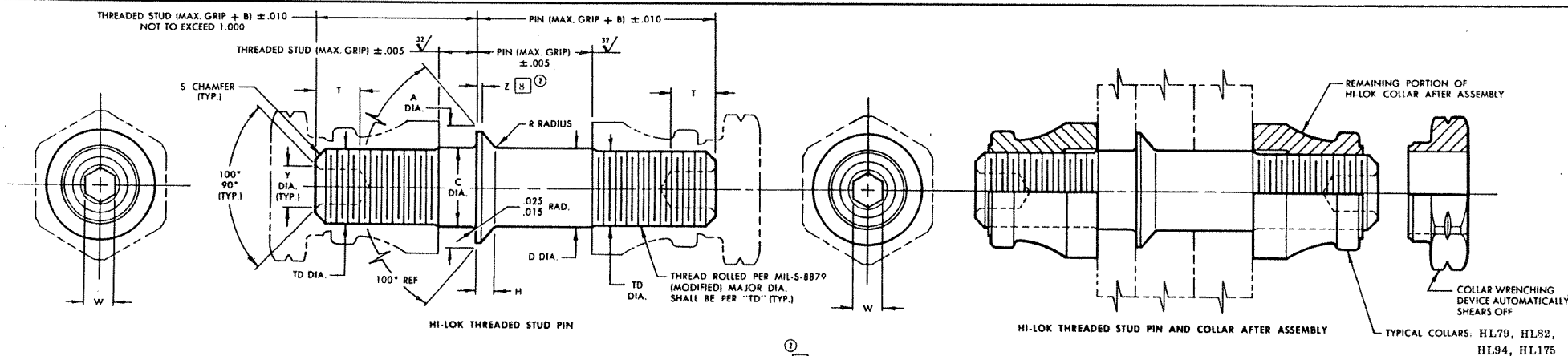


[illegible]

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

- GENERAL NOTES:**
1. Head edge out of roundness shall not exceed ".F."
 2. Concentricity: Conical surface of head to "D" diameter within .005 FIR.
Threaded stud side to pin side within .010 FIR.
 3. "H" dimensioned from maximum "D" diameter.
 4. Dimensions to be met after finish.
 5. Surface texture per ANSI B46.1. ①
 6. Hole preparation per NAS618.
 7. Use HL345 for oversize replacement.
 - ① 8. Curved or flat edge manufacturer's option.

MATERIAL: 6Al-4V titanium alloy per AMS4928 or AMS4967.

HEAT TREAT: 95,000 psi shear minimum.

FINISH: HL245-()-()-() = Cetyl alcohol per HI-Shear Spec. 305.

SPECIFICATION: HI-Lok Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds which HL245 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
② Third dash number indicates threaded stud maximum grip in 1/16ths.

HOW TO ORDER EXAMPLES:

Stud Pin Part Number Only

HL245-8-8-8

8/16 or 1/2 Threaded Stud Maximum Grip Length
 8/16 or 1/2 Maximum Grip Length
 Replaces 8/32 or 1/4 Nominal Diameter Pin
 Pin Part Number

Stud Pin and Collar Assembly Part Number Combination

HL24579-8-8-8

Size, Grip, and Threaded Stud Grip Length
See Above Example
Collar Part Number
Pin Part Number

* * The Double Shear values shown are based on cross sectional area for nominal diameter pin.

U.S. patents 2,882,773; 2,927,491; 2,940,495; 3,027,789; 3,138,987; design patent 191,883; other U.S. and foreign patents granted and pending; property of Hi-Shear Corporation. "Hi-Lok" and "HL" are Registered Trademarks of Hi-Shear Corporation.

DRAWN	DATE
VAN	3-19-70

APPROVED	DATE
<i>P. TING</i>	<i>5-5-70</i>

REVISION DATE
 (2) VAN 2-7-75

hi-lok[®] THREADED STUD PIN
100° FLUSH MS20426 SHEAR HEAD
TITANIUM
1/16" GRIP VARIATION — 1/64" OVERSIZE
DRAWING NUMBER
HL245