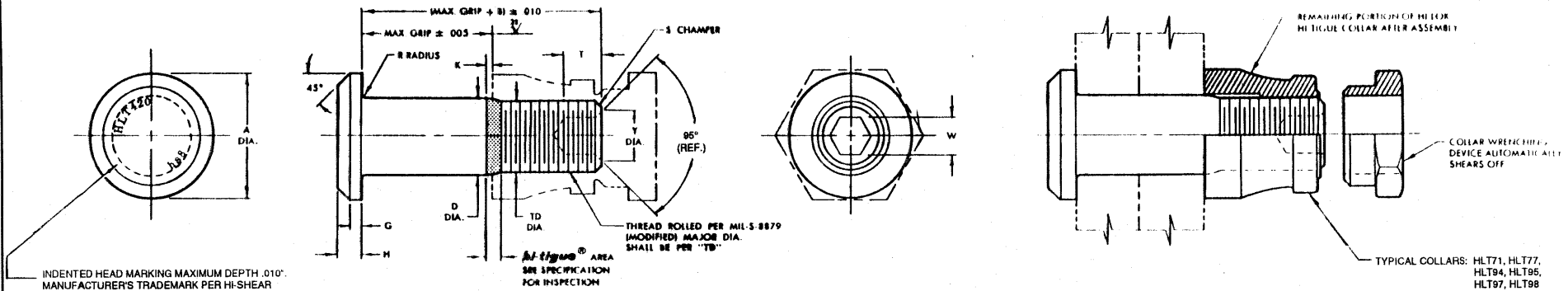


STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
 A Subsidiary of GFI Industries, France
 AIR INDUSTRIES CO., INC. (Licensee - U.S. & Canada) CAGE No. 06725
 HUCK INTERNATIONAL, INC., Deutsch Operation, U.S.A. (Licensee) CAGE No. 97928
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 58878
 FAIRCHILD Aerospace Fastener Division, U.S.A. (Licensee) CAGE No. 92215
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516
 (Pins & Steel Collars)

HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee) CAGE No. 0LB68
 A Subsidiary of GFI Industries, France
 HUCK INTERNATIONAL GmbH & Co. Germany (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)



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	K REF.	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	5/32	.262 .242	.312	.1635 .1630	.1635 .1570	.1595 .1570	.020	.047 .037	.013	.025 .015	1/32" x 45°	8-32UNJC-3A Modified	.0801 .0791	.100 .080	[5]	5,280	2,200
6	3/16	.315 .295	.325	.1895 .1890	.1895 .1810	.1840 .1810	.025	.055 .045	.016	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	7,060	3,000
8	1/4	.412 .387	.395	.2495 .2490	.2495 .2410	.2440 .2410	.030	.069 .059	.021	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	12,260	5,100
10	5/16	.505 .475	.500	.3120 .3115	.3120 .3100	.3060 .3020	.035	.078 .068	.026	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	19,160	8,000
12	3/8	.600 .565	.545	.3745 .3740	.3745 .3640	.3680 .3640	.040	.088 .078	.030	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	27,600	11,300
14	7/16	.676 .641	.635	.4370 .4365	.4370 .4260	.4310 .4260	.045	.105 .093	.035	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	37,500	15,500
16	1/2	.770 .735	.685	.4995 .4990	.4995 .4880	.4930 .4880	.050	.115 .103	.039	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	49,100	20,000
18	9/16	.864 .829	.770	.5615 .5610	.5615 .5500	.5550 .5500	.055	.127 .112	.039	.040 .025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	62,100	25,000
20	5/8	.953 .918	.825	.6240 .6235	.6240 .6120	.6180 .6120	.060	.137 .122	.044	.040 .025	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	76,700	30,200
24	3/4	1.108 1.066	1.050	.7490 .7485	.7490 .7370	.7430 .7370	.070	.151 .136	.044	.045 .030	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.330 .300	.398 .378	110,400	40,200

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

GENERAL NOTES:

1. Concentricity: "A" to "D" diameter within .010 FIM.
2. Dimensions to be met after finish.
3. Surface texture per ANSI B46. 1.
4. Hole preparation per NAS618.
5. Evidence of broken edge across points.
6. Use HLT620 for oversize replacement.

MATERIAL:
HEAT TREAT:
FINISH:

Nickel base alloy per AMS5662.
 125,000 psi shear minimum (210,000 psi tensile minimum).

- ① HLT420-()-() = Passivate per Hi-Shear Spec. 258, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT420AP()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT420DL()-() = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT420FB()-() = Grit blast top of heads, passivate per Hi-Shear Spec. 258, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT420PB()-() = Cadmium plate per QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT420PZ()-() = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT420SJ()-() = Grit blast top of head, passivate per Hi-Shear Spec. 258, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT420SN()-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

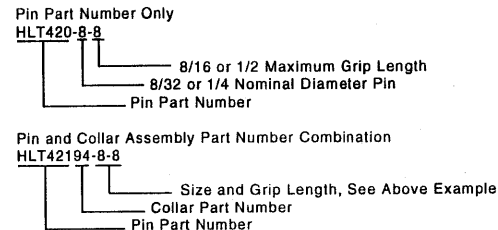
SPECIFICATION:

Hi-Lok Hi-Tigue Product Specification 342.

CODE:

First dash number indicates nominal diameter in 1/32nds.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

HOW TO ORDER EXAMPLE:



HLT420TB()-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.

DRAWN DATE		TITLE HI-LOK® HI-TIGUE® PIN PROTRUDING SHEAR HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16" GRIP VARIATION
D.P.S.	4-22-83	
APPROVED DATE		DRAWING NUMBER HLT420
R.Ting	4-22-83	
REVISION	DATE	
①	J.Henderson 6-22-98	

HLT420