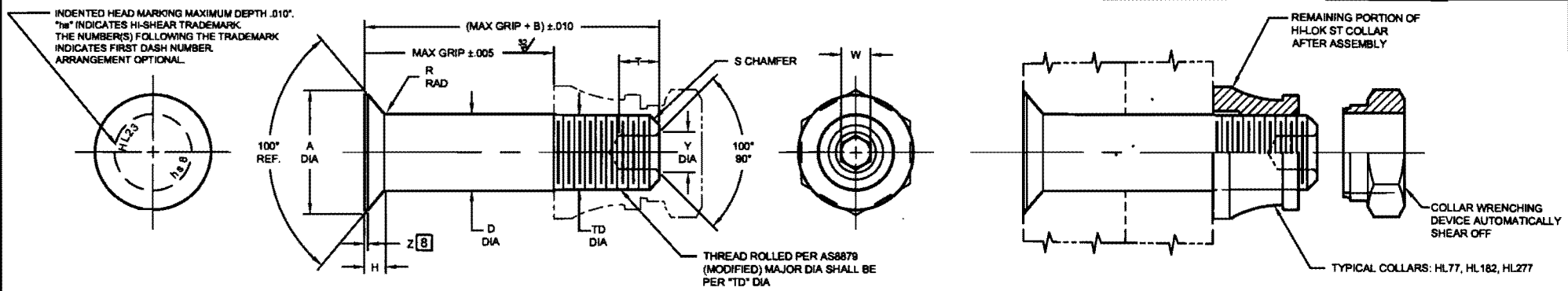




HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73187	BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE No. 0L808
a LISI AEROSPACE Company	a LISI AEROSPACE Company
APR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A. & Canada) CAGE No. 08725	HUCK S.A. France (Licensee - ECC Countries) CAGE No. 08725
HUCK INTERNATIONAL, INC., U.S.A. (Licensee) CAGE No. 97628	BLANC AERO S.A. France (Licensee - ECC Countries) CAGE No. 97628
SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 99976	a LISI AEROSPACE Company
FAIRCHILD Aerospace Fastener Division (Licensee) CAGE No. 92215	TKYO SCREW COMPANY, Japan (Licensee - Japan) CAGE No. 92215
WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 80516	(Pins & Steel Collars) CAGE No. 80516



HI-LOK PIN

HI-LOK PIN AND COLLAR AFTER ASSEMBLY

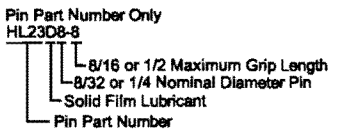
FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
												W HEX	T DEPTH	Y DIA		
5	5/32	.2922 .2874	.312	.1635 .1625	.1595 .1570	.004	.0540 .0520	.025 .015	.010	1/32" x 45°	8-32UNJ-C-3A Modified	.0645 .0635	.135 .115	.090 .075	1,760	860
6	3/16	.3536 .3486	.325	.1895 .1885	.1840 .1810	.005	.0688 .0667	.030 .020	.015	1/32" x 45°	10-32UNJ-F-3A Modified	.0806 .0791	.135 .115	.119 .104	2,550	1,150
8	1/4	.4732 .4682	.395	.2495 .2485	.2440 .2410	.006	.0939 .0918	.030 .020	.015	1/32" x 45°	1/4-28UNJ-F-3A Modified	.0967 .0947	.150 .130	.142 .122	4,420	2,000
10	5/16	.5619 .5569	.500	.3120 .3110	.3060 .3020	.007	.1048 .1027	.040 .030	.015	3/64" x 45°	5/16-24UNJ-F-3A Modified	.1295 .1270	.170 .150	.180 .160	6,900	2,800
12	3/8	.6912 .6862	.545	.3745 .3735	.3680 .3640	.008	.1329 .1308	.040 .030	.015	3/64" x 45°	3/8-24UNJ-F-3A Modified	.1617 .1582	.200 .180	.217 .197	9,940	3,900
14	7/16	.8041 .7969	.635	.4370 .4360	.4310 .4260	.009	.1540 .1510	.050 .040	.022	3/64" x 45°	7/16-20UNJ-F-3A Modified	.1930 .1895	.230 .210	.253 .233	13,800	6,000
16	1/2	.9166 .9095	.685	.4995 .4985	.4930 .4880	.010	.1750 .1720	.050 .040	.022	3/64" x 45°	1/2-20UNJ-F-3A Modified	.2242 .2207	.260 .240	.289 .269	18,000	7,600

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 HL123 for oversize replacement.
 - Curved or flat edge manufacturer's option.

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:



MATERIAL: 7075 aluminum alloy per AMS-QQ-A-225/9 or QQ-A-430.

HEAT TREAT: Age to T6 condition per AMS2770.

- FINISH:**
- HL23-()-() = Anodize per MIL-A-8625, dye color natural and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL23D()-() = Anodize per MIL-A-8625, and solid film lube per AS5272, Type I.
 - HL23TT()-() = Anodize per MIL-A-8625, dye color natural and transluce.

SPECIFICATION: Hi-Lok Product Specification 342.

DRAWN		DATE	TITLE
R.K.L.		5-8-82	HI-LOK® PIN
APPROVED		DATE	100° FLUSH MS20426 SHEAR HEAD ALUMINUM ALLOY 1/16" GRIP VARIATION
Cassna		5-8-82	
REVISION		DATE	DRAWING NUMBER
22		2-13-2012	HL23

HL23