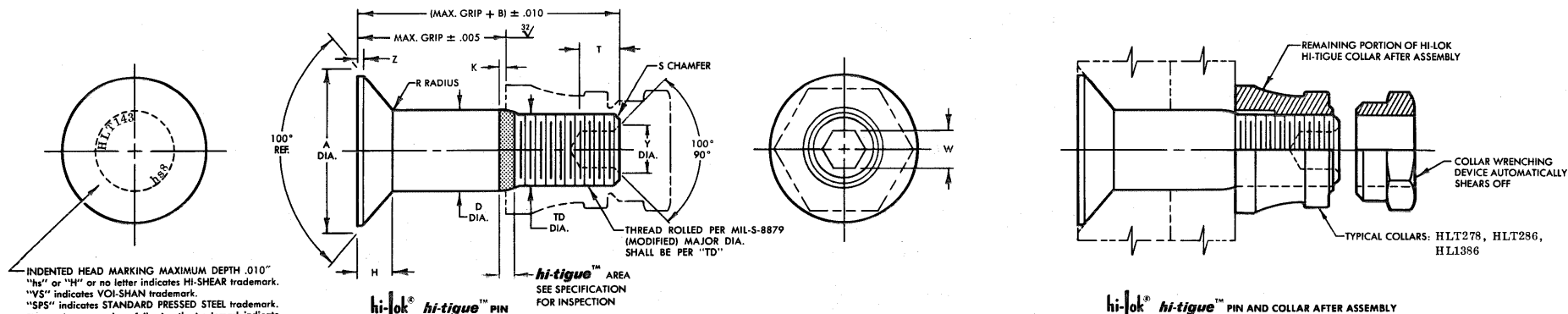


**STANDARDS COMMITTEE FOR
HI-LOK® HI-TIGUE™ PRODUCTS**
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

HI-SHEAR CORPORATION (Patent Holder) — Federal Code Ident. No. 73197
VOI-SHAN DIV., VSI CORP. (Licensee) — Federal Code Ident. No. 92215
STANDARD PRESSED STEEL CO. (Licensee) — Federal Code Ident. No. 56878



FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.		TD DIA.	F	H	K REF.	R RAD.	Z	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT HI-KOTE™ LUBE	WITH HI-KOTE™ LUBE									W HEX.	T DEPTH	Y DIA.		
— 5	3/16			NOTE: Use HLT43-6														
— 6	13/64	.3813 .3765	.360	.2026 .2021	.2026 .2016	.1840 .1810	.005	.0750 .0730	.020	.030 .020	.015 .005	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	6,130	2,750
— 8	17/64	.5066 .5018	.435	.2651 .2646	.2651 .2641	.2440 .2410	.006	.1013 .0993	.025	.030 .020	.015 .005	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	10,490	5,820
— 10	21/64	.6335 .6287	.545	.3276 .3271	.3276 .3266	.3060 .3020	.007	.1283 .1263	.031	.040 .030	.015 .005	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	16,000	9,200
— 12	25/64	.7604 .7556	.590	.3901 .3896	.3901 .3891	.3680 .3640	.008	.1553 .1533	.037	.040 .030	.015 .005	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	22,700	14,000
— 14	29/64	.8884 .8812	.690	.4526 .4521	.4526 .4516	.4310 .4260	.009	.1823 .1798	.039	.050 .040	.022 .005	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	30,600	18,900
— 16	33/64	1.0139 1.0068	.740	.5151 .5146	.5151 .5141	.4930 .4880	.010	.2093 .2063	.045	.050 .040	.022 .005	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	39,600	25,500
— 18	37/64	1.1408 1.1337	.825	.5771 .5766	.5771 .5761	.5550 .5500	.010	.2365 .2335	.043	.050 .040	.025 .005	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	49,700	32,400

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

- 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.
 - Surface texture per ANSI-46.1.
 - Hole preparation per NAS618.
 - Use HLT243 for oversize replacement.

MATERIAL: A-286 high temperature alloy per AMS5731.

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

FINISH: HLT143-()-() = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT143TC-()-() = Hi-Kote II except top surface of head shall be uncoated, 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 which HLT143 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
HLT143-8-8
8/16 or 1/2 Maximum Grip Length
Replaces 8/32 or 1/4 Nominal Diameter Pin
Pin Part Number

Pin and Collar Assembly Part Number Combination
HLT143286-8-8
Size and Grip Length, See Above Example
Collar Part Number
Pin Part Number

U. S. Patents 2,882,773; 2,947,491; 2,940,495; 3,027,789; 3,138,987; 3,578,367; design patent 1,91,883; other U.S. and Foreign patents granted and pending; property of Hi-Shear Corporation. "Hi-Lok" and "Hi-Tigue" are Registered Trademarks. "Hi-Kote" is a trademark of Hi-Shear Corporation.	
DRAWN VAN 6-12-72	DATE 6-12-72
APPROVED JG Wilcox 6-16-72	DATE 6-16-72
REVISION	DATE
hi-lok hi-tigue™ PIN 100° FLUSH MS24694 TENSION HEAD A-286 HIGH TEMPERATURE ALLOY 1/16" GRIP VARIATION - 1/64" OVERSIZE DRAWING NUMBER HLT143	