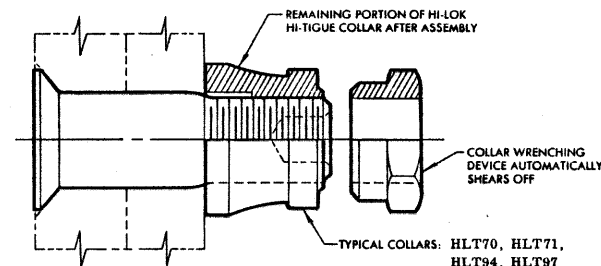
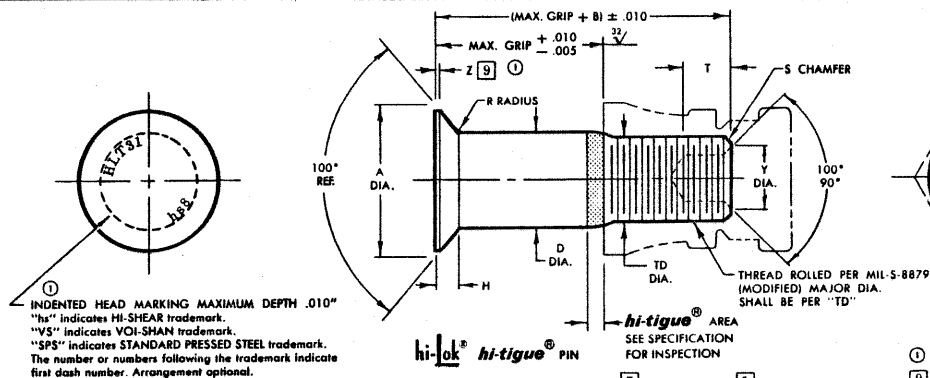


STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

2800 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

LI SI AEROSPACE – Please refer to Central Documentation Website to check validity

HI-SHEAR CORPORATION, U.S.A. (Patent holder) U.S. Federal Code I.S. No. 75187
Division of Hi-Shear Industries Inc., U.S.A. (Licensee)
AIRCRAFT FASTENERS (Forged Parts) LTD., U.K. (Licensee)
Division of Hi-Shear Industries Inc., U.S.A. (Licensee)
VOI-SHAN, Division of VSI Corp., U.S.A. (Licensee) U.S. Federal Code I.S. No. 82215
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TOKYO SCREW COMPANY, Japan (Licensee—Japan)
WEST COAST AEROSPACE INC., U.S.A. (Licensee—Oversize Pins and Steel Collars)
U.S. Federal Code I.S. No. 60515



FIRST DASH NO.	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	.2612 .2564	.312	.1635 .1630	.1595 .1570	.004	.041 .039	.025 .015	.010	1/32" x 45°	8-32UNJC-3A Modified	.0801 .0791	.100 .080	.119 .104	5,290	1,700
-6	3/16	.3016 .2966	.325	.1895 .1890	.1840 .1810	.005	.047 .045	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	7,060	2,600
-8	1/4	.3948 .3898	.395	.2495 .2490	.2440 .2410	.006	.061 .059	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	12,260	4,400
-10	5/16	.4739 .4689	.500	.3120 .3115	.3060 .3020	.007	.069 .066	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	19,160	7,000
-12	3/8	.5604 .5554	.645	.3745 .3740	.3680 .3640	.008	.078 .076	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	27,600	10,000
-14	7/16	.6680 .6620	.635	.4370 .4365	.4310 .4260	.009	.097 .094	.050 .040	.022	3/8" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	37,500	13,500
-16	1/2	.7540 .7480	.685	.4995 .4990	.4930 .4880	.010	.107 .104	.050 .040	.022	3/8" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	49,100	18,000
-18	9/16	.8380 .8310	.770	.5615 .5610	.5550 .5500	.010	.116 .113	.050 .040	.022	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	62,100	22,500
-20	5/8	.9250 .9180	.825	.6240 .6235	.6180 .6120	.010	.126 .123	.050 .040	.022	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	76,700	28,000

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 of solid film lubed parts to be met after lube.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- Maximum "D" diameter may be increased by .0004 to allow for solid film application (code "LP" only).
- Use HLT131 for oversize replacement.
- Curved or flat edge manufacturers option.

MATERIAL: Type 431 stainless steel per AMS5628 and MIL-S-18732.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: HLT31-()-() = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT31LP-()-() = Solid film lube per Spec. MIL-L-46010 and cetyl alcohol lube per Hi-Shear Spec. 305.

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

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 EXAMPLES:

Pin Part Number Only
HLT131-5-8
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
HLT13170-8-8
Size and Grip Length, See Above Example
Collar Part Number
Pin Part Number

U.S. patents 3,390,906; 3,578,367, and foreign patents. "Hi-Lok," "Hi-Tigue," and "HLT" are Registered Trademarks of Hi-Shear Corporation.

DRAWN VAN	DATE 10-27-71	hi-tigue® PIN 100° FLUSH SHEAR HEAD TYPE 431 STAINLESS STEEL 1/16" GRIP VARIATION
APPROVED JG Wilcox	DATE 10-27-71	
REVISION ①	DATE 10-14-83	DRAWING NUMBER HLT31

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HLT31