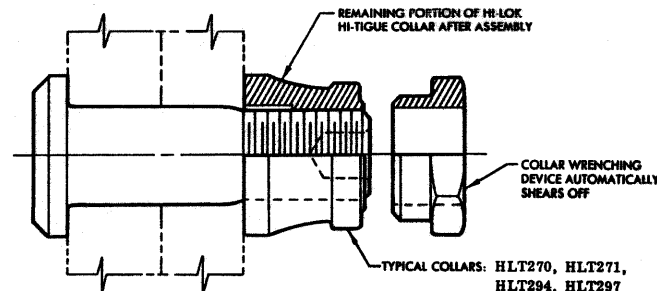
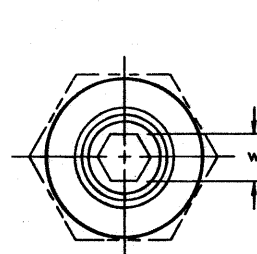
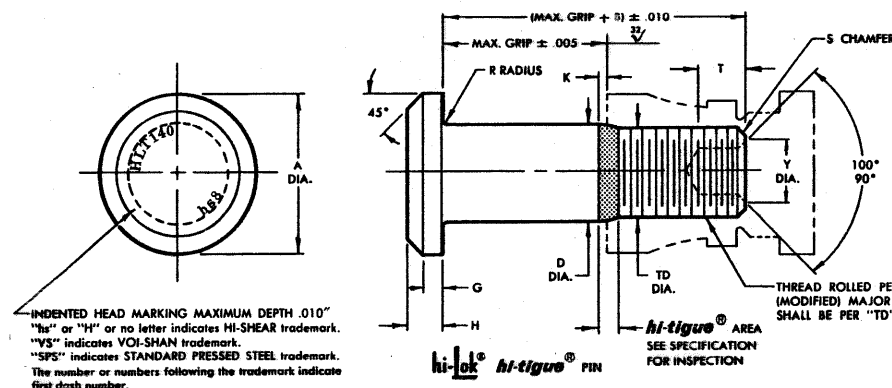


STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) --	U.S. Federal Code No. 73197	HI-SHEAR FASTENERS EUROPE, LTD., U.K. -- (Licensee)
Division of Hi-Shear Industries Inc., U.S.A.		Division of Hi-Shear Industries Inc., U.S.A.
AIR INDUSTRIES CO., INC. -- (Licensee - U.S. & Canada)---	U.S. Federal Code No. 06726	Huck International, GmbH & Co. Germany
HUCK International, Deutsch Operations (Licensee)---	U.S. Federal Code No. 97928	ST. CHAMOND GRANAT, S.A. France-----
SPS TECHNOLOGIES, U.S.A. (Licensee)---	U.S. Federal Code No. 66878	SIMMONDS, S.A. France -----
VOI-SHAN, Division of VSI Corp., U.S.A. -- (Licensee)---	U.S. Federal Code No. 92215	TOKYO SCREW COMPANY, Japan-----
WEST COAST AEROSPACE INC., U.S.A. (Licensee)---	U.S. Federal Code No. 60516	
(Pins & Steel Collars)		



hi-lok® hi-tigue® PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.		TD DIA.	G REF.	H	K REF.	R RAD.	S CHAMFER REF.	THREAD	SOCKET			② DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT HI-KOTE™ LUBE	WITH HI-KOTE™ LUBE								W HEX.	T DEPTH	Y DIA.		
5												NOTE: Use HLT40-6					
6	13/64	.315 .295	.360	.2026 .2021	.2026 .2016	.1840 .1810	.025 .025	.055 .045	.020	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	6,130	2,500
8	17/64	.412 .387	.435	.2651 .2646	.2651 .2641	.2440 .2410	.030	.069 .059	.025	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	10,490	4,300
10	21/64	.505 .475	.545	.3276 .3271	.3276 .3266	.3060 .3020	.035	.078 .068	.031	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	16,000	6,300
12	25/64	.600 .565	.590	.3901 .3896	.3901 .3891	.3680 .3640	.040	.088 .078	.037	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	22,700	8,700
14	29/64	.676 .641	.690	.4526 .4521	.4526 .4516	.4310 .4260	.045	.105 .093	.039	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	30,600	12,100
16	33/64	.770 .735	.740	.5151 .5146	.5151 .5141	.4930 .4880	.050	.116 .103	.045	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	39,600	15,300
18	37/64	.864 .829	.825	.5771 .5766	.5771 .5761	.5550 .5500	.055	.127 .112	.043	.040 .025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	49,700	19,000

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

GENERAL NOTES:

- Concentricity: "A" to "D" diameter within .010 FIR.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- Use HLT240 for oversize replacement.

CODE:

First dash number indicates nominal diameter in 1/32nds of the pin which HLT140 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

MATERIAL:

A-286 high temperature alloy per AMS5731 or AMS5737.

HEAT TREAT:

95,000 psi shear minimum at 70°F.

FINISH:

- HLT140-(-)(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT140TB-(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT140TC-(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, except top surface of head shall be uncoated, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION:

Hi-Lok Hi-Tigue Product Specification 342 and 342-2.

HOW TO ORDER EXAMPLE:

Pin Part Number Only
HLT140-8-8

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

Pin and Collar Assembly Part Number Combination
HLT140270-8-8

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

"Hi-Lok", "HL", "Hi-Tigue", and "HLT" are internationally registered trademarks of Hi-Shear Corporation.		
DRAWN	DATE	TITLE
Van	6-10-72	HI-LOK® HI-TIGUE® PIN PROTRUDING SHEAR HEAD A-286 HIGH TEMPERATURE ALLOY 1/16" GRIP VARIATION, 1/64" OVERSIZE
APPROVED	DATE	
J. Wilcox	6-16-72	
REVISION	DATE	DRAWING NUMBER
②	J.F. Obispo 11-07-94	HLT140