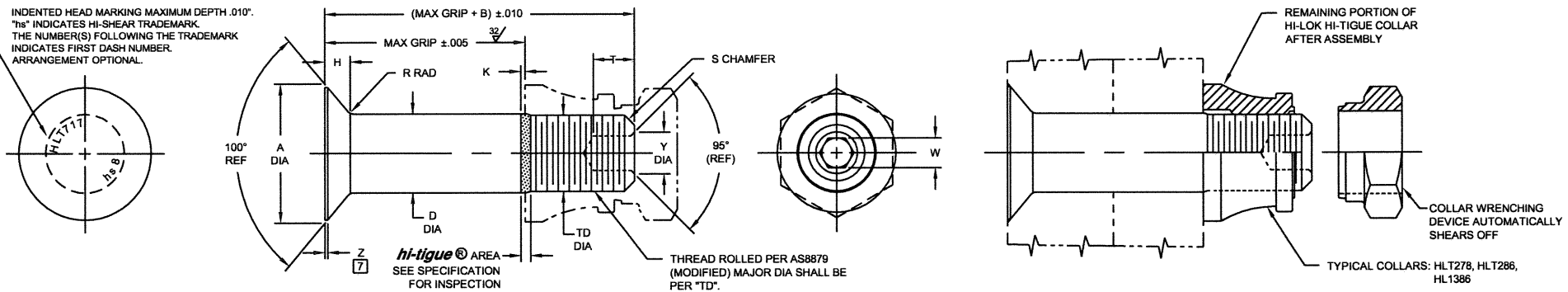


HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197 a LISI AEROSPACE Company	BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE No. 0LB68 a LISI AEROSPACE Company
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HUCK INTERNATIONAL, INC., U.S.A. (Licensee) CAGE No. 97928	BLANC AERO S.A. France (Licensee - ECC Countries)
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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		
5	5/32						NOTE: USE HLT623 (J6-)											
6	7/32	.3813 .3765	.360	.2182 .2177	.2182 .2171	.1840 .1810	.005	.0684 .0644	.016	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	9,400	4,350
8	9/32	.5066 .5018	.435	.2807 .2802	.2807 .2797	.2440 .2410	.006	.0948 .0928	.021	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	15,500	7,750
10	11/32	.6335 .6287	.545	.3432 .3427	.3432 .3422	.3060 .3020	.007	.1218 .1198	.026	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	23,200	12,300
12	13/32	.7604 .7556	.590	.4057 .4052	.4057 .4047	.3680 .3640	.008	.1488 .1468	.030	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	32,400	19,100
14	15/32	.8884 .8812	.690	.4682 .4677	.4682 .4672	.4310 .4260	.009	.1763 .1733	.035	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	43,100	25,800
16	17/32	1.0139 1.0068	.740	.5307 .5302	.5307 .5297	.4930 .4880	.010	.2027 .1997	.039	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	55,400	34,300
18	19/32	1.1408 1.1337	.825	.5927 .5922	.5927 .5917	.5550	.010	.2300 .2270	.039	.050 .040	.025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	69,200	43,500
20	21/32	1.2723 1.2651	.890	.6552 .6547	.6552 .6542	.6180 .6120	.010	.2589 .2559	.044	.050 .040	.025	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	84,500	54,600
24	25/32	1.5308 1.5236	1.115	.7802 .7797	.7802 .7792	.7430 .7370	.012	.3149 .3119	.044	.050 .040	.025	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.330 .300	.398 .378	120,000	79,200

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 HLT423 and HLT623.

MATERIAL: Nickel base alloy per AMS5662.

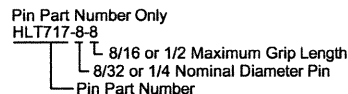
HEAT TREAT: 125,000 psi shear minimum (210,000 psi tensile minimum).

- FINISH:**
- HLT717(-)(-) = Passivate per Hi-Shear Spec. 258, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT717AP(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT717DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT717FB(-)(-) = Grit blast top of head, passivate per Hi-Shear Spec 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT717PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, 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 HLT717 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER EXAMPLE:



- HLT717SD(-)(-) = Grit blast top of head, passivate per Hi-Shear Spec 258, with color yellow on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT717SG(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, with color yellow on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT717TB(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT717GM(-)(-) = Passivate per Hi-Shear Spec. 258. Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 on threads (no overspray on the shank is allowed) and top of head only (.005 max overspray on the head bearing surface permissible) with color white 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	HI-LOK® HI-TIGUE® PIN
APPROVED	DATE	100° FLUSH MS24694 TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16" GRIP VARIATION, 1/32" OVERSIZE
JGW/loax	2-11-85	
REVISION	DATE	DRAWING NUMBER
10	J.F. Obispo 2-22-07	HLT717