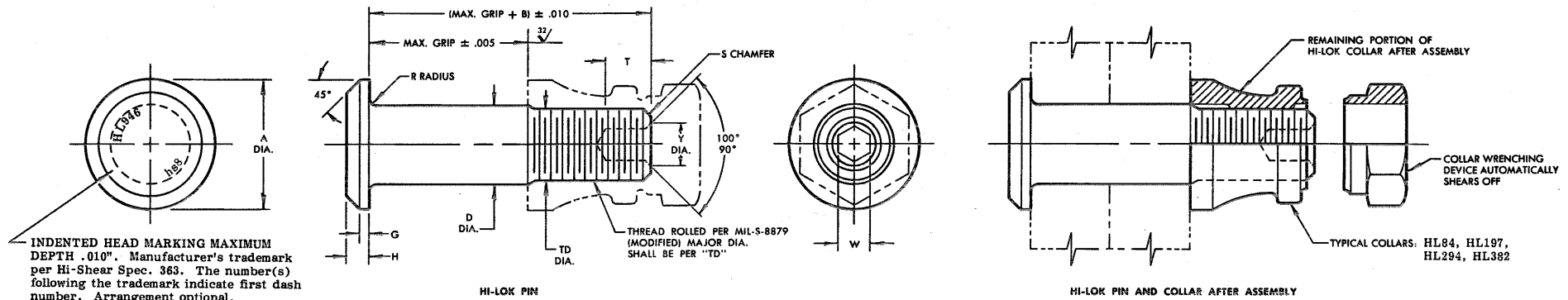


**STANDARDS COMMITTEE  
FOR HI-LOK® PRODUCTS**  
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) U.S. Federal Code I.D. No. 73187  
 Division of HI-Shear Industries Inc., U.S.A.  
 AIRCRAFT FASTENERS (Forged Parts) LTD., U.K. (Licensee)  
 Division of HI-Shear Industries Inc., U.S.A.  
 VOI-SHAN, Division of VSI Corp., U.S.A. (Licensee) U.S. Federal Code I.D. No. 92215  
 SPZ TECHNOLOGIES, U.S.A. (Licensee) U.S. Federal Code I.D. No. 58878  
 ST. CHAMOND-GRAMAT, S.A. France (Licensee—EEC Countries)  
 KAMAX-WERKE, Germany (Licensee—EEC Countries)  
 Rudolph Ketherman GmbH & Co. (Licensee—EEC Countries—Collars)  
 SIMMONDS, S.A. France (Licensee—EEC Countries—Collars)  
 TOKYO SCREW COMPANY, Japan (Licensee—Japan)  
 WEST COAST AEROSPACE INC., U.S.A. (Licensee—Oversize Pine & Steel Collars)  
 U.S. Federal Code I.D. No. 60616



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.

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.		TD DIA.	G REF.	H	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 HL936-6												
-6	7/32	.315 .295	.325	.2182 .2177	.2182 .2172	.1840 .1810	.025 .045	.055 .015	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	9,400	3,000
-8	9/32	.412 .387	.395	.2807 .2802	.2807 .2797	.2440 .2410	.030 .059	.069 .015	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	15,500	5,100
-10	11/32	.505 .475	.500	.3432 .3427	.3432 .3422	.3060 .3020	.035 .068	.078 .020	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	23,200	8,000
-12	13/32	.600 .565	.545	.4057 .4052	.4057 .4047	.3680 .3640	.040 .078	.088 .020	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	32,400	11,300
-14	15/32	.676 .641	.635	.4682 .4677	.4682 .4672	.4310 .4260	.045 .093	.105 .020	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	43,100	15,500
-16	17/32	.770 .735	.685	.5307 .5302	.5307 .5297	.4930 .4880	.050 .103	.115 .020	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	55,400	20,000

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

- GENERAL NOTES: 1. Concentricity: Head to "D" diameter within .010 FIR.  
 2. Dimensions to be met after finish.  
 3. Surface texture per ANSI B46.1.  
 4. Hole preparation per NAS618.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL946 oversize pin replaces.  
 Second dash number indicates maximum grip in 1/16ths. See "Finish" note for explanation of code letters.

MATERIAL: Nickel base alloy per AMS5662.

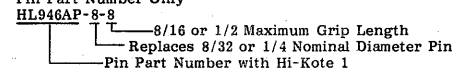
HEAT TREAT: 125,000 psi shear minimum (220,000 psi tension minimum).

- FINISH: HL946-( )-( ) = Passivate per Hi-Shear Spec. 258, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HL946AP-( )-( ) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HL946JT-( )-( ) = Passivate per Hi-Shear Spec. 258, with light blue identification on top of head, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HL946PB-( )-( ) = Cadmium plate per QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

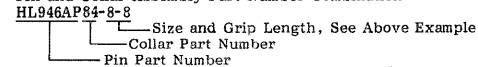
SPECIFICATION: Hi-Lok Product Specification 342.

HOW TO ORDER  
EXAMPLES:

Pin Part Number Only



Pin and Collar Assembly Part Number Combination



Patented internationally. "Hi-Lok" and "HL" are internationally registered trademarks of Hi-Shear Corporation.

DRAWN	DATE	
D. P. S.	2-3-87	
APPROVED	DATE	PROTRUDING SHEAR HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16" GRIP VARIATION-1/32" OVERSIZE
<i>Richard</i>	2-4-87	
REVISION	DATE	DRAWING NUMBER
1	D. P. S. 4-14-87	HL946