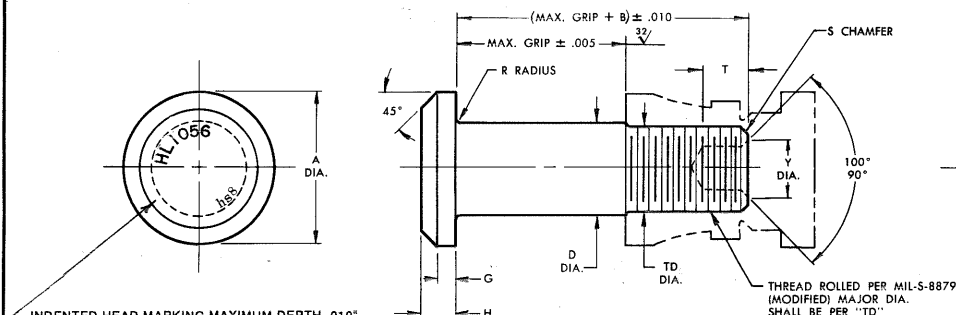


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

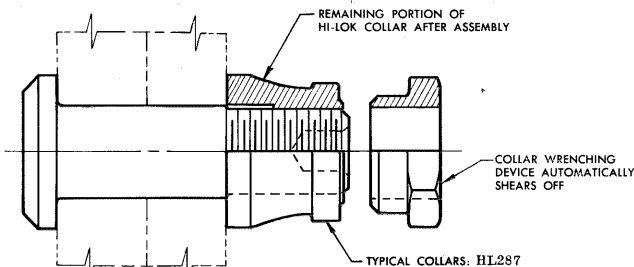
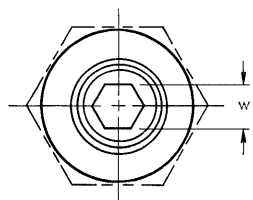
2600 Skypark Drive, Torrance, California U.S.A. 90509

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. 06725
 HUCK INTERNATIONAL, INC., Deutsch Operation, U.S.A. (Licensee) CAGE No. 97528
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878
 FAIRCHILD Aerospace Fastener Division, U.S.A. (Licensee) CAGE No. 92215
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516
 (Pins & Steel Collars)

HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee) CAGE No. 0LB68
 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)
 SIMMONDS S.A., France (Licensee - EEC Countries)
 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

HI-LOK® PIN AND COLLAR AFTER ASSEMBLY

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 HL1054PB-6(-)														
6	15/64	.400 .380	.360		.2339 .2329	.1840 .1810	.035 .064	.074 .064		.025 .015		1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	8,160	3,180
8	19/64	.470 .445	.430		.2963 .2953	.2440 .2410	.045 .077	.090 .077		.025 .015		1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	13,100	5,820
10	23/64	.535 .515	.530		.3589 .3579	.3060 .3020	.055 .098	.112 .098		.030 .020		3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	19,200	9,200
12	27/64	.620 .600	.575		.4214 .4204	.3680 .3640	.065 .130	.140 .130		.030 .020		3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	26,500	14,000
14	31/64	.705 .685	.660		.4839 .4829	.4310 .4260	.075 .150	.160 .150		.030 .020		3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	34,900	18,900
16	35/64	.795 .770	.710		.5464 .5454	.4930 .4880	.085 .178	.188 .178		.030 .020		3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	44,600	25,600
18	39/64	.920 .885	.795		.6084 .6074	.5550 .5500	.125 .210	.210 .200		.040 .025		1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.290 .270	.326 .306	55,300	32,400
20	43/64	.990 .955	.850		.6709 .6699	.6180 .6120	.140 .228	.238 .228		.040 .025		1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.330 .305	.326 .306	67,200	41,000
24	51/64	1.200 1.160	1.075		.7959 .7949	.7430 .7370	.200 .320	.335 .320		.045 .030		1/16" x 45°	3/4-UNJF-3A Modified	.3185 .3150	.395 .365	.398 .378	94,500	59,500

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

CODE:

First dash number indicates nominal diameter in 1/32nds of the pin which HL1056 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

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.

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:

HL1056PB-(-) = 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.

HOW TO ORDER
EXAMPLES:

Pin Part Number Only
 HL1056PB-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
 HL1056PB287-8-8

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 DATE		TITLE	
J.F.Obispo	01-03-96	HI-LOK® PIN PROTRUDING TENSION HEAD ALLOY STEEL, 3/64" OVERSIZE 1/16" GRIP VARIATION	
APPROVED DATE		DRAWING NUMBER	
MC	1-3-96	HL1056	
REVISION DATE			
①	J.F.Obispo 03-12-96		