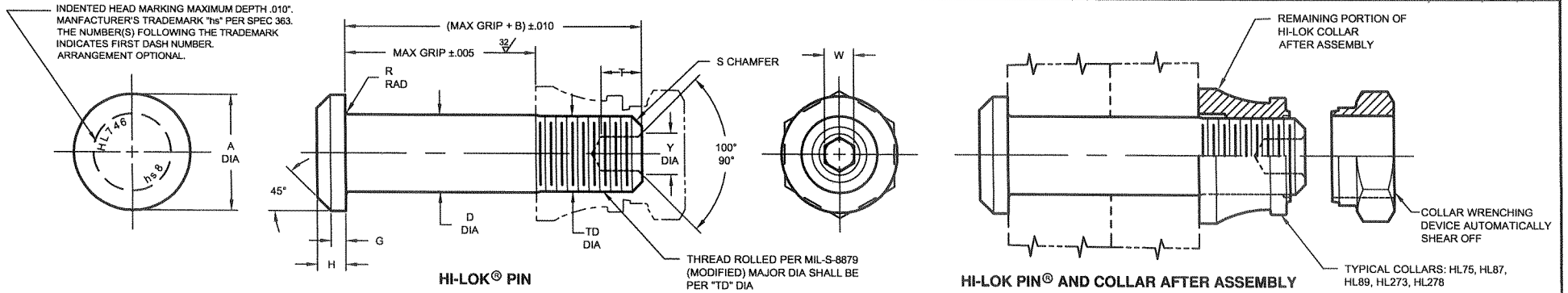


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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

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. 56678
 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)



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
				WITHOUT COATING PLATING, S.F.L.	AFTER COATING PLATING, S.F.L.							W HEX	T DEPTH	Y DIA		
5	3/16															
NOTE: USE HL646-6 ()																
6	13/64	.377 .357	.325	.2026 .2021	.2026 .2016	.1840 .1810	.035	.074 .064	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	8,100	4,350
8	17/64	.440 .415	.395	.2651 .2646	.2651 .2641	.2440 .2410	.045	.090 .080	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	13,800	7,750
10	21/64	.505 .475	.500	.3276 .3271	.3276 .3266	.3060 .3020	.055	.112 .102	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	21,100	12,300
12	25/64	.600 .565	.545	.3901 .3896	.3901 .3891	.3680 .3640	.075	.140 .130	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	30,000	19,100
14	29/64	.676 .641	.635	.4526 .4521	.4526 .4516	.4310 .4260	.095	.160 .150	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	40,300	25,800
16	33/64	.770 .735	.685	.5151 .5146	.5151 .5141	.4930 .4880	.095	.188 .178	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	52,200	34,300
18	37/64	.877 .842	.770	.5771 .5766	.5771 .5761	.5550 .5500	.125	.210 .200	.040 .025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	65,600	43,500
20	41/64	.953 .918	.825	.6396 .6391	.6396 .6386	.6180 .6120	.140	.238 .228	.040 .025	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	80,600	54,600
24	49/64	1.150 1.110	1.050	.7646 .7641	.7646 .7636	.7430 .7370	.200	.335 .320	.045 .030	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.330 .300	.398 .378	115,000	79,200
28	57/64	1.330 1.290	1.210	.8896 .8891	.8896 .8886	.8680 .8610	.250	.385 .370	.050 .035	5/64" x 45°	7/8-14UNJF-3A Modified	.3820 .3780	.400 .370	.471 .451	156,000	117,000
32	1-1/64	1.510 1.470	1.390	1.0146 1.0141	1.0146 1.0136	.9930 .9860	.300	.435 .420	.060 .045	5/64" x 45°	1-12UNJF-3A Modified	.5100 .5040	.520 .490	.618 .598	202,000	143,000

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. Use HL846 for oversize replacement.

MATERIAL: PH13-8Mo stainless steel per AMS5629.

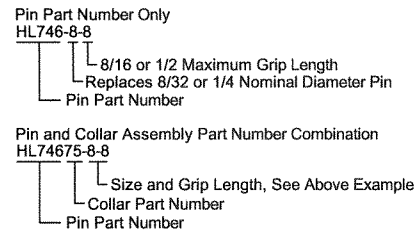
HEAT TREAT: 125,000 psi shear minimum.

- FINISH:**
- HL746-()-() = Solid film lube per AS5272.
 - HL746AP-()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL746LL-()-() = Passivate per Hi-Shear Spec. 262, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL746TB-()-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ⑥ HL746PB-()-() = 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 of the pin which HL746 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

**HOW TO ORDER
EXAMPLE:**



DRAWN		DATE	TITLE	
Van		8-5-71	HI-LOK® PIN	
APPROVED		DATE	PROTRUDING TENSION HEAD PH13-8Mo STAINLESS STEEL 1/16" GRIP VARIATION, 1/64" OVERSIZE	
R.Ting		8-9-71	DRAWING NUMBER	
REVISION		DATE	HL746	
⑥		JFO 9-18-2003		