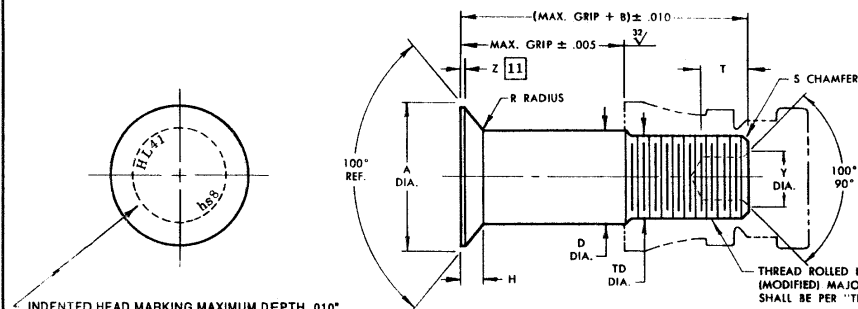


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

2600 Skypark Drive, Torrance, California U.S.A. 90509

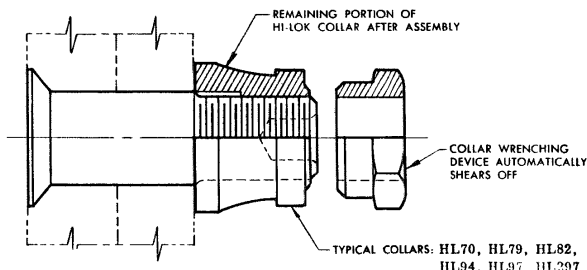
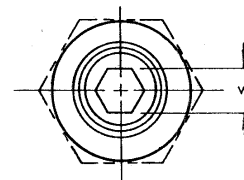
HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
 Division of Hi-Shear Industries Inc., U.S.A.
 AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S. & Canada) CAGE No. 06725
 HUCK INTERNATIONAL, INC., Deutsch Operation, U.S.A. (Licensee) CAGE No. 97928
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56676
 FAIRCHILD Aerospace Fastener Division, U.S.A. (Licensee) CAGE No. 92216
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516
 (Pins & Steel Collars)

HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee) CAGE No. 0LB88
 Division of Hi-Shear Industries Inc., U.S.A.
 HUCK INTERNATIONAL GMBH & CO., Germany (Licensee - EEC Countries)
 SAINT CHAMOND GRANAT, S.A. France (Licensee - EEC Countries)
 SIMMONDS S.A. France (Licensee - EEC Countries-Collars)
 TOKYO SCREW COMPANY, Japan (Licensee - Japan)



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

HI-LOK® PIN



HI-LOK® PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA. [8]		TD DIA.	F	H REF.	R RAD.	Z MAX	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT SOLID FILM LUBE	WITH SOLID FILM LUBE								W HEX	T DEPT H	Y DIA.		
4	1/8	.2219 .2171	.294	.1375 .1370	.1375 .1365	.1335 .1310	.003	.0354 .0334	.020 .010	.010	1/32" x 45°	6-32UNJC-3A Modified	.0645 .0635	.100 .085	[10]	2,840	950
5	5/32	.2612 .2564	.312	.1635 .1630	.1635 .1625	.1595 .1570	.004	.0410 .0390	.025 .015	.010	1/32" x 45°	8-32UNJC-3A Modified	.0801 .0791	.135 .115	[10]	4,010	1,750
6	3/16	.3016 .2966	.325	.1895 .1890	.1895 .1885	.1840 .1810	.005	.0470 .0449	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	5,380	2,000
8	1/4	.3948 .3898	.395	.2495 .2490	.2495 .2485	.2440 .2410	.006	.0610 .0589	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	9,300	3,700
10	5/16	.4739 .4689	.500	.3120 .3115	.3120 .3110	.3060 .3020	.007	.0679 .0758	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	14,600	5,500
12	3/8	.5604 .5554	.545	.3745 .3740	.3745 .3735	.3680 .3640	.008	.0780 .0759	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	21,000	7,200
14	7/16	.6680 .6620	.635	.4370 .4365	.4370 .4360	.4310 .4260	.009	.0969 .0944	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	28,600	10,000
16	1/2	.7540 .7480	.685	.4995 .4990	.4995 .4985	.4930 .4880	.010	.1068 .1043	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	37,300	13,500
18	9/16	.8380 .8310	.770	.5615 .5610	.5615 .5605	.5550 .5500	.010	.1160 .1131	.050 .040	.025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.290 .270	.326 .306	47,200	17,000
20	5/8	.9250 .9180	.825	.6240 .6235	.6240 .6230	.6180 .6120	.010	.1260 .1230	.050 .040	.025	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.330 .305	.326 .306	58,300	21,000
24	3/4	1.0970 1.0850	1.050	.7490 .7485	.7490 .7480	.7430 .7370	.012	.1460 .1410	.050 .040	.025	1/16" x 45°	3/4-UNJF-3A Modified	.3185 .3150	.395 .365	.398 .378	83,900	30,700

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.
- Non-tubed pins must be used with lubed collars.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- Maximum "D" diameter may be increased by .0002 to allow for solid film application.
- Use HL141 for oversize replacement.
- Evidence of broken edge across points.
- Curved or flat edge manufacturer's option.
- Broach petals removed.
- A-286 high temperature alloy per Spec. AMS5737 or AMS5731.
- 95,000 psi shear minimum at 70°F.
- HL41(-)(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL41DL(-)(-) = Kalgard FA or EM620C solid film lube per MIL-L-46010, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL41DU(-)(-) = Solid film lube per MIL-L-46010, Type I.
- HL41GU(-)(-) = Silver plate per AMS2410.
- HL41K(-)(-) = Solid film lubricant per Lubeco 905.
- HL41PY(-)(-) = Passivate per Hi-Shear Spec. 258.
- HL41TF(-)(-) = Hi-Kote 2 solid film per Hi-Shear Spec. 292.
- HL41V(-)(-) = Solid film lubricant per Lubeco 2123, Type II.

MATERIAL:
 HEAT TREAT:
 FINISH:

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 EXAMPLES:

Pin Part Number Only
 HL41-8-8
 8/16 or 1/2 Maximum Grip Length
 8/32 or 1/4 Nominal Diameter Pin
 Pin Part Number

Pin and Collar Assembly Part Number Combination
 HL41V79-8-8
 Size and Grip Length, See Above Example
 Collar Part Number
 Pin Finish
 Pin Part Number

"Hi-Lok" and "HL" are internationally registered trademarks of Hi-Shear Corporation.		
DRAWN	DATE	TITLE
C.E.K.	10-17-62	HI-LOK® PIN
APPROVED	DATE	100° FLUSH SHEAR HEAD
M.E.C.	10-17-62	A-286 HIGH TEMPERATURE ALLOY
		1/16" GRIP VARIATION
REVISION	DATE	DRAWING NUMBER
(25)	J.F. Obispo 7-03-96	HL41

HL41