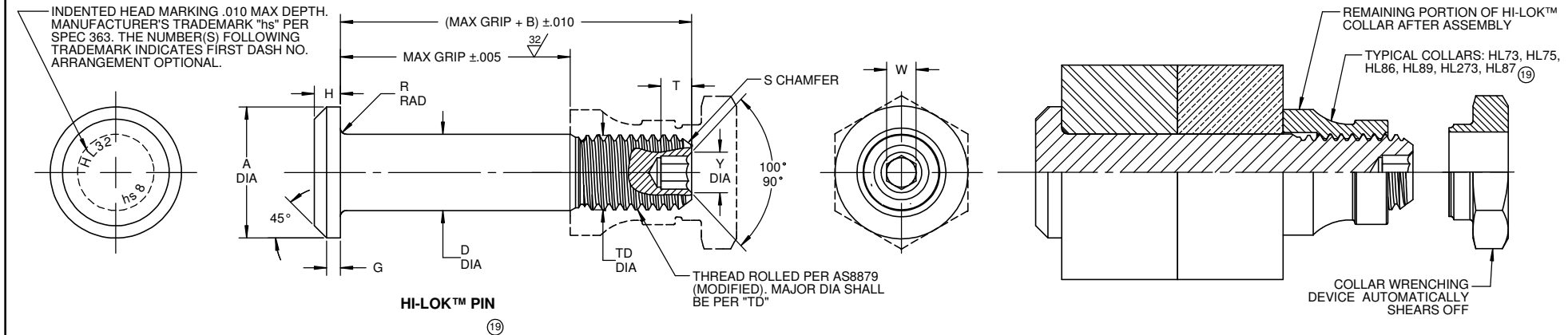




hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

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	MINIBEA, Japan AFSR City of Industry, USA	Licensee (Japan) Licensee	CAGE No. SB962 CAGE No. 1RC86
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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 nominal: USA & Canada) Licensee	CAGE No. 06725 CAGE No. T0802
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ANKIT FASTENERS Ltd, India	Licensee (Steel WW; Titanium - India)	CAGE No. SEM10	AFSR Carson, USA	Licensee	



HI-LOK™ PIN

(19)

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	.322 .306	.312	.1635 .1630	.1635 .1625	.1595 .1570	.030	.060 .055	.025 .015	1/32 x 45°	.1640-32 UNJC-3A	.0645 .0635	.135 .115	.090 .075	5,280	2,940
6	3/16	.377 .357	.325	.1895 .1890	.1895 .1885	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	7,060	4,350
8	1/4	.440 .415	.395	.2495 .2490	.2495 .2485	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	12,260	7,750
10	5/16	.505 .475	.500	.3120 .3115	.3120 .3110	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	19,160	12,300
12	3/8	.600 .530	.545	.3745 .3740	.3745 .3735	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	27,600	19,100
14	7/16	.676 .592	.635	.4370 .4365	.4370 .4360	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	37,500	25,800
16	1/2	.770 .717	.685	.4995 .4990	.4995 .4985	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	49,100	34,300

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- 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. Non-lube pins must be used with wet sealant or with lubed collars.
 6. Use HL36 for oversize replacement.
 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.

- (19) **FINISH:** HL32(-)(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
 [7] HL32AP(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL32D(-)(-) = Solid film lube per Spec. AS5272, Type I.
 HL32PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 [5] HL32PN(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.

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
 HL32AP8-8
 └─ 8/16 or 1/2 Maximum Grip Length
 └─ 8/32 or 1/4 Nominal Diameter Pin
 └─ HI-KOTE™ 1 Aluminum Coating
 └─ Pin Basic Part Number

SPECIFICATION: HI-LOK™ Product Specification 342.

"HI-LOK", "HL", and "HI-KOTE", are Trademarks of Hi-Shear Corporation		
DRAWN BY SCHAD	DATE 4-26-57	TITLE HI-LOK™ PIN PROTRUDING TENSION HEAD 431 STAINLESS STEEL 1/16 GRIP VARIATION
APPROVED Cessna	DATE 4-26-87	
REVISION (19)	DATE FC 4-4-16	DRAWING NUMBER HL32