

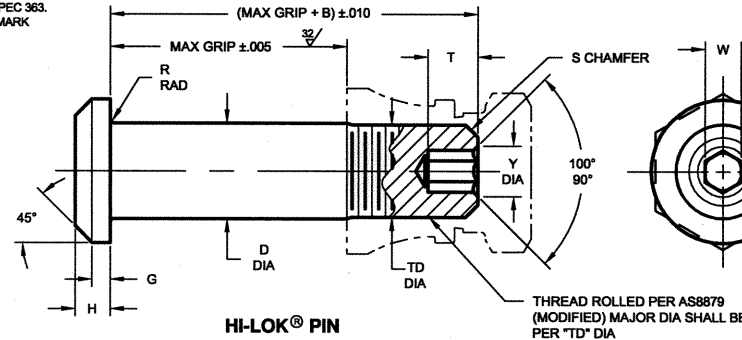
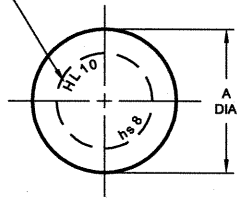
STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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

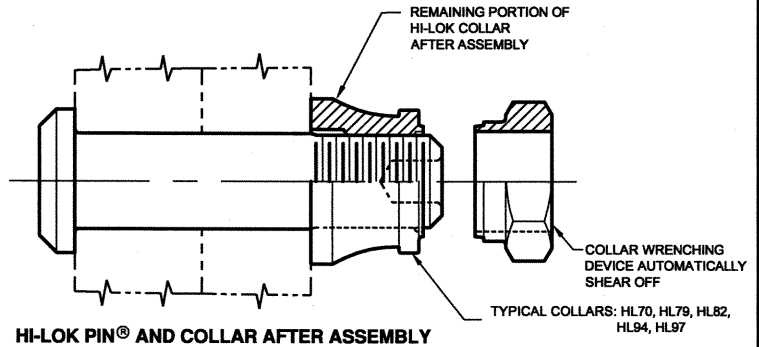
HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
a LSI AEROSPACE Company
AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A. & Canada) CAGE No. 06725
HUCK INTERNATIONAL, INC., U.S.A. (Licensee) CAGE No. 97928
SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56678
FAIRCHILD Aerospace Fastener Division (Licensee) CAGE No. 92215
WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516
(Pine & Steel Collars)

BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE No. 0LB68
a LSI AEROSPACE Company
HUCK S.A. France (Licensee - ECC Countries)
BLANC AERO S.A. France (Licensee - ECC Countries)
a LSI AEROSPACE Company
TOKYO SCREW COMPANY, Japan (Licensee - Japan)

INDENTED HEAD MARKING MAXIMUM DEPTH .010".
MANUFACTURER'S TRADEMARK "HL" PER SPEC 363.
THE NUMBER(S) FOLLOWING THE TRADEMARK
INDICATES FIRST DASH NUMBER.
ARRANGEMENT OPTIONAL.



HI-LOK® PIN



HI-LOK PIN® AND COLLAR AFTER ASSEMBLY

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

FIRST DASH NO.	PIN 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
				WITHOUT COATING OR SOLID FILM	WITH COATING OR SOLID FILM							W HEX	T DEPTH	Y DIA		
4	1/8	.240 .225	.294	.1375 .1370	.1375 .1365	.1335 .1310	.020	.042 .032	.020 .010	1/32" x 37°	6-32UNJC-3A Modified	.0645 .0635	.100 .085	9	2,840	1,350
5	5/32	.262 .242	.312	.1635 .1630	.1635 .1625	.1595 .1570	.020	.047 .037	.025 .015	1/32" x 37°	8-32UNJC-3A Modified	.0645 .0635	.135 .115	.090 .075	4,010	1,940
6	3/16	.315 .295	.325	.1895 .1890	.1895 .1885	.1840 .1810	.025	.055 .045	.025 .015	1/32" x 37°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	5,380	2,500
8	1/4	.412 .387	.395	.2495 .2490	.2495 .2485	.2440 .2410	.030	.069 .059	.025 .015	1/32" x 37°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	9,300	4,300
10	5/16	.505 .475	.500	.3120 .3115	.3120 .3110	.3060 .3020	.035	.078 .068	.030 .020	3/64" x 37°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	14,600	6,300
12	3/8	.600 .565	.545	.3745 .3740	.3745 .3735	.3680 .3640	.040	.088 .078	.030 .020	3/64" x 37°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	21,000	8,700
14	7/16	.676 .641	.635	.4370 .4365	.4370 .4360	.4310 .4260	.045	.105 .093	.030 .020	3/64" x 37°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	28,600	12,100
16	1/2	.770 .735	.685	.4995 .4990	.4995 .4985	.4930 .4880	.050	.115 .103	.030 .020	3/64" x 37°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	37,300	15,300
18	9/16	.864 .829	.770	.5615 .5610	.5615 .5605	.5550 .5500	.055	.127 .112	.040 .025	1/16" x 37°	9/16-18UNJF-3A Modified	.2555 .2520	.290 .270	.326 .306	47,200	19,000
20	5/8	.953 .918	.825	.6240 .6235	.6240 .6230	.6180 .6120	.060	.137 .122	.040 .025	1/16" x 37°	5/8-18UNJF-3A Modified	.2555 .2520	.330 .305	.326 .306	58,300	23,000
24	3/4	1.108 1.066	1.050	.7490 .7485	.7490 .7480	.7430 .7370	.070	.151 .136	.045 .030	1/16" x 37°	3/4-16UNJF-3A Modified	.3185 .3150	.395 .365	.398 .378	83,900	30,700
28	7/8	1.285 1.241	1.210	.8740 .8735	.8740 .8730	.8680 .8610	.090	.187 .172	.050 .035	5/64" x 37°	7/8-14UNJF-3A Modified	.3820 .3780	.455 .425	.471 .451	114,000	45,000
32	1	1.468 1.424	1.390	.9990 .9985	.9990 .9980	.9930 .9860	.110	.218 .203	.060 .045	5/64" x 37°	1-12UNJF-3A Modified	.5100 .5040	.580 .550	.618 .598	149,000	60,900

HL10

JFO-STD/HLPIN

"Hi-Lok" and "HL" are internationally registered trademark of Hi-Shear Corporation.		
DRAWN Brlej	DATE 11-26-62	TITLE HI-LOK® PIN PROTRUDING SHEAR HEAD TITANIUM 1/16 GRIP VARIATION
APPROVED Cessna	DATE 11-26-62	
REVISION 37	DATE J.F.O. 3-23-06	DRAWING NUMBER HL10

SHEET 1 OF 2

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

HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee) CAGE No. 0L86
 a LISI AEROSPACE Company
 HUCK S.A. France (Licensee - ECC Countries)
 BLANC AERO S.A. France (Licensee - ECC Countries)
 a LISI AEROSPACE Company
 TOKYO SCREW COMPANY, Japan (Licensee - Japan)

1. Concentricity: "A" to "D" diameter within .010 FIM.
2. Dimensions to be met after finish.
3. Surface texture per ANSI B46.1.
4. Hole preparation per NAS618.
5. Use HL110 for oversize replacement.
6. Maximum "D" diameter may be increased by .0002 to allow for solid film or aluminum coating application.
7. Dimensions to be met before finish for "VY" code only.
8. Broach petals removed.
9. Evidence of broken edge across points.

HEAT TREAT: 95,000 psi shear minimum.

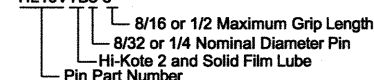
SPECIFICATION: Hi-Lok Product Specification 342.

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.

EXAMPLES:

Pin Part Number Only

HL10VTB8-8



Pin and Collar Assembly Part Number Combination

HL10VTB70-8-8

