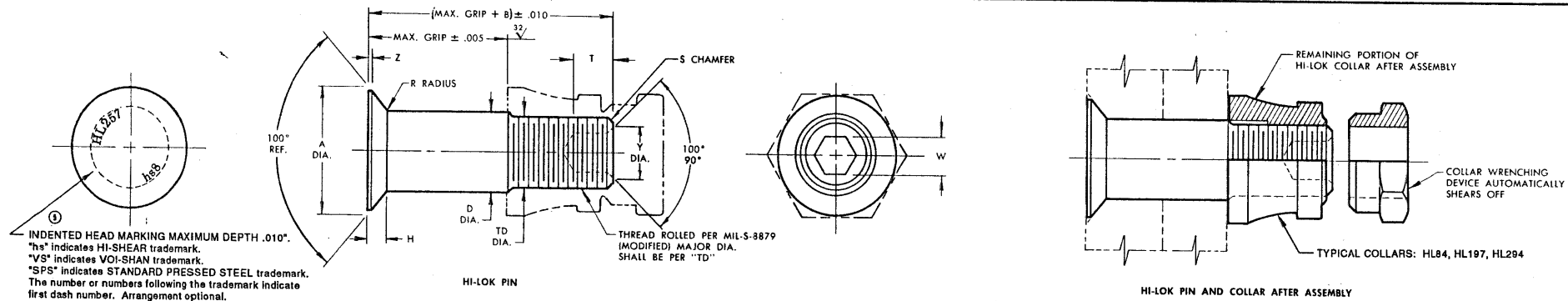


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) U.S. Federal Code No. 73197 Division of Hi-Shear Industries Inc., U.S.A. AIR INDUSTRIES CO., INC. (Licensee - U.S. & Canada) U.S. Federal Code No. 08725 GEUTSCH FASTENER CO., INC. (Licensee) U.S. Federal Code No. 57928 SPS TECHNOLOGIES, U.S.A. (Licensee) U.S. Federal Code No. 55978 VOI-SHAN, Division of VSI Corp., U.S.A. (Licensee) U.S. Federal Code No. 92215 WEST COAST AEROSPACE INC., U.S.A. (Licensee) U.S. Federal Code No. 60516 Pins & Steel Collars	HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee) Division of Hi-Shear Industries Inc., U.S.A. KAMAX-WERKE, Germany (Licensee - EEC Countries) Ruedolph Kellerman GmbH & Co. (Licensee - EEC Countries) ST. CHAMOND GRAVAT, S.A. France (Licensee - EEC Countries) SIMMONDS, S.A. France (Licensee - EEC Countries) Collars TOKYO SCREW COMPANY, Japan (Licensee - Japan)
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FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA. [7]		TD DIA.	[1]					S CHAMFER REF.	THREAD	SOCKET			* DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING, PLATING OR SOLID FILM LUBE	WITH COATING, PLATING OR SOLID FILM LUBE		F	H	R RAD.	Z	W HEX.			T DEPTH	Y DIA.			
-5	13/64			NOTE: Use HL447-6														
-6	7/32	.3536 .3486	.325	.2182 .2177	.2182 .2172	.1840 .1810	.005	.0568 .0547	.030 .020	.015 .005	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	7,100	2,590	
-8	9/32	.4732 .4682	.395	.2807 .2802	.2807 .2797	.2440 .2410	.006	.0807 .0786	.030 .020	.015 .005	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	11,800	4,760	
-10	11/32	.5619 .5569	.500	.3432 .3427	.3432 .3422	.3060 .3020	.007	.0917 .0896	.040 .030	.015 .005	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	17,600	7,100	
-12	13/32	.6912 .6862	.545	.4057 .4052	.4057 .4047	.3680 .3640	.008	.1198 .1177	.040 .030	.015 .005	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	24,600	10,600	
-14	15/32	.8041 .7969	.635	.4682 .4677	.4682 .4672	.4310 .4260	.009	.1409 .1379	.050 .040	.022 .005	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	32,700	14,450	
-16	17/32	.9166 .9095	.685	.5307 .5302	.5307 .5297	.4930 .4880	.010	.1619 .1589	.050 .040	.022 .005	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	42,000	19,550	
-18	19/32	1.0337 1.0266	.770	.5927 .5922	.5927 .5917	.5550 .5500	.010	.1850 .1820	.050 .040	.025 .005	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.290 .270	.326 .306	52,400	24,700	
-20	21/32	1.1230 1.1158	.825	.6552 .6547	.6552 .6542	.6180 .6120	.010	.1962 .1932	.050 .040	.025 .005	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.330 .305	.326 .306	64,100	29,600	
-24	25/32	1.3500 1.3428	1.050	.7802 .7797	.7802 .7792	.7430 .7370	.012	.2390 .2360	.050 .040	.025 .005	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.395 .365	.398 .378	90,900	42,900	

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

- GENERAL NOTES:**
- Head out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .005 FIR.
 - "H" dimensioned from maximum "D" diameter.
 - Dimensions to be met after finish.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - Maximum "D" diameter may be increased by .0002 to allow for solid film application.

MATERIAL: A-286 high temperature alloy per Spec. AMS5737 or AMS5731.

HEAT TREAT: 95,000 psi shear minimum at 70°F.

- FINISH:**
- HL257-() = Passivate per Hi-Shear Spec. 258, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL257AZ-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, with color code black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL257PB-() = Cadmium plate per QQ-P-416, Type II, Class 2, with color code green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL257N-() = Cadmium plate per QQ-P-416, Class II, without lube. (For use in LOX systems)
 - HL257V-() = Solid film lube per "Lubeco" 2123, Type II.

SPECIFICATION: Hi-Lok Product Spec. 342.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL257 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
HL257PB-8-8
8/16 or 1/2 Maximum Grip Length
Replaces 8/32 or 1/4 Nominal Diameter Pin
Type II Cadmium Plate
Pin Part Number

Pin and Collar Assembly Part Number Combination
HL257PB84-8-8
Size and grip length, see above example
Collar Part Number
Pin Finish
Pin Part Number

* The Double Shear values shown are based on cross sectional area for nominal diameter pin.

DRAWN Van		DATE 6-11-68	TITLE HI-LOK® PIN 100° FLUSH MS20426 HEAD A-286 HIGH TEMPERATURE ALLOY 1/16" GRIP VARIATION - 1/32" OVERSIZE	
APPROVED J.M.		DATE 6-11-68	DRAWING NUMBER HL257	
REVISION (5)		DATE 8-7-92	D.P.S.	