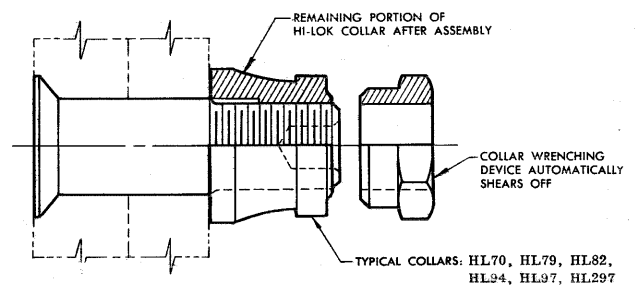
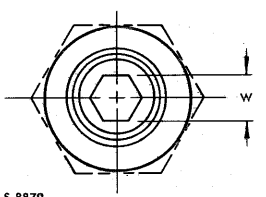
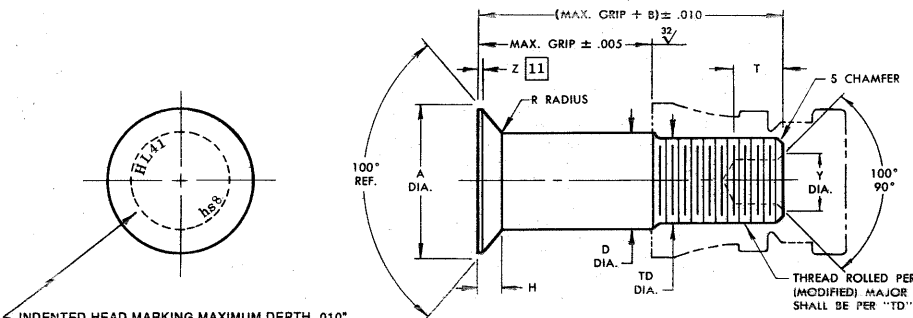


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

2600 Skypark Drive, Torrance, California U.S.A. 90509

HI-SHEAR CORPORATION, U.S.A. (Patent Holder)	CAGE No. 73197	HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee)	CAGE No. 0LB68
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(Fits & Steel Collars)



HI-LOK® PIN

HI-LOK® PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA. [8]		TD DIA.	F	H REF.	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT SOLID FILM LUBE	WITH SOLID FILM LUBE								W HEX.	T DEPTH	Y DIA.		
4	1/8	.2219 .2171	.294	.1375 .1370	.1375 .1365	.1335 .1310	.003	.0354 .0334	.020 .010	.010	1/32" x 45°	6-32UNJC-3A Modified	.0645 .0635	.100 .085	[10]	2,840	950
5	5/32	.2612 .2564	.312	.1635 .1630	.1635 .1625	.1595 .1570	.004	.0410 .0390	.025 .015	.010	1/32" x 45°	8-32UNJC-3A Modified	.0801 .0791	.135 .115	[10]	4,010	1,750
6	3/16	.3016 .2966	.325	.1895 .1890	.1895 .1885	.1840 .1810	.005	.0470 .0449	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	5,380	2,000
8	1/4	.3948 .3898	.395	.2495 .2490	.2495 .2485	.2440 .2410	.006	.0610 .0589	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	9,300	3,700
10	5/16	.4739 .4689	.500	.3120 .3115	.3120 .3110	.3060 .3020	.007	.0679 .0758	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	14,600	5,500
12	3/8	.5604 .5554	.545	.3745 .3740	.3745 .3735	.3680 .3640	.008	.0780 .0759	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	21,000	7,200
14	7/16	.6680 .6620	.635	.4370 .4365	.4370 .4360	.4310 .4260	.009	.0969 .0944	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	28,600	10,000
16	1/2	.7540 .7480	.685	.4995 .4990	.4995 .4985	.4930 .4880	.010	.1068 .1043	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	37,300	13,500
18	9/16	.8380 .8310	.770	.5615 .5610	.5615 .5605	.5550 .5500	.010	.1160 .1131	.050 .040	.025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.290 .270	.326 .306	47,200	17,000
20	5/8	.9250 .9180	.825	.6240 .6235	.6240 .6230	.6180 .6120	.010	.1260 .1230	.050 .040	.025	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.330 .305	.326 .306	58,300	21,000
24	3/4	1.0970 1.0850	1.050	.7490 .7485	.7490 .7480	.7430 .7370	.012	.1460 .1410	.050 .040	.025	1/16" x 45°	3/4-UNJF-3A Modified	.3185 .3150	.395 .365	.398 .378	83,900	30,700

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

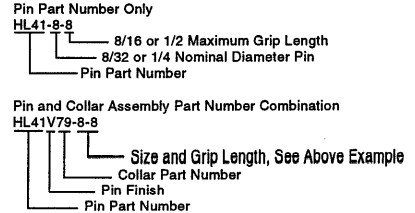
GENERAL NOTES:

- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .005 FIR.
 - "H" dimensioned from maximum "D" diameter.
 - Dimensions to be met after finish.
 - Non-lubed pins must be used with lubed collars.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - Maximum "D" diameter may be increased by .0002 to allow for solid film application.
 - Use HL141 for oversize replacement.
 - Evidence of broken edge across points.
 - Curved or flat edge manufacturer's option.
 - Broach petals removed.
- A-286 high temperature alloy per Spec. AMS5737 or AMS5731.
95,000 psi shear minimum at 70°F.
- HL41(-)(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
HL41DL(-)(-) = Kalgard FA or EM620C solid film lube per MIL-L-46010, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL41DU(-)(-) = Solid film lube per MIL-L-46010, Type I.
HL41GU(-)(-) = Silver plate per AMS2410.
HL41K(-)(-) = Solid film lubricant per Lubeco 905.
HL41PY(-)(-) = Passivate per Hi-Shear Spec. 258.
HL41TF(-)(-) = Hi-Kote 2 solid film per Hi-Shear Spec. 292.
HL41V(-)(-) = Solid film lubricant per Lubeco 2123, Type II.
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 EXAMPLES:



"Hi-Lok" and "HL" are internationally registered trademarks of Hi-Shear Corporation.		
DRAWN	DATE	TITLE
C.E.K.	10-17-62	HI-LOK® PIN 100° FLUSH SHEAR HEAD A-286 HIGH TEMPERATURE ALLOY 1/16" GRIP VARIATION
APPROVED	DATE	
M.E.C.	10-17-62	
REVISION	DATE	DRAWING NUMBER
(25)	J.F.Obispo 7-03-96	HL41

HL41