

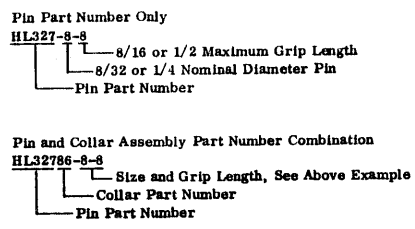
FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.	TD DIA.	F	H	K REF.	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	MIN. GRIP LENGTH
													W HEX.	T DEPTH	Y DIA.			
-5	5/32	.3304 .3256	.312	.1650 .1640	.1595 .1570	.004	.0694 .0674	.013	.025 .015	.010	1/32" x 45°	8-32UNJC-3A Modified	.0801 .0791	.135 .115	.104 .094	4,010	2,180	-2
-6	3/16	.3813 .3765	.325	.1895 .1885	.1840 .1810	.005	.0805 .0785	.016	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	5,380	2,750	-3
-8	1/4	.5066 .5018	.395	.2495 .2485	.2440 .2410	.006	.1080 .1060	.021	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0987 .0947	.110 .090	.142 .122	9,300	5,820	-3
-10	5/16	.6335 .6287	.500	.3120 .3110	.3060 .3020	.007	.1350 .1330	.026	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	14,600	9,200	-3
-12	3/8	.7604 .7556	.545	.3745 .3735	.3680 .3640	.008	.1620 .1600	.030	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	21,000	14,000	-4
-14	7/16	.8884 .8812	.635	.4370 .4360	.4310 .4260	.009	.1895 .1865	.035	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	28,600	18,900	-5
-16	1/2	1.0139 1.0068	.685	.4995 .4985	.4930 .4880	.010	.2160 .2130	.039	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	37,300	25,500	-5
-18	9/16	1.1408 1.1337	.770	.5615 .5605	.5550 .5500	.010	.2430 .2400	.039	.050 .040	.025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	47,200	32,400	-6

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

- GENERAL NOTES:
1. Head edge out of roundness shall not exceed "F."
 2. Concentricity: Conical surface of head to "D" diameter within .005 FIR.
 3. "H" is dimensioned from maximum "D" diameter.
 4. Dimensions to be met after plating.
 5. Surface texture per ANSI B46.1.
 6. Hole preparation per NAS618.
 7. Curved or flat edge manufacturer's option.
 8. Minimum required for head and Hi-Tigue feature.
 9. Standard Hi-Lok pins available in shorter grips.
 9. Use HLT427 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: Alloy steel per Spec. MIL-S-5000, MIL-S-5626; or MIL-S-6049.
HEAT TREAT: 160,000-180,000 psi tensile per Spec. MIL-H-6875.
FINISH: HL327-()-() = Cadmium plate per Spec. QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
① HL327HC-()-() = Cadmium plate per Spec. QQ-P-416, Type II, Class 2, and apply precoat No. PRI436G sealant (.002-.005 thick) plus cetyl alcohol lube per Hi-Shear Spec. 305.
HL327TB-()-() = Cadmium plate per QQ-P-416, Type II, Class 2; Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
SPECIFICATION: Hi-Lok Hi-Tigue Product Specification 342.

U.S. patents 3,138,987; 3,390,906; 3,578,367, and foreign patents. "Hi-Lok," "HL," "Hi-Tigue," and "HLT" are Registered Trademarks of Hi-Shear Corporation.

DRAWN JAN	DATE 2-5-68	<p>hi-lok® hi-tigue® PIN</p> <p>100° FLUSH MS24694 TENSION HEAD ALLOY STEEL</p> <p>1/16" GRIP VARIATION INTERFERENCE APPLICATION</p>
APPROVED J. MILLER	DATE 2-6-68	
REVISION (12)	DATE D. P. S. 7-22-81	DRAWING NUMBER HL327