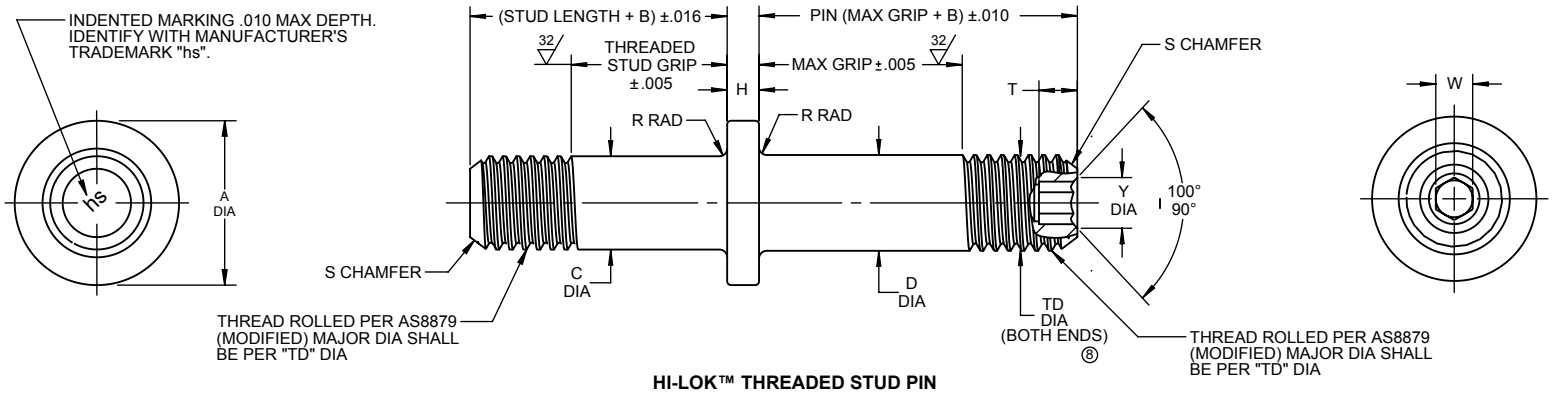
lisi AEROSPACE
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR Corporation, USA
a LISI AEROSPACE Company
Design Holder
CAGE No. 73197

For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at:
HTTP://WWW.LISI-AEROSPACE.COM/LICENSES



HI-LOK™ THREADED STUD PIN

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	C DIA WITHOUT COATING	C DIA WITH COATING	D DIA WITHOUT COATING	D DIA WITH COATING	TD DIA	H	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET W HEX	SOCKET T DEPTH	SOCKET Y DIA	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
6	13/64	.377 .357	.325	.1895 .1890	.1895 .1885	.2026 .2021	.2026 .2016	.1840 .1810	.074 .064	.025 .015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	6,130	3,180
8	17/16	.440 .415	.395	.2495 .2490	.2495 .2485	.2651 .2646	.2651 .2641	.2440 .2410	.087 .077	.025 .015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	10,490	5,820
10	21/64	.502 .472	.500	.3120 .3115	.3120 .3110	.3276 .3271	.3276 .3266	.3060 .3020	.108 .098	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	16,000	9,200
12	25/64	.565 .530	.545	.3745 .3740	.3745 .3735	.3901 .3896	.3901 .3891	.3680 .3640	.130 .120	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	22,700	14,000

GENERAL NOTES:
1. Concentricity: "A" to "D" diameter within .010 FIM. Threaded stud to "D" diameter within .005 FIM.
⑧ 2. Dimensions are in inches and to be met after finish.
⑧ 3. Surface texture per ASME B46.1.
4. Hole preparation per NAS618.
5. Use HL346 for oversize replacement.
[6] After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

MATERIAL: 6Al-4V titanium alloy per AMS4928 or AMS4967.

HEAT TREAT: 160,000 psi tensile minimum.

FINISH: HL246-( )-( )-( ) = Cetyl alcohol lube per Hi-Shear Spec. 305.
[6] HL246AP( )-( )-( ) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, 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 HL246 oversize pin replaces.
Second dash number indicates pin maximum grip in 1/16ths.
Third dash number indicates threaded stud grip in 1/16ths.
See Finish note for explanation of code letters.

HOW TO ORDER
⑧ **EXAMPLE:** Threaded Stud Pin Part Number
HL246AP8-8-8
- 8/16 or 1/2 Threaded Stud Grip
- 8/16 or 1/2 Maximum Grip Length
- Replaces 8/32 or 1/4 Nominal Diameter Pin
- Finish Code
- Pin Basic Part Number

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

DRAWN BY	DATE	TITLE
VAN	1970-07-16	HI-LOK™ THREADED STUD PIN PROTRUDING HEAD TITANIUM ALLOY 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED	DATE	
R.TING	1970-07-28	
REVISION	DATE	DRAWING NUMBER
8	F. CARINGELLA 2017-06-26	HL246 1 OF 1

HL246