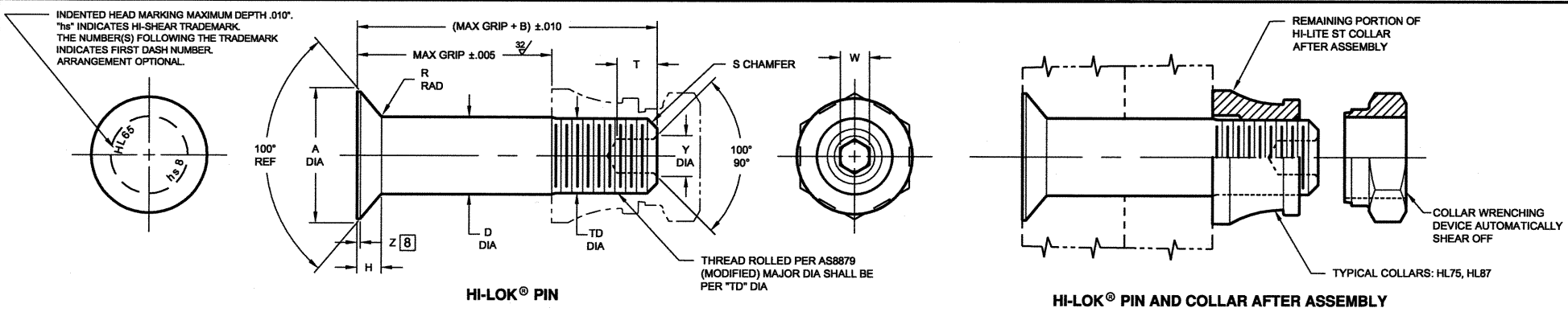


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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

15	HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197 a LISI AEROSPACE Company	BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE No. 0LB68 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)	



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 HL21-6(-) or HL421-6(-)																
5																
6	13/64	.3813 .3765	.325	.2026 .2016	.1840 .1810	.005	.0750 .0730	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	6,130	3,180
8	17/64	.5066 .5018	.395	.2651 .2641	.2440 .2410	.006	.1013 .0993	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	10,490	5,820
10	21/64	.6335 .6287	.500	.3276 .3266	.3060 .3020	.007	.1283 .1263	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	16,000	9,200
12	25/64	.7604 .7556	.545	.3901 .3891	.3680 .3640	.008	.1553 .1533	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	22,700	14,000
14	29/64	.8884 .8812	.635	.4526 .4516	.4310 .4260	.009	.1828 .1798	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	30,600	18,900
16	33/64	1.0139 1.0068	.685	.5151 .5141	.4930 .4880	.010	.2093 .2063	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	39,600	25,600
18	37/64	1.1408 1.1337	.770	.5771 .5761	.5550 .5500	.010	.2365 .2335	.050 .040	.022	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.290 .270	.326 .306	49,700	32,400
20	41/64	1.2723 1.2561	.825	.6396 .6386	.6180 .6120	.010	.2654 .2624	.050 .040	.022	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.330 .305	.326 .306	61,000	41,000
24	49/64	1.5308 1.5236	1.050	.7646 .7636	.7430 .7370	.012	.3214 .3184	.050 .040	.022	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.395 .365	.398 .378	87,200	59,500

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

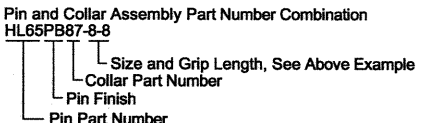
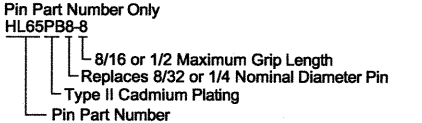
- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .005 FIM.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions to be met after plating.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - Non-lubed pins must be used with wet sealant or with lubed collars.
 - Curved or flat edge manufacturer's option.
 - Use HL221 for oversize replacement.

- MATERIAL:** Alloy steel per AMS6415, AMS6349, or AMS-S-6049.
- HEAT TREAT:** 160,000-180,000 psi tensile per AMS-H-6875.
- FINISH:**
- HL65-() = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL65A-() = Cadmium plate per AMS2400-3 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL65PB-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL65PN-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.

SPECIFICATION: HI-Lok Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL65 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER EXAMPLE:



"Hi-Lok" and "HL" are internationally registered trademark of Hi-Shear Corporation.		
DRAWN	DATE	TITLE
Brij	7-29-64	HI-LOK® PIN
APPROVED	DATE	100° FLUSH MS24694 TENSION HEAD ALLOY STEEL
Cessna	7-30-64	1/16" GRIP VARIATION, 1/64" OVERSIZE
REVISION	DATE	DRAWING NUMBER
15	JMO 12-1-04	HL65
		SHEET 1 OF 1

HL65

JFO-STD/HLPIN