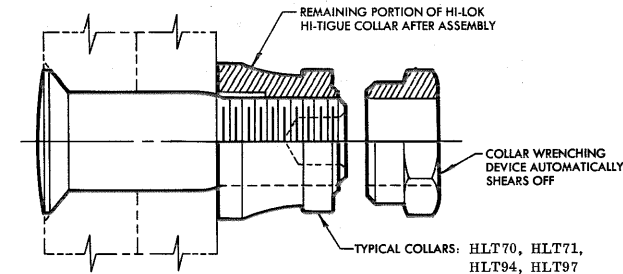
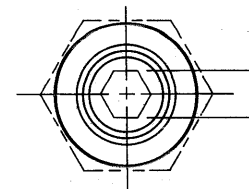
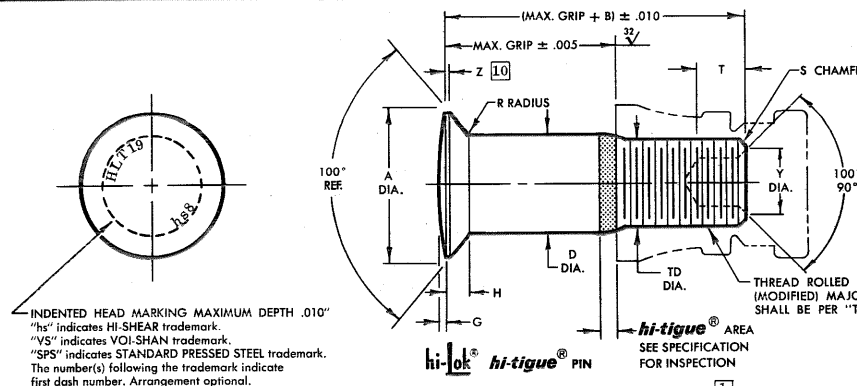


STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

ISI AEROSPACE - Please refer to Central Documentation Website to check validity

HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee)	No. 73197
Division of Hi-Shear Industries Inc., U.S.A.	
AIR INDUSTRIES CO., INC. (Licensee - U.S. & Canada)	U.S. Federal Code No. 06725
DEUTSCH FASTENER CO., INC. (Licensee)	U.S. Federal Code No. 07928
SPS TECHNOLOGIES, U.S.A. (Licensee)	U.S. Federal Code No. 06772
VOI-SHAN, Division of VSI Corp., U.S.A. (Licensee)	U.S. Federal Code No. 02215
WEST COAST AEROSPACE INC., U.S.A. (Licensee)	U.S. Federal Code No. 60516
Plus & Steel Collars	
KAMAX-WERKE, Germany (Licensee - EEC Countries)	
Rudolph Kollermaier GmbH & Co. (Licensee - EEC Countries)	
ST. CHAMOND GRAXAT, S.A. France (Licensee - EEC Countries)	
SIMMONDS, S.A. France (Licensee - EEC Countries)	
TOKYO SCREW COMPANY, Japan (Licensee - Japan)	



FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.	TD DIA.	F	G	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	MIN. GRIP LENGTH
													W HEX.	T DEPTH	Y DIA.			
-5	5/32	.2612 .2564	.312	.1695 .1685	.1595 .1570	.004	.0070 .0040	.0385 .0365	.025 .015	.010	1/32" x 45°	8-32UNJC-3A Modified	.0801 .0791	.100 .080	.104 .094	4,210	1,290	-2
-6	3/16	.3016 .2966	.325	.1955 .1945	.1840 .1810	.005	.0080 .0050	.0445 .0424	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	5,550	2,000	-3
-8	1/4	.3948 .3898	.395	.2555 .2545	.2440 .2410	.006	.0100 .0070	.0586 .0563	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	9,620	3,700	-3
-10	5/16	.4739 .4689	.500	.3180 .3170	.3060 .3020	.007	.0110 .0080	.0654 .0633	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .130	.180 .160	14,890	5,000	-3
-12	3/8	.5604 .5554	.545	.3805 .3795	.3680 .3640	.008	.0125 .0095	.0755 .0734	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	21,430	7,200	-4
-14	7/16	.6680 .6620	.635	.4430 .4420	.4310 .4260	.009	.0150 .0120	.0944 .0919	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	29,000	10,000	-5
-16	1/2	.7540 .7480	.685	.5055 .5045	.4930 .4880	.010	.0165 .0135	.1042 .1017	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	37,900	13,500	-5

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

- ① GENERAL NOTES:
- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .005 FIR.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions to be met after finish.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618 (Column "B") for interference application.
 - Use HLT119 for oversize replacement.
 - Install per Hi-Shear Specification 299.
 - Minimum required for head and Hi-Tigue feature.
 - 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.

HOW TO ORDER EXAMPLES:

Pin Part Number Only
HLT19-8-8

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

Pin and Collar Assembly Part Number Combination
HLT1970-8-8

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

MATERIAL: Alloy steel per Spec. MIL-S-5000, MIL-S-5626 or MIL-S-6049.

HEAT TREAT: 95,000 psi shear minimum (160,000 - 180,000 psi tensile per Spec. MIL-H-6875).

- ① FINISH:
- HLT19-(-)(-) = Cadmium plate per Spec. QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT19BJ-(-)(-) = I.V.D. aluminum coating per MIL-C-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lok Hi-Tigue Product Specification 342.

"HL", "Hi-Lok", "HLT" and "Hi-Tigue" are internationally registered trademarks of Hi-Shear Corporation	
DRAWN VAN	DATE 10-4-68
APPROVED POLIVKA	DATE 10-8-68
REVISION 5	DATE T.Craigne 3-18-93
hi-lok® hi-tigue® PIN 100° FLUSH CROWN SHEAR HEAD ALLOY STEEL 1/16" GRIP VARIATION DRAWING NUMBER HLT19	

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