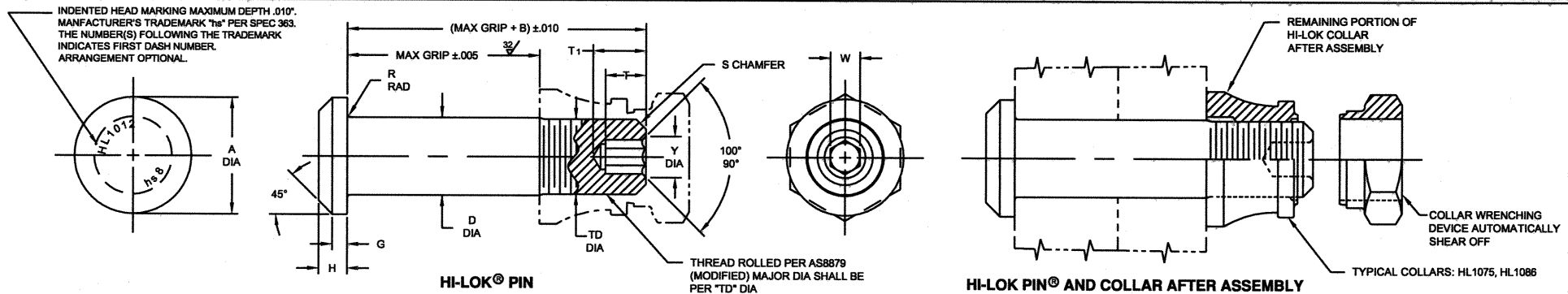


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197 a LISI AEROSPACE Company	BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE No. 0LB68 a LISI AEROSPACE Company
AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A. & Canada) CAGE No. 06725	HUCK S.A. France (Licensee - ECC Countries)
HUCK INTERNATIONAL, INC., U.S.A. (Licensee) CAGE No. 07928	BLANC AERO S.A. France (Licensee - ECC Countries)
SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878	a LISI AEROSPACE Company
FAIRCHILD Aerospace Fastener Division (Licensee) CAGE No. 32215	TOKYO SCREW COMPANY, Japan (Licensee - Japan)
WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516 (Pins & Steel Collars)	



FIRST DASH NO.	PIN NOM DIA	A DIA	B	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 LUBE	WITH COATING OR SOLID FILM LUBE							W HEX	T DEPTH	T1 DEPTH MAX	Y DIA		
5	5/32	.322 .306	.312	.1635 .1630	.1635 .1625	.1595 .1570	.030	.065 .055	.025 .015	1/32" x 37°	8-32UNJC-3A Modified	.0801 .0791	.100 .080	.140	[5]	4,010	2,180
6	3/16	.377 .357	.325	.1895 .1890	.1895 .1885	.1840 .1810	.035	.074 .064	.025 .015	1/32" x 37°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.140	.119 .104	5,380	3,180
8	1/4	.440 .415	.395	.2495 .2490	.2495 .2485	.2440 .2410	.045	.090 .080	.025 .015	1/32" x 37°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.160	.142 .122	9,300	5,820
10	5/16	.505 .475	.500	.3120 .3115	.3120 .3110	.3060 .3020	.055	.112 .102	.030 .020	3/64" x 37°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.200	.180 .160	14,600	9,200
12	3/8	.600 .565	.545	.3745 .3740	.3745 .3735	.3680 .3640	.075	.140 .130	.030 .020	3/64" x 37°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.235	.217 .197	21,000	14,000
14	7/16	.676 .641	.635	.4370 .4365	.4370 .4360	.4310 .4260	.095	.160 .150	.030 .020	3/64" x 37°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.280	.253 .233	28,600	18,900
16	1/2	.770 .735	.685	.4995 .4990	.4995 .4985	.4930 .4880	.095	.188 .178	.030 .020	3/64" x 37°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.320	.289 .269	37,300	25,600
18	9/16	.877 .842	.770	.5615 .5610	.5615 .5605	.5550 .5500	.125	.210 .200	.040 .025	1/16" x 37°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.360	.326 .306	47,200	32,400
20	5/8	.953 .905	.825	.6240 .6235	.6240 .6230	.6180 .6120	.140	.238 .228	.040 .025	1/16" x 37°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.400	.326 .306	58,300	41,000
24	3/4	1.150 1.110	1.050	.7490 .7485	.7490 .7480	.7430 .7370	.200	.335 .320	.045 .030	1/16" x 37°	3/4-16UNJF-3A Modified	.3185 .3150	.330 .300	.425	.398 .378	83,900	59,500

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

- GENERAL NOTES:**
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. Evidence of broken edge across points.
 6. Use HL1022 for oversize replacement.
 7. Broach petals removed.

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

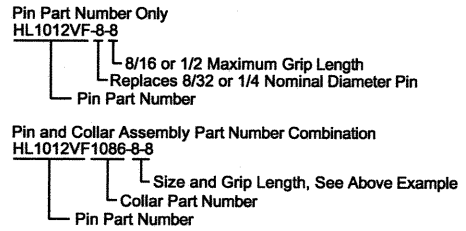
HEAT TREAT: 160,000 psi tensile minimum (95,000 psi shear minimum).

- FINISH:**
- HL1012(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL1012AZ(-)(-) = 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.
 - HL1012DK(-)(-) = Solid film lube per Kalgard FA.
 - HL1012GL(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 on threads only (no overspray is allowed on the shank) color code white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL1012RA(-)(-) = Phosphate fluoride treat with color red on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL1012VF(-)(-) = Surface coating per Hi-Shear Spec. 306, Type I, color blue and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL1012SY(-)(-) = Phosphate fluoride treat, solid film lube per AS5272, Type I, and color red on thread end.

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.

HOW TO ORDER EXAMPLE:



DRAWN DATE Van 11-2-73		TITLE HI-LOK® PIN PROTRUDING TENSION HEAD TITANIUM 1/16 GRIP VARIATION (SPECIAL SOCKET APPLICATION)
APPROVED DATE JG/Wilcox 11-2-73		DRAWING NUMBER HL1012
REVISION 12	DATE J.F.O. 10-25-06	

HL1012