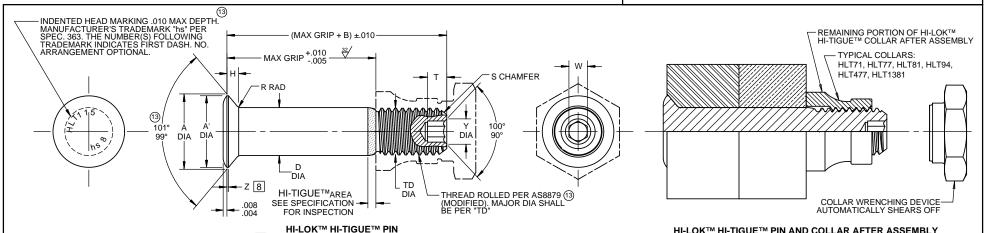
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

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SOCKET FIRST PIN **TENSION DOUBLE** THREAD D TD R В NOM CHAMFER DASH F W Т SHEAR POUNDS DIA н z REF MODIFIED DIA DIA DIA RAD NO. DIA MIN **REF** HEX DEPTH DIA **POUNDS** MINIMUM .2612 1635 .1595 .0410 .025 .1640-32 UNJC-3A .010 .0801 .100 5,250 5 5 5/32 .238 .312 .004 1/32 x 45° 2,000 2561 .1625 .1570 .0390 .005 .0791 .080 4,560

1

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

HI-LOK™ HI-TIGUE™ PIN AND COLLAR AFTER ASSEMBLY

6 3/10	3/16	.3016	.266 .325	325	.1895	.1840	1840 1810 .005	.0470	.030	1/32 x 45°	.1900-32 UNJF-3A	.015	.0806	.100	.119	7,050	2,600
	G, 1.0	.2966			.1885	.1810		.0449	.020			.005	.0791	.080	.104	6,125	
8 1/4	1/4	.3948	.359	.395	.2495	.2440	.006	.0610	.030	1/32 x 45°	.2500-28	.015	.0967	.110	.142	12,220	4,600
	1/4	.3898			.2485	.2410		.0589	.020		UNJF-3A	.005	.0947	.090	.122	10,600	4,600
10 5/16	5/16	.4739	.438	.500	.3120	.3060	.007	.0679	.040	3/64 x 45°	.3125-24 UNJF-3A	.015	.1295	.130	.180	19,110	7,000
	3/10	.4689			.3110	.3020		.0658	.030			.005	.1270	.110	.160	16,600	
12 3/8	2/0	.5604	.525	.545	.3745	.3680		.0780	.040	3/64 x 45°	.3750-24 UNJF-3A	.015	.1617	.160	.217	27,540	10,000
	3/0	.5554	.525	.545	.3735	.3640		.0759	.030			.005	.1582	.140	.197	23,900	
14 7/16	7/16	.6680	.616 .63	625	.4370	.4310	.009	.0969	.050	3/64 x 45°	.4375-20 UNJF-3A	.022	.1930	.190	.253	37,500	14,000
	7/10	.6620		.033	.4360	.4260		.0944	.040			.005	.1895	.170	.233	32,500	
16 1/2	1/2	.7540	.702	.685	.4995	.4930	.010	.1068	.050	3/64 x 45°	.5000-20 UNJF-3A	.022	.2242	.220	.289	49,000	17,800
	1/2	.7480	.702	.003	.4985	.4880		.1043	.040			.005	.2207	.200	.269	42,400	
18 9/16	0/16	.8380	.786	.770	.5615	.5550		.1160	.050	1/16 x 45°	.5625-18 UNJF-3A	.022	.2555	.260	.326	61,910	19,200
	9/16	.8310	.700	.770	.5605	.5500		.1131	.040			.005	.2520	.240	.306	53,700	
20	5/8	.9250	.873	.825	.6240	.6180	010	.1260	.050	1/16 x 45°	.6250-18	.022	.2555	.260	.326	76,450	24,700
		.9180	.013	.023	.6230	.6120		.1230	.040		UNJF-3A	.005	.2520	.240	.306	66,300	

GENERAL NOTES: 1 Head edge out of roundness shall not exceed "F".

- 2. Concentricity: Conical surface of head to "D" diameter within .005 FIM.
- 3. "H" is dimensioned from maximum "D" diameter.
- (13) 4. Dimensions are in inches and to be met after plating.
- 5 Evidence of broken edge across points.
- (13) 6. Surface texture per ASME B46.1.
 - 7. Hole preparation per NAS618.
- 8 Curved or flat edge manufacturer's option.
- 9. Use HLT123 for oversize replacement.

MATERIAL: Alloy steel per AMS6415, AMS6349 or AMS-S-6049.

HEAT TREAT: 108.000-125.000 psi shear (180.000 psi tensile minimum) per AMS-H-6875.

FINISH: HLT115-()-()

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

(3) HLT115TB()-() = Cadmium plate per AMS-QQ-P-416, Type III, Class 2, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LOK™ HI-TIGUE™ Product Specification 352.

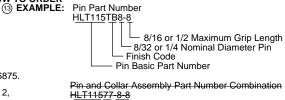
CODE: First dash number indicates nominal diameter in 1/32nds. Second dash number indicates maximum grip in 1/16ths.

See Finish note for explanation of code letters.

HOW TO ORDER

(13)

8



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

"HI-LOK", "HI-TIGUE", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION

RAWN BY	DATE	TITLE
D.P.S.	1977-02-15	HI-LOK™ HI-TIGUE™ PIN
		100° FLUSH CROWN SHEAR HEAD
PPROVED	DATE	ALLOY STEEL
R.TING	1977-02-15	
		1/16 GRIP VARIATION
REVISION	DATE	DRAWING NUMBER
(13)	M.BEARD	UI T445
(19)	2017-06-13	

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