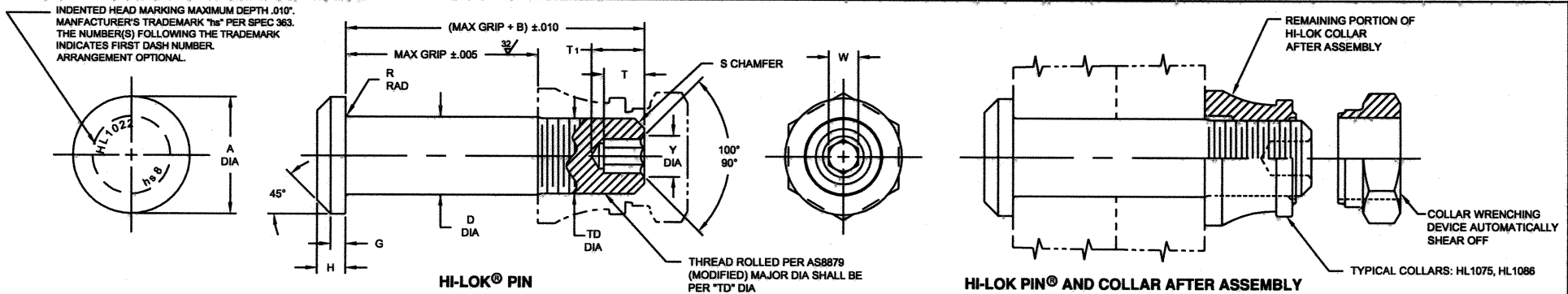


# STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder)	CAGE No. 73197	BLANC AERO INDUSTRIES UK LIMITED (Licensee)	CAGE No. OLB68
a LISI AEROSPACE Company		a LISI AEROSPACE Company	
AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A. & Canada)	CAGE No. 06725	HUCK S.A. France (Licensee - ECC Countries)	
HUCK INTERNATIONAL, INC., U.S.A. (Licensee)	CAGE No. 97928	BLANC AERO S.A. France (Licensee - ECC Countries)	
SPS TECHNOLOGIES, U.S.A. (Licensee)	CAGE No. 56878	a LISI AEROSPACE Company	
FAIRCHILD Aerospace Fastener Division (Licensee)	CAGE No. 92215	TOKYO SCREW COMPANY, Japan (Licensee - Japan)	
WEST COAST AEROSPACE INC., U.S.A. (Licensee)	CAGE No. 60616		



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 OR SOLID FILM LUBE	WITH COATING OR SOLID FILM LUBE							W HEX	T DEPTH	T1 DEPTH MAX			Y DIA
5						NOTE: USE HL1012-6(-)											
6	13/64	.377 .357	.325	.2026 .2021	.2026 .2016	.1840 .1810	.035	.074 .064	.025 .015	1/32" x 37°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.140 .140	.119 .104	6,130	3,180
8	17/64	.440 .415	.395	.2651 .2646	.2651 .2641	.2440 .2410	.045	.090 .080	.025 .015	1/32" x 37°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.160 .160	.142 .122	10,490	5,820
10	21/64	.505 .485	.500	.3276 .3271	.3276 .3266	.3060 .3020	.055	.112 .102	.030 .020	3/64" x 37°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.200 .160	.180 .160	16,000	9,200
12	25/64	.600 .580	.545	.3901 .3896	.3901 .3891	.3680 .3640	.075	.140 .130	.030 .020	3/64" x 37°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.235 .235	.217 .197	22,700	14,000
14	29/64	.676 .651	.635	.4526 .4521	.4526 .4516	.4310 .4260	.095	.160 .150	.030 .020	3/64" x 37°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.280 .280	.253 .233	30,600	18,900
16	33/64	.770 .745	.685	.5151 .5146	.5151 .5141	.4930 .4880	.095	.188 .178	.030 .020	3/64" x 37°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.320 .320	.289 .269	39,600	25,600
18	37/64	.877 .842	.770	.5771 .5766	.5771 .5761	.5550 .5500	.125	.210 .200	.040 .025	1/16" x 37°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.360 .360	.326 .306	49,700	32,400
20	41/64	.953 .905	.825	.6396 .6391	.6396 .6386	.6180 .6120	.140	.238 .228	.040 .025	1/16" x 37°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.400 .400	.326 .306	61,000	41,000
24	49/64	1.150 1.110	1.050	.7646 .7641	.7646 .7636	.7430 .7370	.200	.335 .320	.045 .030	1/16" x 37°	3/4-16UNJF-3A Modified	.3185 .3150	.330 .300	.425 .425	.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 FIM.
  2. Dimensions to be met after finish.
  3. Surface texture per ANSI B46.1.
  4. Hole preparation per NAS618.
  5. Use HL1032 for oversize replacement.

**MATERIAL:** 6AI-4V titanium alloy per AMS4928 or AMS4967.

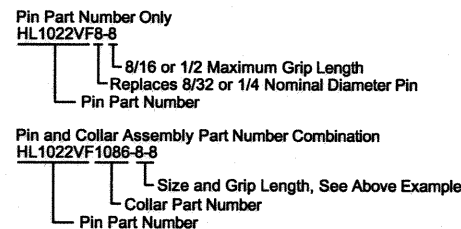
**HEAT TREAT:** 160,000 psi tensile minimum (95,000 psi shear minimum).

- FINISH:**
- HL1022(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL1022AZ(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 with color code black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL1022DK(-)(-) = Solid film lube per Kalgard FA.
  - ⑤ HL1022GL(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 on threads only (no overspray is allowed on the shank) color code white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL1022RA(-)(-) = Phosphate fluoride treat with color red on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL1022VF(-)(-) = Surface coating per Hi-Shear Spec. 306, Type I, color blue and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL1022SY(-)(-) = Phosphate fluoride treat, solid film lube per AS5272, Type I, and color red on thread end.

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

**CODE:** First dash number indicates nominal diameter in 1/32nds of the pin which HL1022 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

**HOW TO ORDER EXAMPLE:**



"Hi-Lok" and "HL" are internationally registered trademark of Hi-Shear Corporation.		TITLE <b>HI-LOK® PIN PROTRUDING TENSION HEAD TITANIUM, 1/64" OVERSIZE 1/16 GRIP VARIATION (SPECIAL SOCKET APPLICATION)</b>
DRAWN J.F.Obispo	DATE 3-22-95	DRAWING NUMBER <b>HL1022</b>
APPROVED E.E.B.	DATE 3-23-95	
REVISION ⑤	DATE J.F.O. 10-25-06	