



PARTS WITH PROTECTION CODE LETTER "A" ARE INACTIVE FOR DESIGN, USE DAN 7

EXAMPLE OF PART NUMBER:

FASTENER

ABS0252-5-8

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 COA TED TO MIL-C-83488, TYPE II CLASS 3, POST- TREATED WITH CETYL - ALCOHOL AS PER HI- SHEAR SPEC.305	-	HL12VBJ
			PHOSPHATE FLUORIDE - TREAT WITH COLOR CO- DE RED ON THREAD END AND CETYL ALCOHOL LU- BE PER HI-SHEAR SPEC. 305.	A	HL12VRA

PROCUREMENT SPECIFICATION: HI-LOK PRODUCT SPEC.342
FINISH: SURFACE TEXTURE PER ANSI-B46-1

PAGE	01	02	03	04	05	06	07							
ISS. / REV.	(1)	(1)	(1)	(1)	(1)	(1)	(1)							
APPROVED AIRBUS INDUSTRIE <i>V. Rollich</i>	TITLE FASTENER HI-LOK *, TITANIUM PROTRUDING HEAD FOR SHEAR AND TENSILE STRESS										CLASSIFICATION			
											ABS0252			
	ISSUE: 04/84 REVISION: (1) 11/86										PAGE 01 OF 07			

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TABLE 1

1st CODE NO.				-5	-6	-8	-10	
NOMINAL \varnothing		inch		5/32	3/16	1/4	5/16	
		mm		4	4,8	6,4	8	
\varnothing A	inch	MAX		.322	.377	.440	.502	
		MIN		.306	.357	.415	.472	
	mm	MAX		8,17	9,57	11,17	12,75	
		MIN		7,77	9,07	10,54	11,99	
B REF	inch		.312	.325	.395	.500		
	mm		7,92	8,26	10,03	12,70		
\varnothing D 1)	inch	MAX		.1635	.1895	.2495	.3120	
		MIN		.1625	.1885	.2485	.3110	
	mm	MAX		4,152	4,813	6,337	7,924	
		MIN		4,128	4,788	6,312	7,899	
\varnothing TD	inch	MAX		.1595	.1840	.2440	.3060	
		MIN		.1570	.1810	.2410	.3020	
	mm	MAX		4,051	4,673	6,197	7,772	
		MIN		3,988	4,597	6,121	7,671	
G REF	inch		.030	.035	.045	.065		
	mm		0,76	0,89	1,14	1,65		
H	inch	MAX		.065	.074	.090	.140	
		MIN		.055	.064	.080	.130	
	mm	MAX		1,65	1,88	2,29	3,55	
		MIN		1,40	1,62	2,03	3,30	
R	inch	MAX		.025	.025	.025	.030	
		MIN		.015	.015	.015	.020	
	mm	MAX		0,64	0,64	0,64	0,76	
		MIN		0,38	0,38	0,38	0,51	
THREAD-3A			.1640-32UNJC MODIFIED	.1900-32UNJF MODIFIED	.2500-28UNJF MODIFIED	.3125-24UNJF MODIFIED		
INTERNAL HEXAGON	W	inch	MAX		.0645	.0806	.0967	.1295
			MIN		.0635	.0791	.0947	.1270
		mm	MAX		1,638	2,047	2,456	3,289
			MIN		1,613	2,009	2,405	3,226
	T	inch	MAX		.135	.135	.150	.170
			MIN		.115	.115	.130	.150
		mm	MAX		3,42	3,42	3,81	4,31
			MIN		2,92	2,92	3,30	3,81
	\varnothing Y	inch	MAX		.090	.119	.142	.180
			MIN		.075	.104	.122	.160
		mm	MAX		2,28	3,02	3,60	4,57
			MIN		1,91	2,64	3,10	4,06
MIN.DBL.SHEAR LOAD KN			17,83	23,93	41,36	64,97		
MIN. TENSILE LOAD KN			9,69	14,14	25,88	40,94		

1) MAXIMUM "D" DIAMETER MAY BE INCREASED BY 0,0051 mm
(0.0002 inch TO ALLOW FOR THE APPLICATION OF ALUMI-
NIUM COATING

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TABLE 2

1st CODE NO.							-5		
2nd CODE NO.	GRIP inch $\pm .005$	LENGTH mm $\pm 0,127$	GRIP LENGTH				LENGTH		WEIGHT kg/1000 PCS
			inch		mm		inch $\pm .010$	mm $\pm 0,25$	
			MAX.	MIN.	MAX.	MIN.			
-2	1/8	3,2	.12	.06	3,1	1,6	.43	11,0	0,810
-3	3/16	4,8	.19	.12	4,7	3,2	.50	12,6	0,905
-4	1/4	6,4	.25	.19	6,3	4,8	.56	14,2	1,000
-5	5/16	7,9	.31	.25	7,8	6,4	.62	15,7	1,095
-6	3/8	9,5	.38	.31	9,4	7,9	.69	17,3	1,185
-7	7/16	11,1	.44	.38	11,0	9,5	.75	18,9	1,280
-8	1/2	12,7	.50	.44	12,6	11,1	.81	20,5	1,300
-9	9/16	14,3	.56	.50	14,2	12,7	.87	22,1	1,470
-10	5/8	15,9	.62	.56	15,8	14,3	.93	23,7	1,570
-11	11/16	17,5	.69	.62	17,4	15,9	1.00	25,4	1,660
-12	3/4	19,1	.75	.69	19,0	17,5	1.06	26,9	1,750
-13	13/16	20,6	.81	.75	20,5	19,1	1.12	28,4	1,850
-14	7/8	22,2	.88	.81	22,1	20,6	1.19	30,0	1,945
-15	15/16	23,8	.94	.88	23,7	22,2	1.25	31,6	2,040
-16	1	25,4	1.00	.94	25,3	23,8	1.31	33,2	2,130
-17	1-1/16	27,0	1.06	1.00	26,9	25,4	1.37	34,8	2,225
-18	1-1/8	28,6	1.12	1.06	28,5	27,0	1.43	36,4	2,320
-19	1-3/16	30,2	1.19	1.12	30,1	28,6	1.50	38,0	2,410
-20	1-1/4	31,8	1.25	1.19	31,7	30,2	1.56	39,6	2,510
-21	1-5/16	33,4	1.31	1.25	33,3	31,8	1.62	41,2	2,604
-22	1-3/8	35,0	1.38	1.31	34,9	33,4	1.69	42,8	2,699
-23	1-7/16	36,6	1.44	1.38	36,5	35,0	1.75	44,4	2,793
-24	1-1/2	38,2	1.50	1.44	38,1	36,6	1.81	46,0	2,888
-25	1-9/16	39,8	1.56	1.50	39,6	38,2	1.87	47,5	2,982

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TABLE 2 (cont.)

1st CODE NO.							-6		
2nd CODE NO.	GRIP inch ±.005	LENGTH mm ±0,127	GRIP LENGTH				LENGTH		WEIGHT kg/1000 PCS
			inch		mm		inch	mm	
			MAX.	MIN.	MAX.	MIN.	±.010	±0,25	
-2	1/8	3,2	.12	.06	3,1	1,6	.44	11,4	1,162
-3	3/16	4,8	.19	.12	4,7	3,2	.51	13,0	1,290
-4	1/4	6,4	.25	.19	6,3	4,8	.57	14,6	1,410
-5	5/16	7,9	.31	.25	7,8	6,4	.63	16,1	1,535
-6	3/8	9,5	.38	.31	9,4	7,9	.70	17,7	1,660
-7	7/16	11,1	.44	.38	11,0	9,5	.76	19,3	1,790
-8	1/2	12,7	.50	.44	12,6	11,1	.82	20,9	1,910
-9	9/16	14,3	.56	.50	14,2	12,7	.88	22,5	2,035
-10	5/8	15,9	.62	.56	15,8	14,3	.94	24,1	2,160
-11	11/16	17,5	.69	.62	17,4	15,9	1.01	25,7	2,290
-12	3/4	19,1	.75	.69	19,0	17,5	1.07	27,3	2,410
-13	13/16	20,6	.81	.75	20,5	19,1	1.13	28,8	2,530
-14	7/8	22,2	.88	.81	22,1	20,6	1.20	30,4	2,660
-15	15/16	23,8	.94	.88	23,7	22,2	1.26	32,0	2,790
-16	1	25,4	1.00	.94	25,3	23,8	1.32	33,6	2,910
-17	1-1/16	27,0	1.06	1.00	26,9	25,4	1.38	35,2	3,035
-18	1-1/8	28,6	1.12	1.06	28,5	27,0	1.44	36,8	3,160
-19	1-3/16	30,2	1.19	1.12	30,1	28,6	1.51	38,4	3,285
-20	1-1/4	31,8	1.25	1.19	31,7	30,2	1.57	40,0	3,410
-21	1-5/16	33,4	1.31	1.25	33,3	31,8	1.63	41,6	3,535
-22	1-3/8	35,0	1.38	1.31	34,9	33,4	1.70	43,2	3,660
-23	1-7/16	36,6	1.44	1.38	36,5	35,0	1.76	44,8	3,785
-24	1-1/2	38,2	1.50	1.44	38,1	36,6	1.82	46,3	3,910
-25	1-9/16	39,8	1.56	1.50	39,6	38,2	1.88	47,9	4,034

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TABLE 2 (cont.)

1st CODE NO.							-8		
2nd CODE NO.	GRIP inch ± 0.005	LENGTH mm ± 0.127	GRIP LENGTH				LENGTH		WEIGHT kg/1000 PCS
			inch		mm		inch ± 0.010	mm ± 0.25	
			MAX.	MIN.	MAX.	MIN.			
-2	1/8	3,2	.12	.06	3,1	1,6	.51	13,1	2,560
-3	3/16	4,8	.19	.12	4,7	3,2	.58	14,7	2,760
-4	1/4	6,4	.25	.19	6,3	4,8	.64	16,3	2,965
-5	5/16	7,9	.31	.25	7,8	6,4	.70	17,8	3,175
-6	3/8	9,5	.38	.31	9,4	7,9	.77	19,4	3,380
-7	7/16	11,1	.44	.38	11,0	9,5	.83	21,0	3,580
-8	1/2	12,7	.50	.44	12,6	11,1	.89	22,6	3,790
-9	9/16	14,3	.56	.50	14,2	12,7	.95	24,2	3,990
-10	5/8	15,9	.62	.56	15,8	14,3	1.01	25,8	4,200
-11	11/16	17,5	.69	.62	17,4	15,9	1.08	27,4	4,400
-12	3/4	19,1	.75	.69	19,0	17,5	1.14	29,0	4,610
-13	13/16	20,6	.81	.75	20,5	19,1	1.20	30,5	4,810
-14	7/8	22,2	.88	.81	22,1	20,6	1.27	32,1	5,020
-15	15/16	23,8	.94	.88	23,7	22,2	1.33	33,7	5,230
-16	1	25,4	1.00	.94	25,3	23,8	1.39	35,3	5,430
-17	1-1/16	27,0	1.06	1.00	26,9	25,4	1.45	36,9	5,635
-18	1-1/8	28,6	1.12	1.06	28,5	27,0	1.51	38,5	5,833
-19	1-3/16	30,2	1.19	1.12	30,1	28,6	1.58	40,1	6,040
-20	1-1/4	31,8	1.25	1.19	31,7	30,2	1.64	41,7	6,250
-21	1-5/16	33,4	1.31	1.25	33,3	31,8	1.70	43,3	6,455
-22	1-3/8	35,0	1.38	1.31	34,9	33,4	1.77	44,9	6,660
-23	1-7/16	36,6	1.44	1.38	36,5	35,0	1.83	46,5	6,865
-24	1-1/2	38,2	1.50	1.44	38,1	36,6	1.89	48,0	7,070
-25	1-9/16	39,8	1.56	1.50	39,6	38,2	1.95	49,6	7,275

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TABLE 2 (cont.)

1 st CODE NO.							-10		
2 nd CODE NO.	GRIP inch ±.005	LENGTH mm ±0,127	GRIP LENGTH				LENGTH		WEIGHT kg/1000 PCS
			inch		mm		inch ±.010	mm ±0,25	
			MAX.	MIN.	MAX.	MIN.			
-2	1/8	3,2	.12	.06	3,1	1,6	.62	15,8	3,98
-3	3/16	4,8	.19	.12	4,7	3,2	.68	17,4	4,35
-4	1/4	6,4	.25	.19	6,3	4,8	.75	19,0	4,73
-5	5/16	7,9	.31	.25	7,8	6,4	.81	20,5	5,10
-6	3/8	9,5	.38	.31	9,4	7,9	.87	22,1	5,48
-7	7/16	11,1	.44	.38	11,0	9,5	.92	23,5	5,84
-8	1/2	12,7	.50	.44	12,6	11,1	.99	25,3	6,22
-9	9/16	14,3	.56	.50	14,2	12,7	1.06	26,9	6,59
-10	5/8	15,9	.62	.56	15,8	14,3	1.12	28,5	6,96
-11	11/16	17,5	.69	.62	17,4	15,9	1.18	30,1	7,34
-12	3/4	19,1	.75	.69	19,0	17,5	1.25	31,7	7,72
-13	13/16	20,6	.81	.75	20,5	19,1	1.31	33,2	8,10
-14	7/8	22,2	.88	.81	22,1	20,6	1.37	34,8	8,47
-15	15/16	23,8	.94	.88	23,7	22,2	1.43	36,4	8,85
-16	1	25,4	1.00	.94	25,3	23,8	1.50	38,0	9,23
-17	1-1/16	27,0	1.06	1.00	26,9	25,4	1.56	39,6	9,61
-18	1-1/8	28,6	1.12	1.06	28,5	27,0	1.62	41,2	9,97
-19	1-3/16	30,2	1.19	1.12	30,1	28,6	1.68	42,8	10,36
-20	1-1/4	31,8	1.25	1.19	31,7	30,2	1.75	44,4	10,74
-21	1-5/16	33,4	1.31	1.25	33,3	31,8	1.81	46,0	11,11
-22	1-3/8	35,0	1.38	1.31	34,9	33,4	1.87	47,5	11,48
-23	1-7/16	36,6	1.44	1.38	36,5	35,0	1.93	49,1	11,86
-24	1-1/2	38,2	1.50	1.44	38,1	36,6	2.00	50,7	12,23
-25	1-9/16	39,8	1.56	1.50	39,6	38,2	2.06	52,3	12,61

2) MAXIMUM ENGRAVING DEPTH OF IDENTIFICATION 0,254mm (.010 inch)

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

PER MANUFACTURER'S CODE IDENTIFICATION LETTER "V"
 FOR TITANIUM WITH SURFACE PROTECTION.

FOLLOWING NUMBER= 1st CODE NUMBER. ARRANGEMENT
 OPTIONAL.

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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					
		THREAD MIL-S-8879 MODIFIED	Ø D inch MAX. MIN.		mm MAX. MIN.		SUPPLIERS DESIGNATION
-5	3)						
-6	ABS0252-6-(*)X	.1900-32UNJF-3A	.2026	.2016	5,146	5,121	HL112VBJ-6
	ABS0252A6-(*)X						HL112VRA-6
-8	ABS0252-8-(*)X	.2500-28UNJF-3A	.2651	.2641	6,733	6,708	HL112VBJ-8
	ABS0252A8-(*)X						HL112VRA-8
-10	ABS0252-10-(*)X	.3125-24UNJF-3A	.3276	.3266	8,321	8,296	HL112VBJ-10
	ABS0252A10-(*)X						HL112VRA-10

TABLE 4

1st CODE NO.	PART NO. IDENTIFICATION	0,80mm (1/32 inch) REPAIR SIZE Y					SUPPLIERS DESIGNATION
		THREAD MIL-S-8879 MODIFIED	Ø D		mm		
			inch MAX.	MIN.	MAX.	MIN.	
-5	4)						
-6	ABS0252-6-(*)Y	.1900-32UNJF-3A	.2182	.2172	5,542	5,518	HL412VBJ-6
	ABS0252A6-(*)Y						HL412VRA-6
-8	ABS0252-8-(*)Y	.2500-28UNJF-3A	.2807	.2797	7,219	7,105	HL412VBJ-8
	ABS0252A8-(*)Y						HL412VRA-8
-10	ABS0252-10-(*)Y	.3125-24UNJF-3A	.3432	.3422	8,717	8,692	HL412VBJ-10
	ABS0252A10-(*)Y						HL412VRA-10

3) USE ABS0252-6-(*) OR ~~ABS0252A6-(*)~~ SUPPLIERS DESIGNATION HL12VBJ-6 OR ~~HL12VRA-6~~

4) USE ABS0252-6-(*)X OR ~~ABS0252A6-(*)X~~ SUPPLIERS DESIGNATION HL112VBJ-6 OR ~~HL112VRA-6~~

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

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