lisi AEROSPACE
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR CORPORATION, U.S.A. (Patent Holder)	CAGE No. 73197	BLANC AERO INDUSTRIES RUGBY (Licensee)	CAGE No. U6300
a LISI AEROSPACE Company		a LISI AEROSPACE Company	
AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A & Canada)	CAGE No. 06725	BLANC AERO S.A. France (Licensee)	CAGE NO. F018B
ALCOA FASTENING SYSTEMS, U.S.A. (Licensee)	CAGE No. t5653	a LISI AEROSPACE Company	
SPS TECHNOLOGIES, U.S.A. (Licensee)	CAGE No. 56878	LISI AEROSPACE CANADA (Licensee)	CAGE No. L4528
WEST COAST AEROSPACE INC., U.S.A. (Licensee) (Pins & Steel Collars)	CAGE No. 60516	a LISI AEROSPACE Company	
MINEBEA CO., LTD. Japan (Licensee-Japan)		FT BESTAS, Izmer (Licensee)	CAGE No. T0802
		a LISI AEROSPACE Company	

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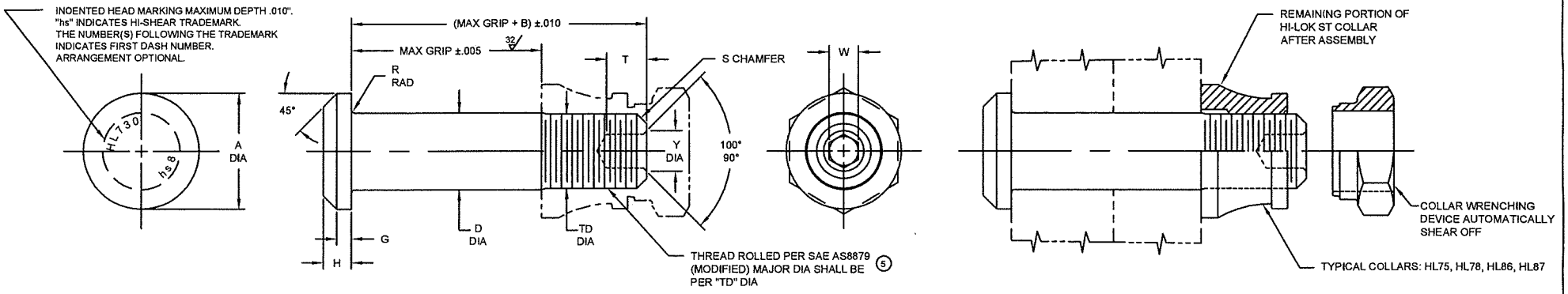

HI-LOK® PIN **HI-LOK PIN® AND COLLAR AFTER ASSEMBLY**

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA Without Plating or Coating	D DIA With Plating or Coating	TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD	SOCKET W HEX	SOCKET T DEPTH	SOCKET Y DIA	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
5	5/32	.322 .306	.312	.1635 .1630	.1635 .1625	.1595 .1570	.030	.065 .055	.025 .015	1/32" x 45°	8-32UNJC-3A Modified	.0801 .0791	.135 .115	[5]	5,280	2,940
6	3/16	.377 .357	.325	.1895 .1890	.1895 .1885	.1840 .1810	.035	.074 .064	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	7,060	4,350
8	1/4	.440 .415	.395	.2495 .2490	.2495 .2485	.2440 .2410	.045	.090 .080	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	12,260	7,750
10	5/16	.505 .475	.500	.3120 .3115	.3120 .3110	.3060 .3020	.055	.112 .102	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	19,160	12,300
12	3/8	.600 .565	.545	.3745 .3740	.3745 .3735	.3680 .3640	.075	.140 .130	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	27,600	19,100
14	7/16	.676 .641	.635	.4370 .4365	.4370 .4360	.4310 .4260	.095	.160 .150	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	37,500	25,800
16	1/2	.770 .735	.685	.4995 .4990	.4995 .4985	.4930 .4880	.095	.188 .178	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	49,100	34,300

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 HL938 for oversized replacement.

MATERIAL: Nickel base alloy per AMS5662.

HEAT TREAT: 125,000 psi shear minimum (210,000 psi tensile minimum).

FINISH:
HL730-( )-( ) = Passivate per HI-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
HL730AP-( )-( ) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
HL730JT-( )-( ) = Passivate per Hi-Shear Spec. 258, with light blue Identification on top of head, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL730PB-( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

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:

Pin Part Number Only
HL730PB8-8
- 8/16 or 1/2 Maximum Grip Length
- 8/32 or 1/4 Nominal Diameter Pin
- Cadmium Plating
- Pin Part Number

Pin and Collar Assembly Part Number Combination
HL730PB75-8-8
- Size and Grip Length, See Above Example
- Collar Part Number
- Pin Part Number

"Hi-Lok" and "HL" are internationally registered trademark of Hi-Shear Corporation.

DRAWN	DATE	TITLE
D.P.S	3-4-83	**HI-LOK® PIN**
APPROVED	DATE	PROTRUDING TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16" GRIP VARIATION
R.Ting	3-4-83	
REVISION	DATE	DRAWING NUMBER
(5)	LGV 5-19-2009	**HL730**

HL730