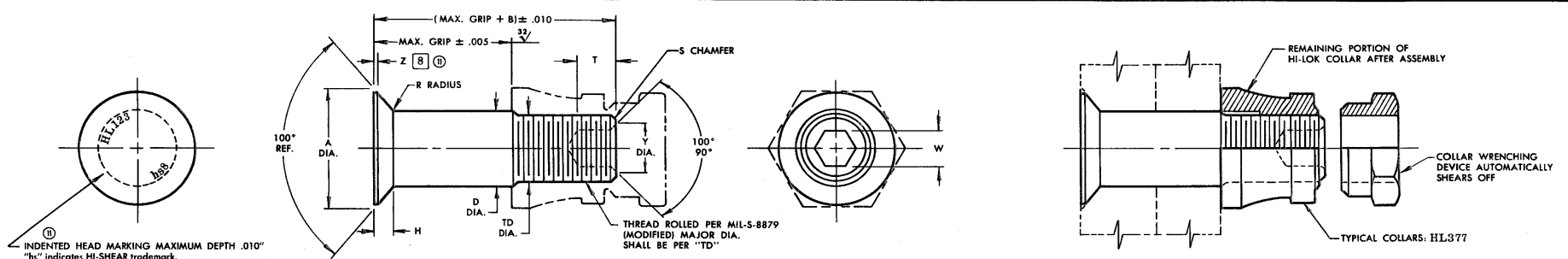


**STANDARDS COMMITTEE
FOR HI-LOK® PRODUCTS**
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90505

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) U.S. Federal Code I.D. No. 73197
 Division of Hi-Shear Industries Inc.
 VOI-SHAN, Division of VSI Corp., U.S.A. (Licensee) U.S. Federal Code I.D. No. 92215
 SPS TECHNOLOGIES, U.S.A. (Licensee) U.S. Federal Code I.D. No. 58878
 LITTON FASTENING SYSTEMS, U.S.A. (Licensee) U.S. Federal Code I.D. No. 97928
 KAMAX-WERKE, Germany (Licensee)
 Rudolph Kellerman GmbH & Co.
 ST. CHAMOND-GRANAT, S.A. France (Licensee)
 TOKYO SCREW COMPANY, Japan (Licensee)



INDENTED HEAD MARKING MAXIMUM DEPTH .010"
 "hs" indicates HI-SHEAR trademark.
 "VS" indicates VOI-SHAN trademark.
 "SPS" indicates STANDARD PRESSED STEEL trademark.
 The number(s) following the trademark indicate first dash number. Arrangement optional.

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.	TD DIA.	F	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
												W HEX.	T DEPTH	Y DIA.		
-5	11/64	.2922 .2874	.312	.1770 .1760	.1595 .1570	.004	.0483 .0463	.025 .015	.010	1/32" x 45°	8-32UNJC-3A Modified	.0645 .0635	.135 .115	.090 .075	2,200	860
-6	13/64	.3536 .3486	.325	.2028 .2016	.1840 .1810	.005	.0633 .0612	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	2,900	1,150
-8	17/64	.4732 .4682	.395	.2651 .2641	.2440 .2410	.006	.0873 .0852	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	5,000	2,000
-10	21/64	.5619 .5569	.500	.3276 .3266	.3060 .3020	.007	.0983 .0962	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	7,600	2,800
-12	25/64	.6912 .6862	.545	.3901 .3891	.3680 .3640	.008	.1263 .1242	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	10,800	3,900
-14	29/64	.8041 .7969	.635	.4526 .4516	.4310 .4260	.009	.1475 .1445	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .235	14,500	6,000
-16	35/64	.9166 .9095	.685	.5151 .5141	.4930 .4880	.010	.1685 .1655	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	18,800	7,600

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" dimensioned from maximum "D" diameter.
 - Dimensions to be met after finish.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - Use HL259 for oversize replacement.
 - Curved or flat edge manufacturer's option.

MATERIAL: 7075-T6 aluminum alloy per Spec. QQ-A-225/9 or QQ-A-430.

HEAT TREAT: Age to T6 condition per MIL-H-6088.

FINISH: HL123-()-() = Anodize per Spec. MIL-A-8625, dye color natural, and cetyl alcohol lubricant per Hi-Shear Spec. 305.
 HL123D-()-() = Anodize per MIL-A-8625 and solid film lubricant per MIL-L-8937.

SPECIFICATION: Hi-Lok Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds which HL123 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
 HL123D-8-8
 8/16 or 1/2 Maximum Grip Length
 Replaces 8/32 or 1/4 Nominal Diameter Pin
 Solid Film Lubricant
 Pin Part Number

Pin and Collar Assembly Part Number Combination
 HL123D377-8-8
 Size and Grip Length, See Above Example
 Collar Part Number
 Pin Finish
 Pin Part Number

* * The double shear values shown are based on cross sectional area for nominal diameter pin.

U.S. patent: 2,927,491; 2,940,495; 3,027,789; 3,138,987. Other U.S. and Foreign patents granted and pending. "Hi-Lok" and "HL" are Registered Trademarks of Hi-Shear Corporation.	
DRAWN Brlej	DATE 3-22-63
APPROVED Cessna	DATE 3-22-63
REVISION 11	DATE 5-14-80
100° FLUSH MS20426 SHEAR HEAD ALUMINUM ALLOY 1/16" GRIP VARIATION - 1/64" OVERSIZE	
DRAWING NUMBER HL123	

HL123