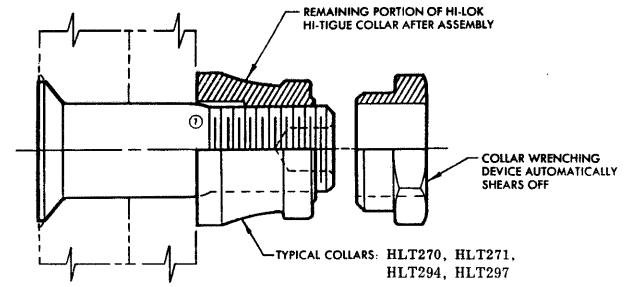
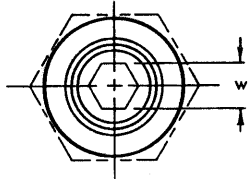
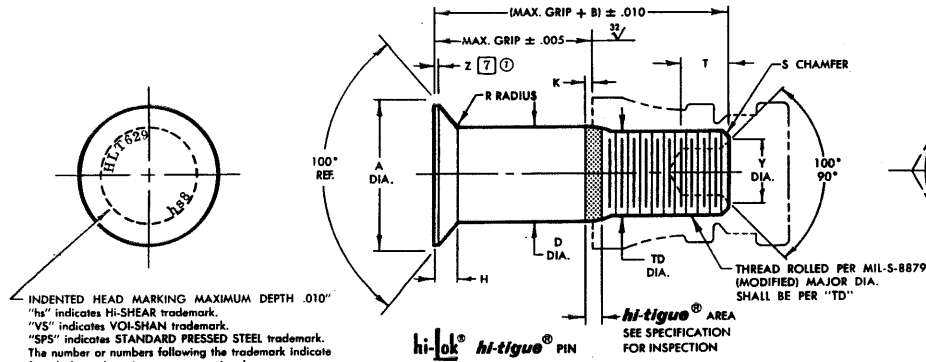


**STANDARDS COMMITTEE FOR
HI-LOK® HI-TIGUE® PRODUCTS**
2800 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

HI-SHEAR LUBRICANTS, U.S.A. (Licenses) U.S. Federal Code I.D. No. 73181
 Division of HI-Shear Industries Inc., U.S.A. (Licensee)
 AIRCRAFT FASTENERS (Forged Parts) LTD., U.K. (Licensee)
 Division of HI-Shear Industries Inc., U.S.A. (Licensee)
 VOI-SHAN, Division of VSI Corp., U.S.A. (Licensee) U.S. Federal Code I.D. No. 32215
 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. 97828
 Division of Litton Systems Inc., U.S.A. (Licensee)
 S. CHAMUNU-SHANAI, S.A. France (Licensee—EEC Countries)
 KAMAX-WERKE, Germany (Licensee—EEC Countries)
 Rudolph Kellerman GmbH & Co. (Licensee—EEC Countries—Collars)
 SHIMONDS, S.A. France (Licensee—EEC Countries—Collars)
 TOKYO SCREW COMPANY, Japan (Licensee—Japan)
 WEST COAST AEROSPACE INC., U.S.A. (Licensee—Oversize Pins & Steel Collars)
 U.S. Federal Code I.D. No. 60516



FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.	TD DIA.	F	H	K REF.	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	
													W HEX.	T DEPTH	Y DIA.			
- 5	3/16			NOTE: Use HL329-6														
- 6	7/32	.3303 .3253	.360	.2182 .2172	.1840 .1810	.005	.0470 .0449	.022	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	8,070	2,340	
- 8	9/32	.4260 .4210	.435	.2807 .2797	.2440 .2410	.006	.0610 .0589	.027	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	13,400	4,200	
- 10	11/32	.5051 .5001	.545	.3432 .3422	.3060 .3020	.007	.0679 .0658	.032	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	20,000	6,500	
- 12	13/32	.5916 .5866	.590	.4057 .4047	.3680 .3640	.008	.0780 .0759	.036	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	28,000	9,230	
- 14	15/32	.6992 .6932	.690	.4682 .4672	.4310 .4260	.009	.0969 .0944	.035	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	37,200	13,200	
- 16	17/32	.7852 .7792	.740	.5307 .5297	.4930 .4880	.010	.1068 .1043	.045	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	47,700	16,800	
- 18	19/32	.8692 .8622	.825	.5927 .5917	.5550 .5500	.010	.1160 .1131	.041	.050 .040	.022	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	59,600	19,000	

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 FTR.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions to be met after plating.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - Curved or flat edge manufacturer's option.

CODE: First dash number indicates nominal diameter in 1/32nds which HLT629 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
HLT629-8-8
 — 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
HLT629270-8-8
 — Size and Grip Length, See Above Example
 — Collar Part Number
 — Pin Part Number

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

HEAT TREAT: 108,000 psi shear minimum (180,000—200,000 psi tensile per Spec. MIL-H-6875).

FINISH: HLT629-()-() = Cadmium plate per Spec. QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT629TB-()-() = 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. 304.

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

U.S. patents 3,390,906; 3,578,367; and foreign patents. "Hi-Lok," "Hi-Tigue," and "HLT" are Registered Trademarks of Hi-Shear Corporation.	
DRAWN VAN DATE 6-24-69	DATE 6-24-69
APPROVED DATE 6-24-69	DATE 6-24-69
REVISION DATE 10-6-83	DATE 10-6-83
<p align="center">hi-lok® hi-tigue® PIN</p> <p align="center">100° FLUSH SHEAR HEAD ALLOY STEEL 1/16" GRIP VARIATION - 1/32" OVERSIZE</p> <p align="center">DRAWING NUMBER HLT629</p>	

HLT629