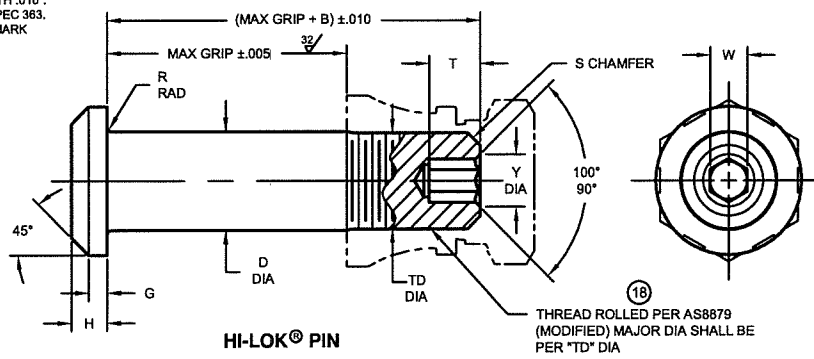
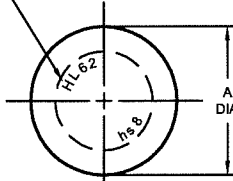




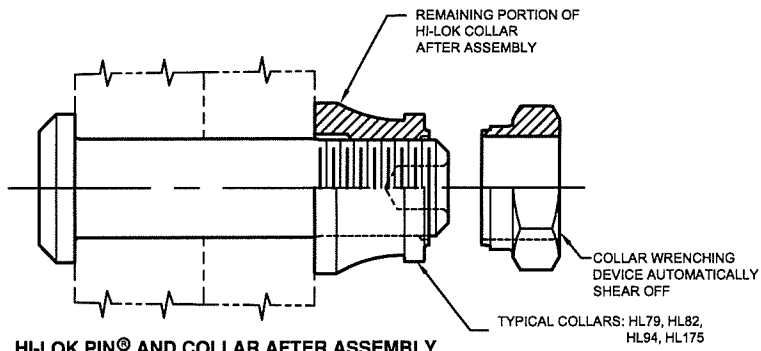
HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197	BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE No. OLB88
a LISI AEROSPACE Company	a LISI AEROSPACE Company
AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A. & Canada) CAGE No. 06725	HUCK S.A. France (Licensee - ECC Countries)
HUCK INTERNATIONAL, INC., U.S.A. (Licensee) CAGE No. 97928	BLANC AERO S.A. France (Licensee - ECC Countries)
SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878	a LISI AEROSPACE Company
FAIRCHILD Aerospace Fastener Division (Licensee) CAGE No. 92215	TOKYO SCREW COMPANY, Japan (Licensee - Japan)
WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516	
(Pins & Steel Collars)	

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

18  
THREAD ROLLED PER AS8879 (MODIFIED) MAJOR DIA SHALL BE PER "TD" DIA



HI-LOK PIN® AND COLLAR AFTER ASSEMBLY

REMAINING PORTION OF HI-LOK COLLAR AFTER ASSEMBLY  
COLLAR WRENCHING DEVICE AUTOMATICALLY SHEAR OFF  
TYPICAL COLLARS: HL79, HL82, HL94, HL175

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
											W HEX	T DEPTH	Y DIA		
5															
NOTE: USE HL18-6-( ) or HL418-6-( )															
6	13/64	.315 .295	.325	.2026 .2016	.1840 .1810	.025	.055 .045	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	6,130	2,500
8	17/64	.412 .387	.395	.2651 .2641	.2440 .2410	.030	.069 .059	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	10,490	4,300
10	21/64	.505 .475	.500	.3276 .3266	.3060 .3020	.035	.078 .068	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	16,000	6,300
12	25/64	.600 .565	.545	.3901 .3891	.3680 .3640	.040	.088 .078	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	22,700	8,700
14	29/64	.676 .641	.635	.4526 .4516	.4310 .4260	.045	.105 .093	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	30,600	12,100
16	33/64	.770 .735	.685	.5151 .5141	.4930 .4880	.050	.115 .103	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	39,600	15,300
18	37/64	.864 .829	.770	.5771 .5761	.5550	.055	.127 .112	.040 .025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.290 .270	.326 .306	49,700	19,000
20	41/64	.953 .918	.825	.6396 .6386	.6180 .6120	.060	.137 .122	.040 .025	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.330 .305	.326 .306	61,000	23,000
24	49/64	1.108 1.066	1.050	.7646 .7636	.7430 .7370	.070	.151 .136	.045 .030	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.395 .365	.398 .378	87,200	30,700
28	57/64	1.285 1.241	1.210	.8896 .8886	.8680 .8610	.090	.187 .172	.050 .035	5/64" x 45°	7/8-14UNJF-3A Modified	.3820 .3780	.455 .425	.471 .451	118,000	45,000
32	1-1/64	1.468 1.424	1.390	1.0146 1.0136	.9930 .9860	.110	.218 .203	.060 .045	5/64" x 45°	1-12UNJF-3A Modified	.5100 .5040	.580 .550	.618 .598	154,000	60,900

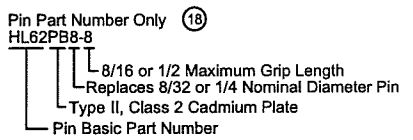
SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH.

- 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 HL218 for oversize replacement.

**CODE:** First dash number indicates nominal diameter in 1/32nds which HL62 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

- 18 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).
- 18 FINISH:**
- HL62-( )-( ) = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL62A-( )-( ) = Cadmium plate per AMS2400-3, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL62PB( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL62TF( )-( ) = Cadmium plate per AMS-QQ-P-416, Type III, Class 2, and Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.
- SPECIFICATION:** Hi-Lok Product Specification 342.

**HOW TO ORDER EXAMPLE:**



DRAWN DATE		TITLE	
Brfej	5-2-63	HI-LOK® PIN PROTRUDING SHEAR HEAD ALLOY STEEL 1/16 GRIP VARIATION, 1/64 OVERSIZE	
APPROVED DATE		DRAWING NUMBER	
Cessna	11-1-63	18 HL62	
REVISION DATE		DRAWING NUMBER	
18	J.F.O. 6-13-13	HL62	

HL62