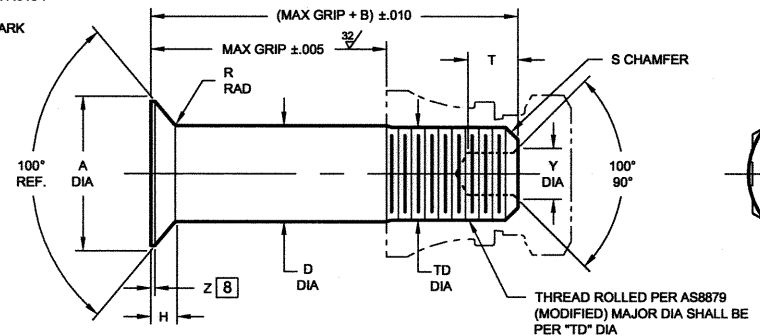
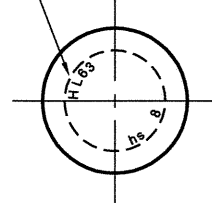


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

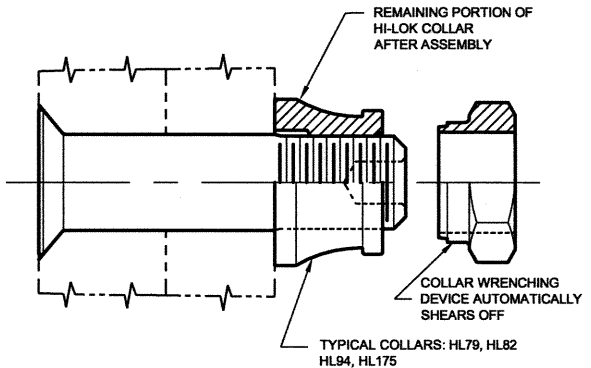
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

19	HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197	BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE No. OLB68
	a LI SI AEROSPACE Company	a LI SI 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 LI SI 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	

INDENTED HEAD MARKING MAXIMUM DEPTH .010".
"hs" INDICATES HI-SHEAR TRADEMARK.
THE NUMBER(S) FOLLOWING THE TRADEMARK
INDICATES FIRST DASH NUMBER.
ARRANGEMENT OPTIONAL.



HI-LOK® PIN



HI-LOK® PIN AND COLLAR AFTER ASSEMBLY

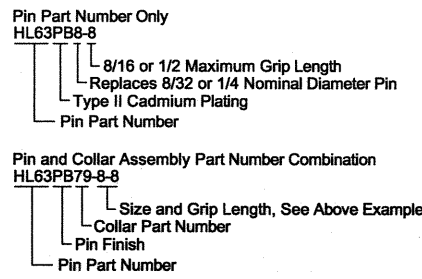
FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
												W HEX	T DEPTH	Y DIA		
NOTE: USE HL19()6-() or HL419()6-()																
5																
6	13/64	.3016 .2966	.325	.2026 .2016	.1840 .1810	.005	.0415 .0394	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	6,130	2,000
8	17/64	.3948 .3898	.395	.2651 .2641	.2440 .2410	.006	.0544 .0523	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	10,490	3,700
10	21/64	.4739 .4689	.500	.3276 .3266	.3060 .3020	.007	.0614 .0593	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	16,000	5,000
12	25/64	.5604 .5554	.545	.3901 .3891	.3680 .3640	.008	.0714 .0693	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	22,700	7,200
14	29/64	.6680 .6620	.635	.4526 .4516	.4310 .4260	.009	.0904 .0879	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	30,600	10,000
16	33/64	.7540 .7480	.685	.5151 .5141	.4930 .4880	.010	.1002 .0977	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	39,600	13,500
18	37/64	.8380 .8310	.770	.5771 .5761	.5550 .5500	.010	.1094 .1065	.050 .040	.022	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.290 .270	.326 .306	49,700	17,000
20	41/64	.9250 .9180	.825	.6396 .6386	.6180 .6120	.010	.1197 .1168	.050 .040	.022	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.330 .305	.326 .306	61,000	21,000
24	49/64	1.0970 1.0850	1.050	.7646 .7636	.7430 .7370	.012	.1394 .1344	.050 .040	.022	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.395 .365	.398 .378	87,200	30,700
28	57/64	1.3197 1.3030	1.210	.8896 .8886	.8680 .8610	.014	.1804 .1734	.050 .040	.022	5/64" x 45°	7/8-14UNJF-3A Modified	.3820 .3780	.455 .425	.471 .451	118,000	42,000
32	1-1/64	1.5186 1.4995	1.390	1.0146 1.0136	.9930 .9860	.014	.2114 .2034	.050 .040	.022	5/64" x 45°	1-12UNJF-3A Modified	.5100 .5040	.580 .550	.618 .598	154,000	55,000

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 FIM.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions to be met after finish.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - Use HL219 for oversize replacement.
 - Curved or flat edge manufacturer's option.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL63 oversize pin replaces. 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 AMS-S-6049.
- HEAT TREAT:** 95,000 psi shear minimum (160,000-180,000 psi tensile per AMS-H-6875).
- FINISH:**
 HL63(-)(-) = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL63A(-)(-) = Cadmium plate per AMS2400-3 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL63PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
- SPECIFICATION:** Hi-Lok Product Specification 342.

"Hi-Lok" and "HL" are internationally registered trademark of Hi-Shear Corporation.		
DRAWN	DATE	TITLE
Briej	5-2-63	HI-LOK® PIN
APPROVED	DATE	100° FLUSH SHEAR HEAD ALLOY STEEL 1/16" GRIP VARIATION, 1/64" OVERSIZE
Cessna	11-1-63	
REVISION	DATE	DRAWING NUMBER
19	JMO 12-1-04	HL63

HL63

JFO-STD/HLPIN

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