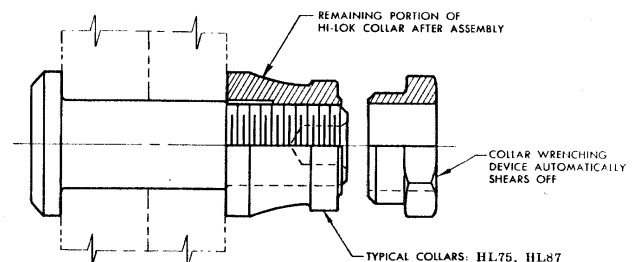
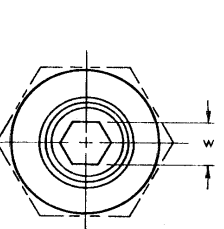
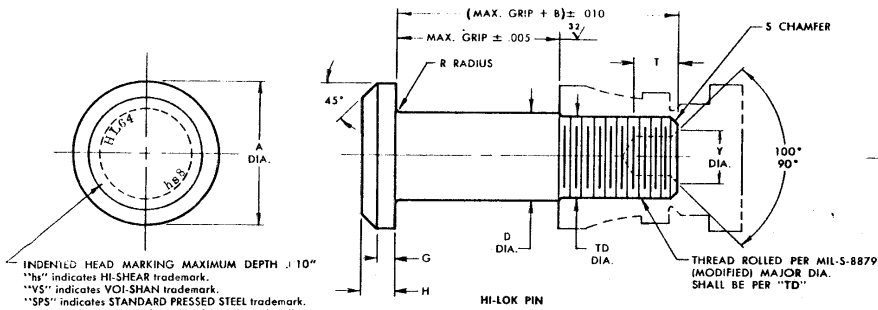


**STANDARDS COMMITTEE
FOR HI-LOK® PRODUCTS**
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

① HI-SHEAR CORPORATION, U.S.A. (Patent Holder) U.S. Federal Code I.D. No. 73197
 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 VOI 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. 96878
 LITTON FASTENING SYSTEMS, U.S.A. (Licensee) U.S. Federal Code I.D. No. 97828
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 ST. CHAMOND-GRANAT, S.A. France (Licensee—EEC Countries)
 KAMAX-WERKE, Germany (Licensee—EEC Countries)
 Rudolph Kellerman GmbH & Co. (Licensee—EEC Countries—Collars)
 SIMMONDS, 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. 60518



FIRST DASH NO.	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 .520	.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	.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 FIR.
 2. Dimensions to be met after plating.
 3. Non-lubed pins must be used with wet sealant or with lubed collars.
 4. Surface texture per ANSI B46.1.
 5. Hole preparation per NAS618.
 6. Use HL220 for oversize replacement.

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

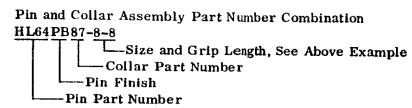
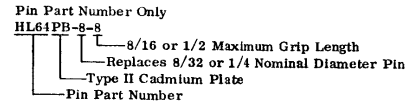
HEAT TREAT: 160,000—180,000 psi tensile per Spec. MIL-H-6875.

- ④ FINISH: HL64-()-() = Cadmium plate per Spec. 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 Spec. QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL64PN-()-() = Cadmium plate per Spec. QQ-P-416, Type II, Class 2 (see Note 3).

SPECIFICATION: Hi-Lok Product Specification 342.

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 the "Finish" note for explanation of code letters.

HOW TO ORDER
EXAMPLES:



U.S. patents 3,390,906, and foreign patents. "Hi-Lok" and "HL" are Registered Trademarks of Hi-Shear Corporation.

DRAWN	DATE	 PROTRUDING TENSION HEAD ALLOY STEEL 1/16" GRIP VARIATION - 1/64" OVERSIZE
Brlej	7-29-64	
APPROVED	DATE	
Cessna	7-30-64	
REVISION	DATE	DRAWING NUMBER
①	D, P, S, 1-11-85	HL64

HL64