

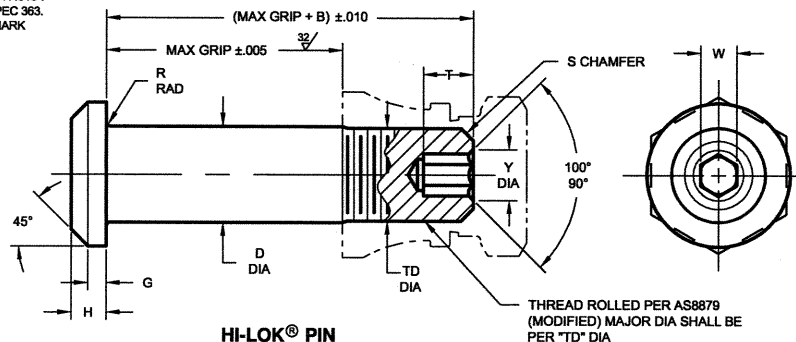
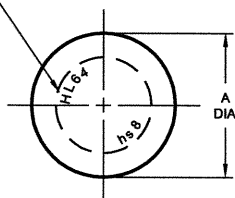
STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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

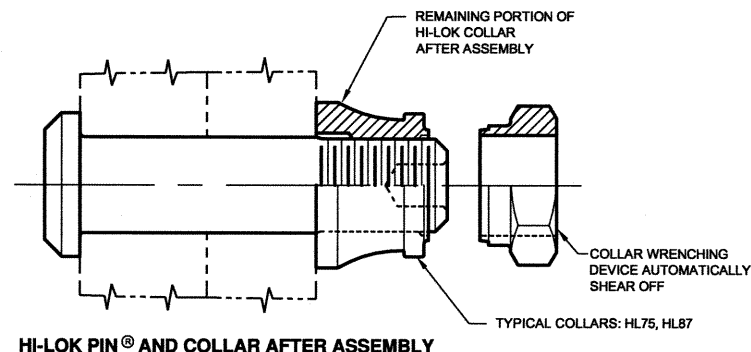
⑦ HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
a LISI AEROSPACE Company
AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A. & Canada) CAGE No. 06725
HUCK INTERNATIONAL, INC., U.S.A. (Licensee) CAGE No. 97928
SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878
FAIRCHILD Aerospace Fastener Division (Licensee) CAGE No. 92215
WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516
(Pins & Steel Collars)

BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE No. 0LB68
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)

INDENTED HEAD MARKING MAXIMUM DEPTH .010".
MANUFACTURER'S TRADEMARK "hs" 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

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
											W HEX	T DEPTH	Y DIA		
5							NOTE: USE HL20-6(-) or HL420-6(-)								
6	13/64	.377 .357	.325	.2026 .2016	.1840 .1810	.035	.074 .064	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	6,130	3,180
8	17/64	.440 .415	.395	.2651 .2641	.2440 .2410	.045	.090 .077	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	10,490	5,820
10	21/64	.502 .472	.500	.3276 .3266	.3060 .3020	.055	.112 .098	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	16,000	9,200
12	25/64	.565 .530	.545	.3901 .3891	.3680 .3640	.065	.140 .130	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	22,700	14,000
14	29/64	.627 .592	.635	.4526 .4516	.4310 .4260	.075	.160 .150	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	30,600	18,900
16	33/64	.752 .717	.685	.5151 .5141	.4930 .4880	.085	.188 .178	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	39,600	25,600
18	37/64	.877 .842	.770	.5771 .5761	.5550 .5500	.125	.210 .200	.040 .025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.290 .270	.326 .306	49,700	32,400
20	41/64	.953 .918	.825	.6396 .6386	.6180 .6120	.140	.238 .228	.040 .025	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.330 .305	.326 .306	61,000	41,000
24	49/64	1.150 1.110	1.050	.7646 .7636	.7430 .7370	.200	.335 .320	.045 .030	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.395 .365	.398 .378	87,200	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 plating.
3. Surface texture per ANSI B46.1.
4. Hole preparation per NAS618.
5. Non-lubed pins must be used with sealant or lubed collars.
6. Evidence of broken edge across points.
7. Use HL220 for oversize replacement.

CODE:

First dash number indicates nominal diameter in 1/32nds which HL64 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See Finish note for explanation of code letters.

HOW TO ORDER EXAMPLE:

Pin Part Number Only
HL64PB8-8

8/16 or 1/2 Maximum Grip Length
Replaces 8/32 or 1/4 Nominal Diameter Pin
Type II Cadmium Plate
Pin Basic Part Number

Pin and Collar Assembly Part Number Combination
HL64PB86-8-8

Size and Grip Length, See Above Example
Collar Part Number
Pin Finish
Pin Basic Part Number

MATERIAL:

Alloy steel per AMS6415, AMS6349 or AMS-S-6049.

HEAT TREAT:

160,000 - 180,000 psi tensile per AMS-H-6875.

FINISH:

- HL64(-)(-) = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL64A(-)(-) = Cadmium plate per AMS2400-3 and cetyl alcohol lube per Hi-Shear Spec. 305.
HL64PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL64PN(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
HL64RB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, color violet to purple, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION:

Hi-Lok Product Specification 342.

HL64

JFO-STD/HLPIN

"Hi-Lok" and "HL" are internationally registered trademark of Hi-Shear Corporation.			
DRAWN	DATE	TITLE	
Brlj	7-29-64	HI-LOK® PIN PROTRUDING TENSION HEAD ALLOY STEEL, 1/64" OVERSIZE 1/16 GRIP VARIATION	
APPROVED	DATE		
Cessna	7-30-64		
REVISION	DATE	DRAWING NUMBER	
⑦	JMO 12-1-04	HL64	

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SHEET 1 OF 1