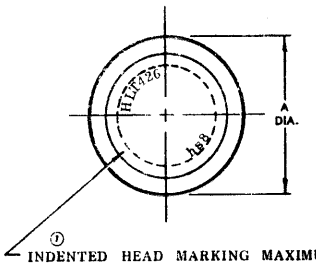
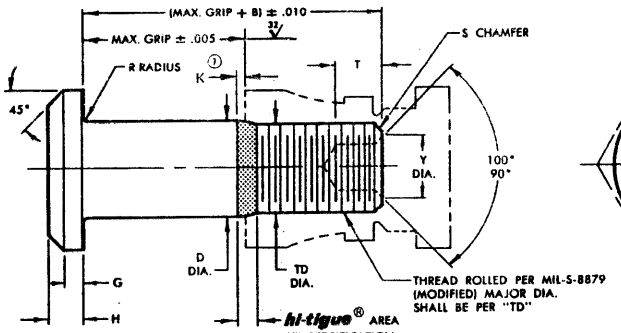
CORPORATION, U.S.A. _____ (Patent Holder) _____ U.S. Federal Code I.D. No. 73197
of Hi-Shear Industries Inc., U.S.A.
FASTENERS (Forged Parts) LTD., U.K. _____ (Licensee)
Division of Hi-Shear Industries Inc., U.S.A.
Allfast, Division of VSI Corp., U.S.A. _____ (Licensee) _____ U.S. Federal Code I.D. No. 92215
SPS TECHNOLOGIES, U.S.A. _____ (Licensee) _____ U.S. Federal Code I.D. No. 56878

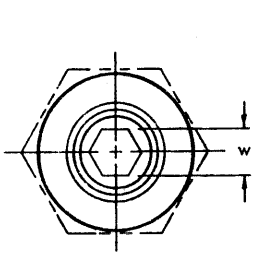
ST. CHAMOND-GRANAT, S.A.F.
KAMAX-WERKE, Germany
Rudolph Kellerman Gmelt & Co.
SIMMONDS, S.A. France
TOKYO SCREW COMPANY, Japan
WEST COAST AEROSPACE INC., U.S.A.
U.S. Federal Code I.D. No. 60516

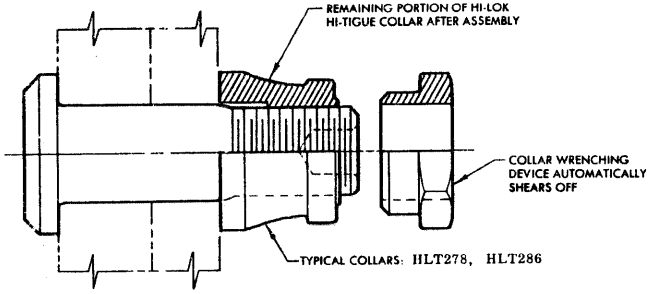


① INDENTED HEAD MARKING MAXIMUM DEPTH .010". Manufacturer's trademark per Hi-Shear Spec. 363. The number(s) following the trademark indicate first dash number. Arrangement optional.



hi-lok® hi-tigue® PIN





hi-lok® hi-tigue® PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.		D DIA.	TD DIA.	G REF.	H	K REF.	R RAD.	S CHAMFER REF.	THREAD	SOCKET W HEX.	SOCKET T DEPTH	SOCKET Y DIA.	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
–5	3/16				① NOTE: Use HL326-6												
–6	13/64	.377 .357	.360		.2026 .2016	.1840 .1810	.035	.074 .064	.020	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	6,130	2,750
–8	17/64	.440 .415	.435		.2651 .2641	.2440 .2410	.045	.090 .080	.025	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	10,490	5,820
–10	21/64	.505 .475	.545		.3276 .3266	.3060 .3020	.055	.112 .102	.031	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	16,000	9,200
–12	25/64	.600 .530	.590		.3901 .3891	.3680 .3640	.075	.140 .130	.037	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	22,700	14,000
–14	29/64	.676 .592	.690		.4526 .4516	.4310 .4260	.095	.160 .150	.039	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	30,600	18,900
–16	33/64	.770 .717	.740		.5151 .5141	.4930 .4880	.095	.188 .178	.045	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	39,600	25,500
–18	37/64	.877 .842	.825		.5771 .5761	.5550 .5500	.125	.210 .200	.043	.040 .025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	49,700	32,400

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

GENERAL NOTES:
1. Concentricity: "A" to "D" diameter within .010 FIR.
2. Dimensions to be met after plating.
3. Surface texture per ANSI B46.1.
4. Hole preparation per NAS618.
5. Use HLT626 for oversize replacement.

MATERIAL: Alloy steel per Spec. MIL-S-5000, MIL-S-5626 or MIL-S-6049.

HEAT TREAT: 160,000—180,000 psi tensile per Spec. MIL-H-6875.

FINISH: HLT426-( )-( ) = Cadmium plate per Spec. QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT426TB-( )-( ) = Cadmium plate per QQ-P-416, Type II, Class 2; Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lok Hi-Tigue Product Specification 342.

① CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HLT426 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
HLT426-8-8
- 8/16 or 1/2 Maximum Grip Length
- Replaces 8/32 or 1/4 Nominal Diameter Pin
- Pin Part Number

Pin and Collar Assembly Part Number Combination
HLT426286-8-8
- Size and Grip Length, See Above Example
- Collar Part Number
- Pin Part Number

U.S. Patent 3,578,367 and international patents. "HL", "Hi-Lok", "HLT", and "Hi-Tigue" are internationally registered trademarks of Hi-Shear Corporation.

DRAWN	DATE	hi-lok® hi-tigue® PIN
Van	6-21-69	PROTRUDING TENSION HEAD
APPROVED	DATE	ALLOY STEEL
V. Miller	6-21-69	1/16" GRIP VARIATION — 1/64" OVERSIZE
REVISION ⑦	DATE D.P.S. 11-3-87	DRAWING NUMBER HLT426

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CODE IDENTIFICATION NO. 73197

HLT426