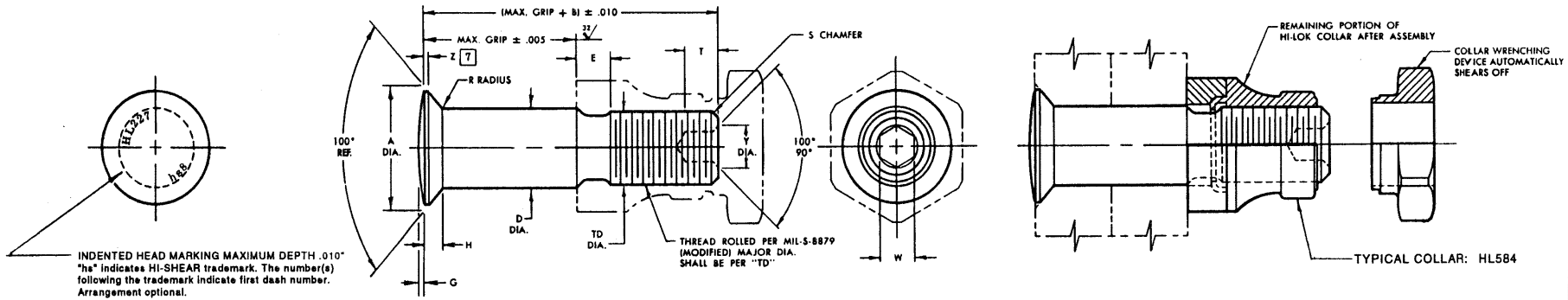


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) --U.S. Federal Code No. 73197
 A Subsidiary of GFI Industries, France.
 AIR INDUSTRIES CO., INC. (Licensee - U.S. & Canada) --U.S. Federal Code No. 08725
 DEUTSCH FASTENER CO., INC. (Licensee) --U.S. Federal Code No. 87828
 SPS TECHNOLOGIES, U.S.A. (Licensee) --U.S. Federal Code No. 88878
 VOI-SHAN, Division of VSI Corp., U.S.A. (Licensee) --U.S. Federal Code No. 92216
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) --U.S. Federal Code No. 80516
 (Pin & Steel Collars)

HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee)
 A Subsidiary of GFI Industries, France.
 KAMAX-WERKE, Germany (Licensee - EEC Countries)
 Rudolph Kellerman GmbH & Co. (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"
 "he" indicates HI-SHEAR trademark. The number(s) following the trademark indicate first dash number. Arrangement optional.

TYPICAL COLLAR: HL584

HI-LOK® PIN

HI-LOK® PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.		TD DIA.	E REF.	F	G	H	R RAD.	Z MAX	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING	WITH COATING										W HEX.	T DEPTH	Y DIA.		
5	5/32	.2612 .2564	.395	.1635 .1630	.1635 .1625	.1595 .1570	.125	.004	.010 .005	.0410 .0390	.025 .015	.010	1/32" x 37°	8-32UNJC-3A Modified	.0645 .0635	.100 .080	.090 .075	4,010	1,290
6	3/16	.3016 .2966	.410	.1895 .1890	.1895 .1885	.1840 .1810	.130	.005	.010 .005	.0470 .0449	.030 .020	.015	1/32" x 37°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	5,380	2,000
8	1/4	.3948 .3898	.495	.2495 .2490	.2495 .2485	.2440 .2410	.140	.006	.012 .007	.0610 .0589	.030 .020	.015	1/32" x 37°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	9,300	3,700
10	5/16	.4739 .4689	.560	.3120 .3115	.3120 .3110	.3060 .3020	.160	.007	.015 .010	.0680 .0660	.040 .030	.015	3/64" x 37°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	14,600	5,000
12	3/8	.5604 .5554	.625	.3745 .3740	.3745 .3735	.3680 .3640	.170	.008	.015 .010	.0780 .0760	.040 .030	.015	3/64" x 37°	3/8-24UNJF-3A Modified	.1817 .1582	.160 .140	.217 .197	21,000	7,200

SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH.

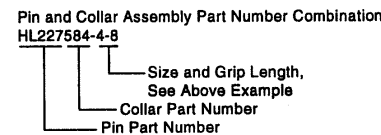
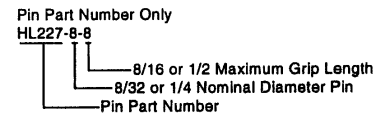
GENERAL NOTES:

- Head edge out of roundness shall not exceed "F".
- Concentricity of conical surface of head to "D" diameter within .005 FIM.
- "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 HL339 for oversize replacement.

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 EXAMPLES:



MATERIAL:

6Al-4V titanium alloy per Spec. AMS4928 or AMS4967.

HEAT TREAT:

95,000 psi shear minimum.

FINISH:

- HL227-()-() = Cetyl alcohol lube per Hi-Shear Spec. 305.
- HL227BJ()-() = IVD aluminum coating per MIL-C-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL227AP()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION:

Hi-Lok Product Specification 342.

*Hi-Lok® and "HL" are internationally registered trademarks of Hi-Shear Corporation.			
DRAWN	DATE	TITLE HI-LOK® PIN 100° FLUSH CROWN SHEAR HEAD TITANIUM 1/16" GRIP VARIATION (MECHANICAL LOCK APPLICATION)	
D.P.S.	11-30-76		
APPROVED	DATE	DRAWING NUMBER HL227	
J.G. Wilcox	12-2-76		
REVISION	DATE		
④	JRH 3-11-97		

HL227