lisi AEROSPACE
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR Corporation, USA
a LISI AEROSPACE Company
Design Holder
CAGE No. 73197

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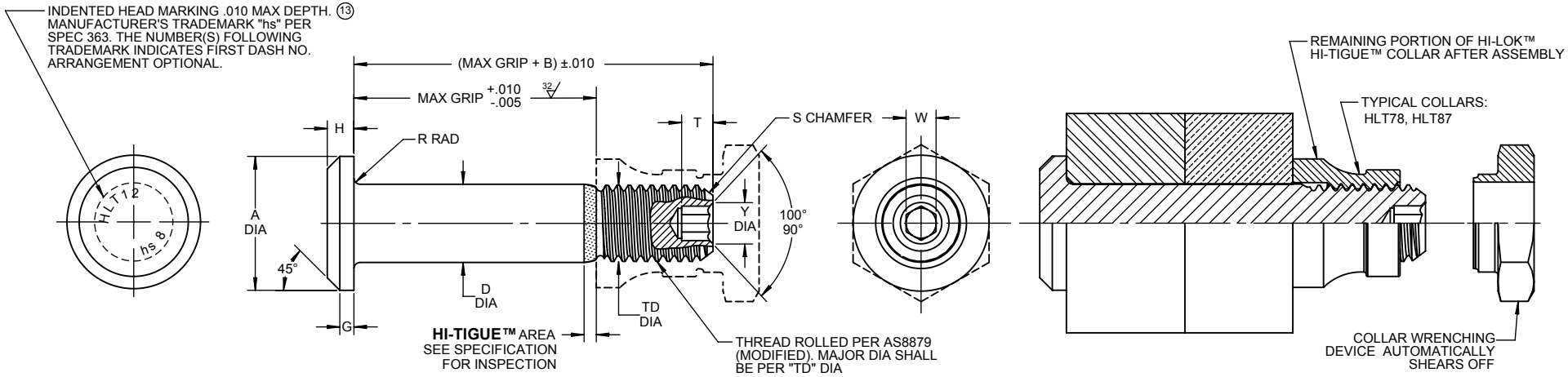

HI-LOK™ HI-TIGUE™ PIN

HI-LOK™ HI-TIGUE™ PIN AND COLLAR AFTER ASSEMBLY

6

FIRST DASH NO.	PIN NOM DIA	**A** DIA	**B** REF	**D** DIA WITHOUT COATING OR SOLID FILM	**D** DIA WITH COATING OR SOLID FILM	**TD** DIA	**G** REF	**H**	**R** RAD	**S** CHAMFER REF	**THREAD** MODIFIED	SOCKET **W** HEX	SOCKET **T** DEPTH	SOCKET **Y** DIA	DOUBLE SHEAR POUNDS	TENSION POUNDS MINIMUM	MIN. GRIP LENGTH
5	5/32	.322 .306	.312	.1695 .1690	.1695 .1685	.1595 .1570	.030	.060 .055	.025 .015	1/32 x 37°	.1640-32 UNJC-3A	.0645 .0635	.100 .080	.090 .075	4,210	2,180	2
6	3/16	.377 .357	.325	.1955 .1950	.1955 .1945	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	5,550	2,750	2
8	1/4	.440 .415	.395	.2555 .2550	.2555 .2545	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	9,620	5,820	2
10	5/16	.505 .475	.500	.3180 .3175	.3180 .3170	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	14,890	9,200	2
12	3/8	.600 .565	.545	.3805 .3800	.3805 .3795	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	21,430	14,000	3
14	7/16	.676 .641	.635	.4430 .4425	.4430 .4420	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	29,000	18,900	4
16	1/2	.770 .735	.685	.5055 .5050	.5055 .5045	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	37,900	25,500	4

SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH

"HI-LOK", "HI-TIGUE", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY	DATE	TITLE
VAN	1968-07-01	HI-LOK™ HI-TIGUE™ PIN PROTRUDING TENSION HEAD TITANIUM 1/16 GRIP VARIATION
APPROVED	DATE	
R.TING	1968-07-25	
REVISION	DATE	DRAWING NUMBER
(13)	M.BEARD 2017-05-17	**HLT12** 1 OF 2

HLT12

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GENERAL NOTES:
1. Concentricity: "A" to "D" diameter within .010 FIM.
(13) 2. Dimensions are in inches and to be met after finish.
(13) 3. Surface texture per ASME B46.1.
4. Hole preparation per NAS618 (Column B) for interference application.
5. Use HLT112 for oversize replacement.
[6] Minimum required for head and HI-TIGUE™ feature.
[7] After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

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

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

FINISH:
HLT12-( )-( ) = Cetyl alcohol lube per Hi-Shear Spec. 305.
[7] HLT12AP( )-( ) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT12TB( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT12UV( )-( ) = Anodize per Hi-Shear Spec. 306, Type II, HI-KOTE™ 2 solid film lube per Hi-Shear Spec 292 (spray only) and cetyl alcohol lube (water base) per Hi-Shear Spec. 305.
HLT12NKJ( )-( ) = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 with color silver on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT12NKK( )-( ) = Sulfuric acid anodizing per ISO8080 and HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only with color silver on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT12NKL( )-( ) = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only with color silver on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
(13) HLT12HK( )-( ) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

SPECIFICATION: HI-LOK™ HI-TIGUE™ Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds.
Second dash number indicates maximum grip in 1/16ths.
See Finish note for explanation of code letters.

HOW TO ORDER
(13) **EXAMPLE:** Pin Part Number
HLT12AP8-8
- 8/16 or 1/2 Maximum Grip Length
- 8/32 or 1/4 Nominal Diameter Pin
- Finish Code
- Pin Basic Part Number

HLT12

DRAWING NUMBER
HLT12