



PARTS WITH PROTECTION CODE LETTER "A" ARE INACTIVE FOR DESIGN, USE DAN 5

EXAMPLE OF PART NUMBER:

FASTENER

ABS0250-5-8

DESIGNATION

BASIC PART NUMBER

CODE FOR PROTECTION

1st CODE NUMBER

2nd CODE NUMBER

MATERIAL	HEAT TREATMENT	PROTECTION	CODE FOR PROTECTION	SUPPLIER'S 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	-	HL10VBJ
		PHOSPHATE FLUORIDE TREAT WITH COLOR CODE RED ON THREAD END AND CETYL ALCOHOL LUBE PER HI-SHEAR SPEC.305	A	HL10VRA

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>r. Allievi</i>	TITLE FASTENER HI-LOK *, TITANIUM WITH UNIVERSAL HEAD FOR SHEAR STRESS										CLASSIFICATION			
	ISSUE: 04-84 REVISION: (1) 11-86										ABS0250			
											PAGE 01 OF 04			

PUBLISHED AND DISTRIBUTED BY: AIRBUS INDUSTRIE
31700 BLAGNAC
FRANCE

© Copyright AIRBUS-INDUSTRIE 1986
All rights reserved.



TABLE 1

1st CODE NO.				-5	-6	-8
NOMINAL Ø						
inch				5/32	3/16	1/4
mm				4	4,8	6,4
Ø A	inch	MAX	.262	.315	.412	
		MIN	.242	.295	.387	
	mm	MAX	6,65	8,00	10,46	
		MIN	6,15	7,49	9,83	
B REF	inch		.312	.325	.395	
	mm		7,92	8,26	10,03	
Ø 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	
Ø 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	
G	inch		.020	.025	.030	
	mm		0,51	0,64	0,76	
H	inch	MAX	.047	.055	.069	
		MIN	.037	.045	.059	
	mm	MAX	1,19	1,37	1,75	
		MIN	0,94	1,14	1,50	
R	inch	MAX	.025	.025	.025	
		MIN	.015	.015	.015	
	mm	MAX	0,64	0,64	0,64	
		MIN	0,38	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
	ØY	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				8,63	11,12	19,12

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

CLASSIFICATION

ABS0250

ISSUE: 04/84

REVISION: ① 11/86

PAGE 02



2nd CODE NO.	1st CODE NO.		GRIP LENGTH				-5		-6		-8	
	GRIP	LENGTH	inch		mm		LENGTH	WEIGHT	LENGTH	WEIGHT	LENGTH	WEIGHT
	±.005	mm	MAX.	MIN.	MAX.	MIN.	inch ±.010	kg/1000 PCS	inch ±.010	kg/1000 PCS	inch ±.010	kg/1000 PCS
-2	1/8	3,2	.12	.06	3,1	1,6	.43	11,0	.44	11,4	.51	13,1
-3	3/16	4,8	.19	.12	4,7	3,2	.50	12,6	.51	13,0	.58	14,7
-4	1/4	6,4	.25	.19	6,3	4,8	.56	14,2	.57	14,6	.64	16,3
-5	5/16	7,9	.31	.25	7,8	6,4	.62	15,7	.63	16,1	.70	17,8
-6	3/8	9,5	.38	.31	9,4	7,9	.69	17,3	.70	17,7	.77	19,4
-7	7/16	11,1	.44	.38	11,0	9,5	.75	18,9	.76	19,3	.83	21,0
-8	1/2	12,7	.50	.44	12,6	11,1	.81	20,5	.82	20,9	.89	22,6
-9	9/16	14,3	.56	.50	14,2	12,7	.87	22,1	.88	22,5	.95	24,2
-10	5/8	15,9	.62	.56	15,8	14,3	.93	23,7	.94	24,1	1,01	25,8
-11	11/16	17,5	.69	.62	17,4	15,9	1,00	25,3	1,01	25,7	1,08	27,4
-12	3/4	19,1	.75	.69	19,0	17,5	1,06	26,9	1,07	27,3	1,14	29,0
-13	13/16	20,6	.81	.75	20,5	19,1	1,12	28,4	1,13	28,8	1,20	30,5
-14	7/8	22,2	.88	.81	22,1	20,6	1,19	30,0	1,20	30,4	1,27	32,1
-15	15/16	23,8	.94	.88	23,7	22,2	1,25	31,6	1,26	32,0	1,33	33,7
-16	1	25,4	1,00	.94	25,3	23,8	1,31	33,2	1,32	33,6	1,39	35,3
-17	1-1/16	27,0	1,06	1,00	26,9	25,4	1,37	34,8	1,38	35,2	1,45	36,9
-18	1-1/8	28,6	1,12	1,06	28,5	27,0	1,43	36,4	1,44	36,8	1,51	38,5
-19	1-3/16	30,2	1,19	1,12	30,1	28,6	1,50	38,0	1,51	38,4	1,58	40,1
-20	1-1/4	31,8	1,25	1,19	31,7	30,2	1,56	39,6	1,57	40,0	1,64	41,7

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.



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	∅ D inch MAX. MIN.		mm MAX. MIN.		
-5	3)						
-6	ABS0250-6-(*)X						HL110VBJ-6
	ABS0250A6-(*)X	.1900-32UNJF-3A	.2026	.2016	5,146	5,121	HL110VRA-6
-8	ABS0250-8-(*)X	.2500-28UNJF-3A	.2651	.2641	6,733	6,708	HL110VBJ-8
	ABS0250A8-(*)X						HL110VRA-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	ABS0250-6-(*)Y	.1900-32UNJF-3A	.2182	.2172	5,542	5,518	HL410VBJ-6	
	ABS0250A6-(*)Y						HL410VRA-6	
-8	ABS0250-8-(*)Y	.2500-28UNJF-3A	.2807	.2797	7,219	7,105	HL410VBJ-8	
	ABS0250A8-(*)Y						HL410VRA-8	

3) USE ABS0250-6-(*) OR ~~ABS0250A6-(*)~~ SUPPLIERS DESIGNATION HL10VBJ-6 OR
~~HL10VRA-6~~

4) USE ABS0250-6-(*)X OR ~~ABS0250A6-(*)X~~ SUPPLIERS DESIGNATION HL110VBJ-6 OR
~~HL110VRA-6~~

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

CLASSIFICATION

ABS0250

ISSUE: 04/84

REVISION: ① 11/86

PAGE 04