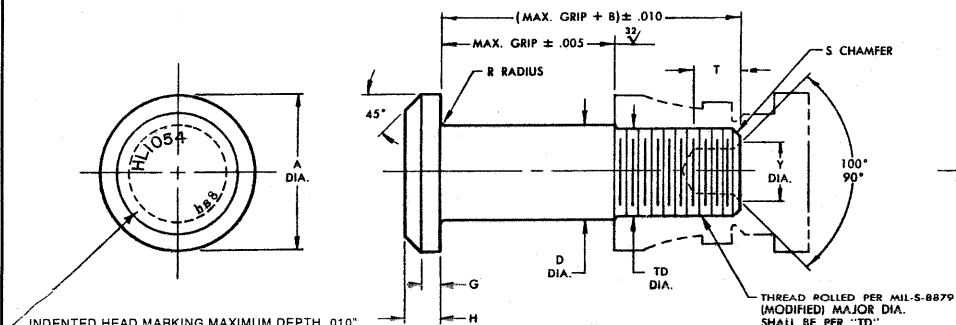


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

2600 Skypark Drive, Torrance, California U.S.A. 90509

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
Division of Hi-Shear Industries Inc., U.S.A.
AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S. & Canada) CAGE No. 09725
HUCK INTERNATIONAL INC., U.S.A. (Licensee) CAGE No. 97928
SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 58878
FAIRCHILD Aerospace Fastener Division, U.S.A. (Licensee) CAGE No. 92215
WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60515
(Pins & Steel Collars)

HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee) CAGE No. 0LB88
Division of Hi-Shear Industries Inc., U.S.A.
HUCK INTERNATIONAL GMBH & CO., Germany (Licensee - EEC Countries)
SAINT CHAMOND GRANAT, S.A. France (Licensee - EEC Countries)
SMYTHCO S.A. France (Licensee - EEC Countries - Collars)
TOKYO SCREW COMPANY, Japan (Licensee - Japan)

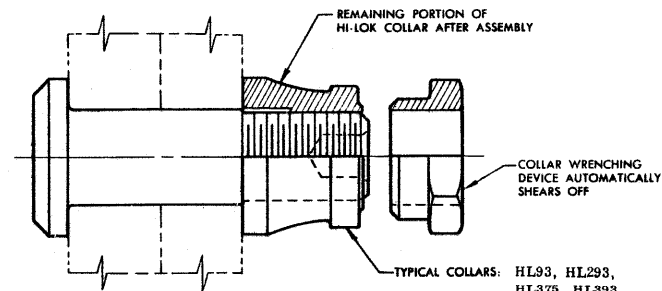


INDENTED HEAD MARKING MAXIMUM DEPTH .010".
MANUFACTURER'S TRADEMARK PER HI-SHEAR SPEC.
363. THE NUMBER(S) FOLLOWING THE TRADEMARK
INDICATE FIRST DASH NUMBER.
ARRANGEMENT OPTIONAL.

HI-LOK® PIN

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.		D DIA	TD DIA.	G REF.	H		R RAD.		S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
														W HEX.	T DEPTH	Y DIA.		
5				NOTE: USE HL1052PB-6(-)														
6	7/32	.390 .370	.325		.2182 .2172	.1840 .1810	.035	.074 .064		.025 .015		1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	7,100	3,180
8	9/32	.460 .435	.395		.2807 .2797	.2440 .2410	.045	.090 .077		.025 .015		1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	11,800	5,820
10	11/32	.520 .500	.500		.3432 .3422	.3060 .3020	.055	.112 .098		.030 .020		3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	17,600	9,200
12	13/32	.620 .600	.545		.4057 .4047	.3680 .3640	.065	.140 .130		.030 .020		3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	24,600	14,000
14	15/32	.695 .670	.635		.4682 .4672	.4310 .4260	.075	.160 .150		.030 .020		3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	32,700	18,900
16	17/32	.790 .765	.685		.5307 .5297	.4930 .4880	.085	.188 .178		.030 .020		3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	42,000	25,600
18	19/32	.905 .870	.770		.5927 .5917	.5550 .5500	.125	.210 .200		.040 .025		1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.290 .270	.326 .306	52,400	32,400
20	21/32	.975 .940	.825		.6552 .6542	.6180 .6120	.140	.238 .228		.040 .025		1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.330 .305	.326 .306	64,100	41,000
24	25/32	1.185 1.145	1.050		.7802 .7792	.7430 .7370	.200	.335 .320		.045 .030		1/16" x 45°	3/4-UNJF-3A Modified	.3185 .3150	.395 .365	.398 .378	90,900	59,500

HI-LOK® PIN AND COLLAR AFTER ASSEMBLY



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

GENERAL NOTES:

1. Concentricity: "A" to "D" diameter within .010 FIR.
2. Dimensions to be met after finish.
3. Surface texture per ANSI B46.1.
4. Hole preparation per NAS618.
5. Use HL1056 for oversize replacement.

MATERIAL:

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

HEAT TREAT:

160,000 - 180,000 psi tensile per MIL-H-6875.

FINISH:

HL1054PB-()-() = Cadmium plate per QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION:

Hi-Lok Product Specification 342.

CODE:

First dash number indicates nominal diameter in 1/32nds of the pin which HL1054 oversize pin replaces.
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
HL1054PB-8-8

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

Pin and Collar Assembly Part Number Combination
HL1054PB93-8-8

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

"Hi-Lok" and "HL" are internationally
registered trademarks of Hi-Shear Corporation.

DRAWN J.F.Obispo	DATE 01-03-96	TITLE HI-LOK® PIN PROTRUDING TENSION HEAD ALLOY STEEL, 1/32" OVERSIZE 1/16" GRIP VARIATION	
APPROVED <i>mc</i>	DATE 1-3-96	DRAWING NUMBER HL1054	
REVISION	DATE		