product Specification 342.

**CODE:** First dash number indicates nominal diameter in 1/32nds of the pin which HLT715 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

**HOW TO ORDER EXAMPLE:**

- HLT715SP(-)(-) = 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.
- HLT715TB(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT715FF(-)(-) = 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.



*Hi-Lok*, *HL*, Hi-Tigue, and *HLT* are internationally registered trademark of Hi-Shear Corporation.		
DRAWN	DATE	TITLE
D.P.S.	2-8-85	<b>HI-LOK® HI-TIGUE® PIN</b>
100° FLUSH SHEAR HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16" GRIP VARIATION, 1/32" OVERSIZE		
APPROVED	DATE	DRAWING NUMBER
J.Wilcox	2-11-85	<b>HLT715</b>
REVISION	DATE	
(8)	JO 8-20-02	

HLT715