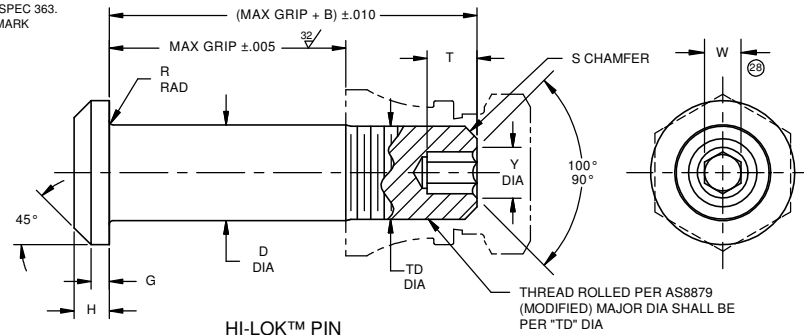
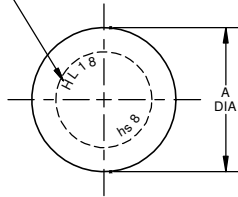




hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

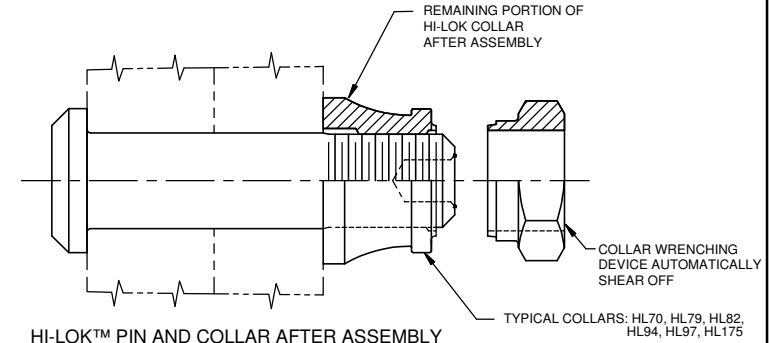
Hi-Shear Corporation, U.S.A. a LISI AEROSPACE Company	Design Holder	CAGE No. 73197	SPS TECHNOLOGIES, UK SPS TECHNOLOGIES, UK	Licensee	CAGE No. K5673
BLANC AERO INDUSTRIES UK Ltd a LISI AEROSPACE Company	Licensee	CAGE No. U6300	MINEBEA, Japan AFSR City of Industry, USA	Licensee (Japan) Licensee	CAGE No. 56878 CAGE No. SB962 CAGE No. 1RC86 CAGE No. 06950 CAGE No. 60516
BLANC AERO INDUSTRIES SA, France a LISI AEROSPACE Company	Licensee	CAGE No. F0188-C	WEST COAST AEROSPACE, USA	Licensee	(oversize: WW except Japan nominal: USA & Canada Licensee (USA, Canada))
LISI AEROSPACE CANADA, Canada a LISI AEROSPACE Company	Licensee	CAGE No. L4528	Air Industries CO., USA FTB Fastener Technology Bestas, Turkey	Licensee	CAGE No. 06725 CAGE No. T0802
BLANC AERO TECHNOLOGIES SA, France a LISI AEROSPACE Company	Licensee	CAGE No. FA1X3	AFSR Hildesheim, Germany AFSR Carson, USA	Licensee Licensee	CAGE No. C4293 CAGE No. 17446
ANKIT FASTENERS Ltd, India	Licensee (Steel WW, Titanium - India)	CAGE No. SEM10			

INDENTED HEAD MARKING MAXIMUM DEPTH .010".
MANUFACTURER'S TRADEMARK "hs" PER SPEC 363.
THE NUMBER(S) FOLLOWING THE TRADEMARK
INDICATES FIRST DASH NUMBER.
ARRANGEMENT OPTIONAL.



HI-LOK™ PIN

THREAD ROLLED PER AS8879
(MODIFIED) MAJOR DIA SHALL BE
PER "TD" DIA



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
											W HEX	T DEPTH	Y DIA		
5	5/32	.262 .242	.312	.1635 .1625	.1595 .1570	.020	.047 .037	.025 .015	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.135 .115	[6]	4,010	1,940
6	3/16	.315 .295	.325	.1895 .1885	.1840 .1810	.025	.055 .045	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	5,380	2,500
8	1/4	.412 .387	.395	.2495 .2485	.2440 .2410	.030	.069 .059	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	9,300	4,300
10	5/16	.505 .475	.500	.3120 .3110	.3060 .3020	.035	.078 .068	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	14,600	6,300
12	3/8	.600 .565	.545	.3745 .3735	.3680 .3640	.040	.088 .078	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	21,000	8,700
14	7/16	.676 .641	.635	.4370 .4360	.4310 .4260	.045	.105 .093	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	28,600	12,100
16	1/2	.770 .735	.685	.4995 .4985	.4930 .4880	.050	.115 .103	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	37,300	15,300
18	9/16	.864 .829	.770	.5615 .5605	.5550 .5500	.055	.127 .112	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	47,200	19,000
20	5/8	.953 .918	.825	.6240 .6230	.6180 .6120	.060	.137 .122	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	58,300	23,000
24	3/4	1.108 1.066	1.050	.7490 .7480	.7430 .7370	.070	.151 .136	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	83,900	30,700
28	7/8	1.285 1.241	1.210	.8740 .8730	.8680 .8610	.090	.187 .172	.050 .035	5/64 x 45°	.8750-14 UNJF-3A	.3820 .3780	.455 .425	.471 .451	114,000	45,000
32	1	1.468 1.424	1.390	.9990 .9980	.9930 .9860	.110	.218 .203	.060 .045	5/64 x 45°	1.0000-12 UNJF-3A	.5100 .5040	.580 .550	.618 .598	149,000	60,900

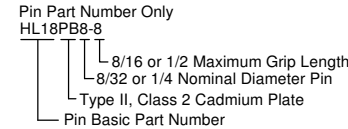
GENERAL NOTES:

- Concentricity: "A" to "D" diameter within .010 FIM.
- Dimensions to be met after finish.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- Non-lubed pins must be used with lubed collars.
- Evidence of broken edge across points.
- Use HL62 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 EXAMPLE:



MATERIAL:

Alloy steel per AMS6415, AMS6349 or AMS6382, AMS6322.

HEAT TREAT:

95,000 psi shear (160,000-180,000 psi tensile per AMS-H-6875).

FINISH:

- HL18(-)(-) = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per alcohol per Hi-Shear Spec. 305.
- HL18PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per alcohol per Hi-Shear Spec. 305.
- HL18TF(-)(-) = Cadmium plate per AMS-QQ-P-416, Type III, Class 2, and HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
- [5] HL18PN(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.

SPECIFICATION:

HI-LOK™ Product Specification 342.

"HI-LOK", "HL", and "HI-KOTE", are Trademarks of Hi-Shear Corporation.	
DRAWN BY J.C.S.	DATE 7-19-62
APPROVED Cessna	DATE 7-24-62
REVISION (28)	DATE F.C. 2-25-16
TITLE HI-LOK™ PIN PROTRUDING SHEAR HEAD ALLOY STEEL 1/16 GRIP VARIATION	
DRAWING NUMBER HL18	