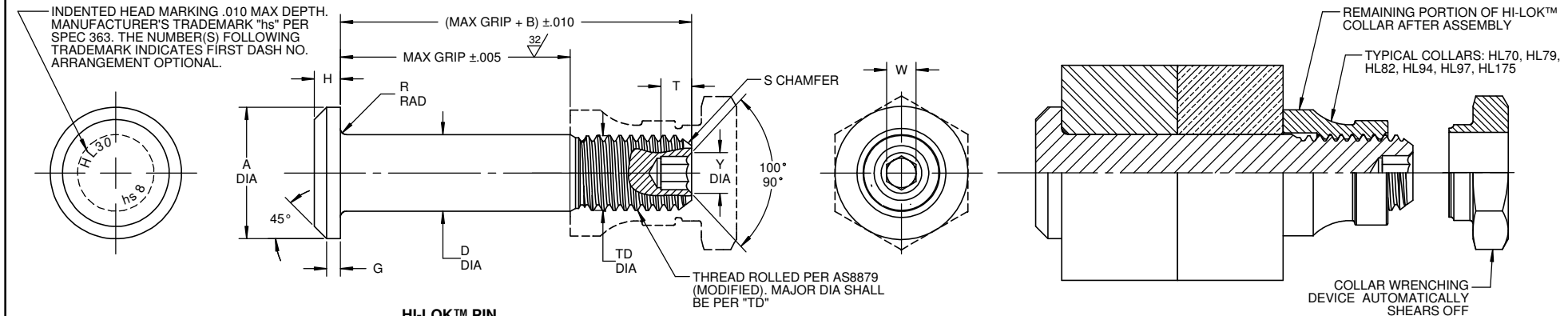


Hi-Shear Corporation, U.S.A. a LI-SI AEROSPACE Company	Design Holder	CAGE No. 73197	SPS TECHNOLOGIES, UK SPS TECHNOLOGIES, USA	Licensee	CAGE No. K5673 CAGE No. 56878
BLANC AERO INDUSTRIES UK Ltd a LI-SI AEROSPACE Company	Licensee	CAGE No. U6300	MINEBEA, Japan AFSR City of Industry, USA	Licensee (Japan) Licensee	CAGE No. SB962 CAGE No. 1RC86
BLANC AERO INDUSTRIES SA, France a LI-SI AEROSPACE Company	Licensee	CAGE No. F0188-C	WEST COAST AEROSPACE, USA	Licensee	CAGE No. 06990 CAGE No. 60516
LI-SI AEROSPACE CANADA, Canada a LI-SI AEROSPACE Company	Licensee	CAGE No. L4528	Air Industries CO., USA FTB Fastener Technology Bestas, Turkey	Licensee (oversize: WW except Japan normal: USA & Canada Licensee (USA, Canada))	CAGE No. 06725 CAGE No. T0802
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ANKIT FASTENERS Ltd, India	Licensee (Steel WW; Titanium - India)	CAGE No. SEM10			



HI-LOK™ PIN

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
				WITHOUT COATING OR SOLID FILM	AFTER COATING OR SOLID FILM							W HEX	T DEPTH	Y DIA		
5	5/32	.262 .242	.312	.1635 .1630	.1635 .1625	.1595 .1570	.020	.047 .037	.025 .015	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.135 .115	[6]	5,280	2,000
6	3/16	.315 .295	.325	.1895 .1890	.1895 .1885	.1840 .1810	.025	.055 .045	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	7,060	3,000
8	1/4	.412 .387	.395	.2495 .2490	.2495 .2485	.2440 .2410	.030	.069 .059	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.160 .130	.142 .122	12,260	5,100
10	5/16	.505 .475	.500	.3120 .3115	.3120 .3110	.3060 .3020	.035	.078 .068	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	19,160	8,000
12	3/8	.600 .565	.545	.3745 .3740	.3745 .3735	.3680 .3640	.040	.088 .078	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.220 .180	.217 .197	27,600	11,300
14	7/16	.676 .641	.635	.4370 .4365	.4370 .4360	.4310 .4260	.045	.105 .093	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	37,500	15,500
16	1/2	.770 .735	.685	.4995 .4990	.4995 .4985	.4930 .4880	.050	.115 .103	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	49,100	20,000
18	9/16	.864 .829	.770	.5615 .5610	.5615 .5605	.5550 .5500	.055	.127 .112	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	62,100	25,000
20	5/8	.953 .918	.825	.6240 .6235	.6240 .6230	.6180 .6120	.060	.137 .122	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	76,700	30,200

HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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. Use HL66 for oversize replacement.

[6] Evidence of broken edge across points.

[7] After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

MATERIAL: Type 431 stainless steel per AMS5628 and MIL-S-18732.

HEAT TREAT: 125,000 psi shear minimum.

- ② **FINISH:** HL30(-)(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
[7] HL30AP(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL30BJ(-)(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL30D(-)(-) = Solid film lube per Spec. AS5272, Type I.
HL30K(-)(-) = Solid film lube per Spec. "Lubeco" 905.
HL30UR(-)(-) = Passivate per Hi-Shear Spec. 258, red identification on top of heads, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LOK™ Product Specification 342.

SPECIFICATION: HI-LOK™ 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:

Pin Part Number
HL30-8-8

8/16 or 1/2 Maximum Grip Length
8/32 or 1/4 Nominal Diameter Pin
Pin Basic Part Number

"HI-LOK", "HL", and "HI-KOTE",
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DRAWN BY Gardiner	DATE 12-22-60	TITLE HI-LOK™ PIN
APPROVED Cessna	DATE 12-23-60	PROTRUDING SHEAR HEAD TYPE 431 STAINLESS STEEL 1/16 GRIP VARIATION
REVISION (21)	DATE FC 4-4-16	DRAWING NUMBER HL30