



PARTS WITH PROTECTION CODE LETTER "A" ARE INACTIVE FOR DESIGN, USE DAN 8

EXAMPLE OF PART NUMBER:

FASTENER

ABS0253-5-8

DESIGNATION

BASIC PART NUMBER

CODE FOR PROTECTION

1st CODE NUMBER

2nd CODE NUMBER

MATERIAL	HEAT TREATMENT MIN STRENGTH N/mm ²		PROTECTION	CODE FOR PROTECTION	SUPPLIERS DESIGNATION
	TENSILE	SHEAR			
6AL-4V TITANIUM-ALLOY PER AMS4928 OR AMS4967	1103	655	I.V.D. ALUMINIUM COATED TO MIL-C-83488, TYPE II CLASS 3, POST-TREATED WITH CETYL - ALCOHOL AS PER HI-SHEAR SPEC.305	-	HL13VBJ
			PHOSPHATE FLUORIDE - TREAT WITH COLOR CODE RED ON THREAD END AND CETYL ALCOHOL LUBE PER HI-SHEAR SPEC. 305.	A	HL13VRA

PROCUREMENT SPECIFICATION: HI-LOK PRODUCT SPEC.342

FINISH: SURFACE TEXTURE PER ANSI-B46-1

PAGE	01	02	03	04															
ISS. / REV.	①	①	①	①															
APPROVED AIRBUS INDUSTRIE <i>v. Rollé</i>		TITLE FASTENER HI-LOK *, TITANIUM COUNTERSUNK HEAD FOR SHEAR AND TENSILE STRESS												CLASSIFICATION					
		ISSUE: 04/84 REVISION: ① 11/86												ABS0253					
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TABLE 1

1st CODE NO.				-5	-6	-8
NOMINAL \varnothing		inch		5/32	3/16	1/4
		mm		4	4,8	6,4
\varnothing A	inch	MAX	.330	.381	.506	
		MIN	.326	.376	.502	
	mm	MAX	8,38	9,67	12,85	
		MIN	8,28	9,55	12,75	
A1 MIN. VALUE		inch	.300	.340	.465	
		mm	7,62	8,64	11,81	
B REF	inch		.312	.325	.395	
	mm		7,92	8,26	10,03	
\varnothing D 1)	inch	MAX	.1635	.1895	.2495	
		MIN	.1625	.1885	.2485	
	mm	MAX	4,152	4,813	6,337	
		MIN	4,128	4,788	6,312	
\varnothing TD	inch	MAX	.1595	.1840	.2440	
		MIN	.1570	.1810	.2410	
	mm	MAX	4,051	4,673	6,197	
		MIN	3,988	4,597	6,121	
F	inch		.004	.005	.006	
	mm		0,10	0,13	0,15	
H	inch	MAX	.0700	.0805	.1080	
		MIN	.0680	.0785	.1060	
	mm	MAX	1,778	2,044	2,743	
		MIN	1,727	1,994	2,692	
R	inch	MAX	.025	.030	.030	
		MIN	.015	.020	.020	
	mm	MAX	0,64	0,76	0,76	
		MIN	0,38	0,51	0,51	
Z	inch		.010	.015	.015	
	mm		0,25	0,38	0,38	
THREAD-3A				.1640-32UNJC MODIFIED	.1900-32UNJF MODIFIED	.2500-28UNJF MODIFIED
INTERNAL HEXAGON	W	inch	MAX	.0645	.0806	.0967
			MIN	.0635	.0791	.0947
		mm	MAX	1,638	2,047	2,456
			MIN	1,613	2,009	2,405
	T	inch	MAX	.135	.135	.150
			MIN	.115	.115	.130
		mm	MAX	3,42	3,42	3,81
			MIN	2,92	2,92	3,30
	\varnothing Y	inch	MAX	.090	.119	.142
			MIN	.075	.104	.122
		mm	MAX	2,28	3,02	3,60
			MIN	1,91	2,64	3,10
MIN.DOUBLE SHEAR LOAD kN				17,83	23,93	41,36
MIN. TENSILE LOAD kN				9,69	14,14	25,88

1) MAXIMUM "D" DIAMETER MAY BE INCREASED BY 0,0051mm (0,0002 inch) TO ALLOW FOR THE APPLICATION OF ALUMINIUM COATING.

CLASSIFICATION

ABS0253

ISSUE: 04/84

REVISION: ① 11/86

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1st CODE NO.				-5				-6				-8				
2nd CODE NO.	GRIP		LENGTH mm	GRIP LENGTH		LENGTH		WEIGHT kg/1000 PCS	LENGTH		WEIGHT kg/1000 PCS	LENGTH		WEIGHT kg/1000 PCS		
	inch ±.005	mm		inch MAX.	mm MIN.	inch ±.010	mm ±0,25		inch ±.010	mm ±0,25		inch ±.010	mm ±0,25			
-2	1/8	3,2	±0,127	.12	.06	3,1	1,6	.43	11,0	0,650	.44	11,4	0,920	.51	13,1	2,030
-3	3/16	4,8		.19	.12	4,7	3,2	.50	12,6	0,745	.51	13,0	1,050	.58	14,7	2,230
-4	1/4	6,4		.25	.19	6,3	4,8	.56	14,2	0,840	.57	14,6	1,170	.64	16,3	2,440
-5	5/16	7,9		.31	.25	7,8	6,4	.62	15,7	0,940	.63	16,1	1,300	.70	17,8	2,650
-6	3/8	9,5		.38	.31	9,4	7,9	.69	17,3	1,030	.70	17,7	1,470	.77	19,4	2,850
-7	7/16	11,1		.44	.38	11,0	9,5	.75	18,9	1,120	.76	19,3	1,590	.83	21,0	3,060
-8	1/2	12,7		.50	.44	12,6	11,1	.81	20,5	1,220	.82	20,9	1,720	.89	22,6	3,260
-9	9/16	14,3		.56	.50	14,2	12,7	.87	22,1	1,310	.88	22,5	1,845	.95	24,2	3,465
-10	5/8	15,9		.62	.56	15,8	14,3	.93	23,7	1,410	.94	24,1	1,970	1,01	25,8	3,670
-11	11/16	17,5		.69	.62	17,4	15,9	1,00	25,3	1,500	1,01	25,7	2,095	1,08	27,4	3,880
-12	3/4	19,1		.75	.69	19,0	17,5	1,06	26,9	1,595	1,07	27,3	2,220	1,14	29,0	4,080
-13	13/16	20,6		.81	.75	20,5	19,1	1,12	28,4	1,690	1,13	28,8	2,350	1,20	30,5	4,290
-14	7/8	22,2		.88	.81	22,1	20,6	1,19	30,0	1,785	1,20	30,4	2,470	1,27	32,1	4,490
-15	15/16	23,8		.94	.88	23,7	22,2	1,25	31,6	1,880	1,26	32,0	2,590	1,33	33,7	4,700
-16	1	25,4		1,00	.94	25,3	23,8	1,31	33,2	1,970	1,32	33,6	2,710	1,39	35,3	4,900
-17	1-1/16	27,0		1,06	1,00	26,9	25,4	1,37	34,8	2,070	1,38	35,2	2,840	1,45	36,9	5,110
-18	1-1/8	28,6		1,12	1,06	28,5	27,0	1,43	36,4	2,160	1,44	36,8	2,965	1,51	38,5	5,310
-19	1-3/16	30,2		1,19	1,12	30,1	28,6	1,50	38,0	2,250	1,51	38,4	3,060	1,58	40,1	5,515
-20	1-1/4	31,8		1,25	1,19	31,7	30,2	1,56	39,6	2,350	1,57	40,0	3,215	1,64	41,7	5,720

2) MAXIMUM ENGRAVING DEPTH OF IDENTIFICATION 0,254mm (0.010 inch)

IDENTIFICATION: "hs" FOR HI-SHEAR
 "VS" FOR VOI-SHAN
 "SPS" FOR STANDARD PRESSED STEEL
 "KAB" FOR KAWAX
 "T" FOR SAINT-CHAMOND-GRANAT

PER MANUFACTURER'S CODE IDENTIFICATION LETTER "V" FOR TITANIUM WITH SURFACE PROTECTION.
 FOLLOWING NUMBER= 1st CODE NUMBER. ARRANGEMENT OPTIONAL.

CLASSIFICATION

ABS0253

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ISSUE: 04/84

REVISION: ① 11/86

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OVERSIZE FASTENER
RESTRICTED USE
FOR REPAIR ONLY

TABLE 3

1st CODE NO.	PART NO. IDENTIFICATION	0,40mm (1/64 inch) REPAIR SIZE X						SUPPLIERS DESIGNATION
		THREAD MIL-S-8879 MODIFIED	Ø D inch MAX. MIN.		mm MAX. MIN.			
-5	3)							
-6	ABS0253-6-(*)X							HL113VBJ-6
	ABS0253A6-(*)X	.1900-32UNJF-3A	.2026	.2016	5,146	5,121	HL113VRA-6	
-8	ABS0253-8-(*)X	.2500-28UNJF-3A	.2651	.2641	6,733	6,708	HL113VBJ-8	
	ABS0253A8-(*)X						HL113VRA-8	

TABLE 4

1st CODE NO.	PART NO. IDENTIFICATION	0,80mm (1/32 inch) REPAIR SIZE Y					
		THREAD MIL-S-8879 MODIFIED	Ø D				SUPPLIERS DESIGNATION
			inch MAX.	MIN.	mm MAX.	MIN.	
-5	4)						
-6	ABS0253-6-(*)Y	.1900-32UN JF-3A	.2182	.2172	5,542	5,518	HL413VBJ-6
	ABS0253A6-(*)Y						HL413VRA-6
-8	ABS0253-8-(*)Y	.2500-28UN JF-3A	.2807	.2797	7,219	7,105	HL413VBJ-8
	ABS0253A8-(*)Y						HL413VRA-8

3) USE ABS0253-6-(*) OR ~~ABS0253A6-(*)~~ SUPPLIERS DESIGNATION HL13VBJ-6 OR
~~HL13VRA-6~~

4) USE ABS0253-6-(*)X OR ~~ABS0253A6-(*)X~~ SUPPLIERS DESIGNATION HL113VBJ-6 OR
~~HL113VRA-6~~

*) GRIP LENGTH 2nd CODE NO. SEE TABLE 2

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REVISION: ① 11/86

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