



PARTS WITH PROTECTION CODE LETTER "A" ARE INACTIVE FOR DESIGN, USE DAN 6

EXAMPLE OF PART NUMBER:

FASTENER

ABS0251-5-8

DESIGNATION _____

BASIC PART NUMBER _____

CODE FOR PROTECTION _____

1st CODE NUMBER _____

2nd CODE NUMBER _____

MATERIAL	HEAT TREATMENT	PROTECTION	CODE FOR PROTECTION	SUPPLIERS DESIGNATION
6AL-4V TITANIUM-ALLOY PER AMS4928 OR AMS4967	MINIMUM SHEAR STRENGTH 655 N/mm ² (MPa)	I.V.D. ALUMINIUM COATED TO MIL-C-83488, TYPE II CLASS 3, POST-TREATED WITH CETYL ALCOHOL AS PER HI-SHEAR SPEC.305	-	HL11VBJ
		PHOSPHATE FLUORIDE TREAT WITH COLOR CODE RED ON THREAD END AND CETYL ALCOHOL LUBE PER HI-SHEAR SPEC.305	A	HL11VRA

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>f. Rohrich</i>		TITLE									CLASSIFICATION		
		FASTENER HI-LOK *, TITANIUM WITH COUNTERSUNK HEAD FOR SHEAR STRESS									ABS0251		
		ISSUE: 04/84 REVISION: (1) 11/86									PAGE 01 OF 04		

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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	.261	.302	.395	
		MIN	.256	.297	.390	
	mm	MAX	6,63	7,67	10,03	
		MIN	6,50	7,54	9,91	
A1 MIN. VALUE		inch	.235	.260	.355	
		mm	5,97	6,60	9,02	
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	.0410	.0470	.0610	
		MIN	.0390	.0450	.0590	
	mm	MAX	1,041	1,194	1,549	
		MIN	0,991	1,143	1,499	
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. DBL. SHEAR LOAD kN				17,83	23,93	41,36
MIN. TENSILE LOAD kN				5,73	8,89	16,45

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

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1st CODE NO.				-5			-6			-8		
2nd CODE NO.	GRIP		GRIP LENGTH		LENGTH		WEIGHT		LENGTH		WEIGHT	
	inch	mm	inch	mm	inch	mm	kg/1000 PCS	mm	inch	mm	kg/1000 PCS	mm
	±.005	±0,127	MAX.	MIN.	±.010	±0,25		±0,25	±.010	±0,25		±.010
-2	1/8	3,2	.12	.06	.43	11,0	0,488	.44	.51	13,1	0,726	.51
-3	3/16	4,8	.19	.12	.50	12,6	0,584	.51	.58	14,7	0,850	.58
-4	1/4	6,4	.25	.19	.56	14,2	0,680	.57	.64	16,3	0,966	.64
-5	5/16	7,9	.31	.25	.62	15,7	0,776	.63	.70	17,8	1,090	.70
-6	3/8	9,5	.38	.31	.69	17,3	0,865	.70	.77	19,4	1,220	.77
-7	7/16	11,1	.44	.38	.75	18,9	0,960	.76	.83	21,0	1,345	.83
-8	1/2	12,7	.50	.44	.81	20,5	1,055	.82	.89	22,6	1,460	.89
-9	9/16	14,3	.56	.50	.87	22,1	1,145	.88	.95	24,2	1,590	.95
-10	5/8	15,9	.62	.56	.93	23,7	1,242	.94	1,01	25,8	1,710	1,01
-11	11/16	17,5	.69	.62	1,00	25,3	1,338	1,01	1,08	27,4	1,840	1,08
-12	3/4	19,1	.75	.69	1,06	26,9	1,435	1,07	1,14	29,0	1,960	1,14
-13	13/16	20,6	.81	.75	1,12	28,4	1,525	1,13	1,20	30,5	2,080	1,20
-14	7/8	22,2	.88	.81	1,19	30,0	1,620	1,20	1,27	32,1	2,210	1,27
-15	15/16	23,8	.94	.88	1,25	31,6	1,710	1,26	1,33	33,7	2,330	1,33
-16	1	25,4	1,00	.94	1,31	33,2	1,810	1,32	1,39	35,3	2,460	1,39
-17	1-1/16	27,0	1,06	1,00	1,37	34,8	1,901	1,38	1,45	36,9	2,580	1,45
-18	1-1/8	28,6	1,12	1,06	1,43	36,4	2,000	1,44	1,51	38,5	2,700	1,51
-19	1-3/16	30,2	1,19	1,12	1,50	38,0	2,090	1,51	1,58	40,1	2,830	1,58
-20	1-1/4	31,8	1,25	1,19	1,56	39,6	2,180	1,57	1,64	41,7	2,950	1,64

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 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
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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	ABS0251-6-(*)X							HL111VBJ-6
	ABS0251A6-(*)X	.1900-32UNJF-3A	.2026	.2016	5,146	5,121		HL111VRA-6
-8	ABS0251-8-(*)X	.2500-28UNJF-3A	.2651	.2641	6,733	6,708		HL111VBJ-8
	ABS0251A8-(*)X							HL111VRA-8

TABLE 4

1st CODE NO.	PART NO. IDENTIFICATION	0,80mm (1/32 inch) REPAIR SIZE Y					SUPPLIERS DESIGNATION
		THREAD MIL-S-8879 MODIFIED	inch MAX. MIN.		mm MAX. MIN.		
-5	4)						
-6	ABS0251-6-(*)Y	.1900-32UNJF-3A	.2182	.2172	5,542	5,518	HL411VBJ-6
	ABS0251A6-(*)Y						HL411VRA-6
-8	ABS0251-8-(*)Y	.2500-28UNJF-3A	.2807	.2797	7,219	7,105	HL411VBJ-8
	ABS0251A8-(*)Y						HL411VRA-8

3) USE ABS0251-6-(*) OR ~~ABS0251A6-(*)~~ SUPPLIERS DESIGNATION HL111VBJ-6 OR
~~HL111VRA-6~~

4) USE ABS0251-6-(*)X OR ~~ABS0251A6-(*)X~~ SUPPLIERS DESIGNATION HL111VBJ-6 OR
~~HL111VRA-6~~

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

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