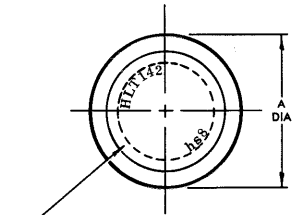
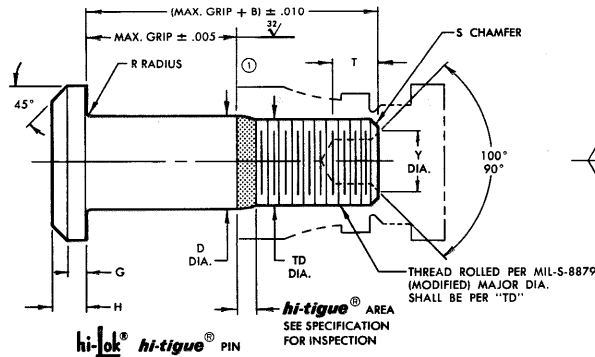


**STANDARDS COMMITTEE FOR
HI-LOK® HI-TIGUE® PRODUCTS**
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

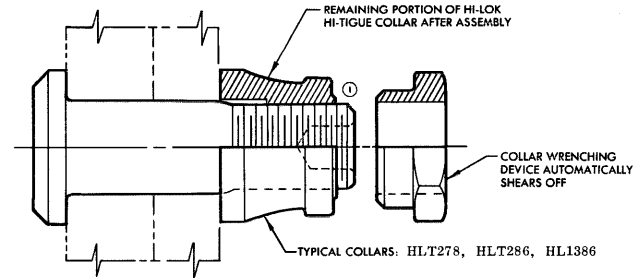
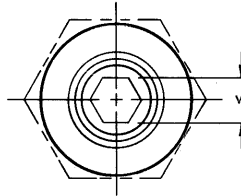
① HI-SHEAR CORPORATION, U.S.A. (Patent Holder) U.S. Federal Code I.D. No. 73197
 Division of Hi-Shear Industries Inc., U.S.A.
 AIRCRAFT FASTENERS (Forged Parts) LTD., U.K. (Licensee)
 Division of Hi-Shear Industries Inc., U.S.A.
 VSI-SHAR, Division of VSI Corp., U.S.A. (Licensee) U.S. Federal Code I.D. No. 92215
 SPS TECHNOLOGIES, U.S.A. (Licensee) U.S. Federal Code I.D. No. 56878
 ST. CHAMOND-GRANAT, S.A. France (Licensee—EEC Countries)
 KANAX-WERKE, Germany (Licensee—EEC Countries)
 Rudolph Kellerman GmbH & Co.
 SHIMMONDS, S.A. France (Licensee—EEC Countries—Collars)
 TOKYO SCREW COMPANY, Japan (Licensee—Japan)
 WEST COAST AEROSPACE INC., U.S.A. (Licensee—Oversize Pins & Steel Collars)
 U.S. Federal Code I.D. No. 60516



① 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.



hi-lok® hi-tigue® PIN



hi-lok® hi-tigue® PIN AND COLLAR AFTER ASSEMBLY

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 HI-KOTE™ LUBE	WITH HI-KOTE™ LUBE							W HEX.	T DEPTH	Y DIA.		
-5				NOTE: Use HLT42-6												
-6	13/64	.377 .357	.360	.2026 .2021	.2026 .2016	.1840 .1810	.035	.074 .064	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	6,130	2,750
-8	17/64	.440 .415	.435	.2651 .2646	.2651 .2641	.2440 .2410	.045	.090 .080	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	10,490	5,820
-10	21/64	.505 .475	.545	.3276 .3271	.3276 .3266	.3060 .3020	.055	.112 .102	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	16,000	9,200
-12	25/64	.600 .565	.590	.3901 .3896	.3901 .3891	.3680 .3640	.075	.140 .130	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	22,700	14,000
-14	29/64	.676 .641	.690	.4526 .4521	.4526 .4516	.4310 .4260	.095	.160 .150	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	30,600	18,900
-16	33/64	.770 .735	.740	.5151 .5146	.5151 .5141	.4930 .4880	.095	.188 .178	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	39,600	25,500
-18	37/64	.877 .842	.825	.5771 .5766	.5771 .5761	.5550 .5500	.125	.210 .200	.040 .025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	49,700	32,400

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

- ① GENERAL NOTES:
1. Concentricity: "A" to "D" diameter within .010 FIR.
 2. Surface texture per ANSI B46.1.
 3. Hole preparation per NAS61S.
 4. Use HLT242 for oversize replacement.

① MATERIAL: A-286 high temperature alloy per AMS5731 or AMS5737.

HEAT TREAT: 95,000 psi shear minimum at 70°F.

① FINISH: HLT142-()-() = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT142TB-()-() = Hi-Kote 2 solid film lube and cetyl alcohol lube per Hi-Shear Spec. 305.

① SPECIFICATION: Hi-Lok Hi-Tigue Product Specification 342 and 342-2.

① CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HLT142 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See "Finish" note for explanation of code letters.

HOW TO ORDER EXAMPLES:

Pin Part Number Only
 HLT142-8-8
 — 8/16 or 1/2 Maximum Grip Length
 — Replaces 8/32 or 1/4 Nominal Diameter Pin
 Pin Part Number

Pin and Collar Assembly Part Number Combination
 HLT142286-8-8
 — Size and Grip Length, See Above Example
 — Collar Part Number
 Pin Part Number

U.S. Patent 3,578,367 and international patents. "HL", "HI-Lok", "HLT", and "HI-TIGUE" are internationally registered trademarks of Hi-Shear Corporation.	
DRAWN DATE VAN 6-12-72	DATE 6-12-72
APPROVED DATE J. B. Willett 6-16-72	DATE 6-16-72
REVISION DATE ① 10-28-86	DATE 10-28-86
PROTRUDING TENSION HEAD A-286 HIGH TEMPERATURE ALLOY 1/16" GRIP VARIATION - 1/64" OVERSIZE	
DRAWING NUMBER HLT142	