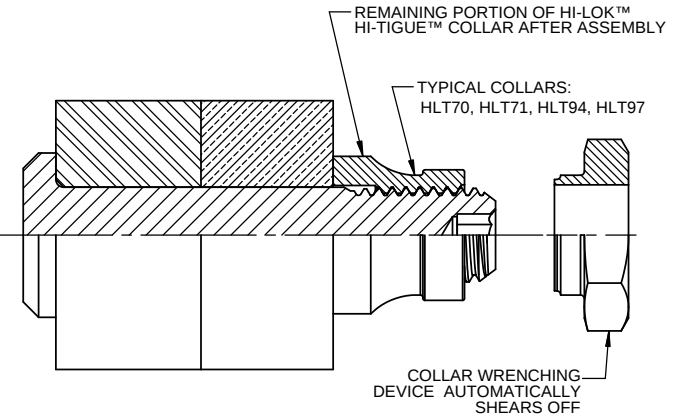
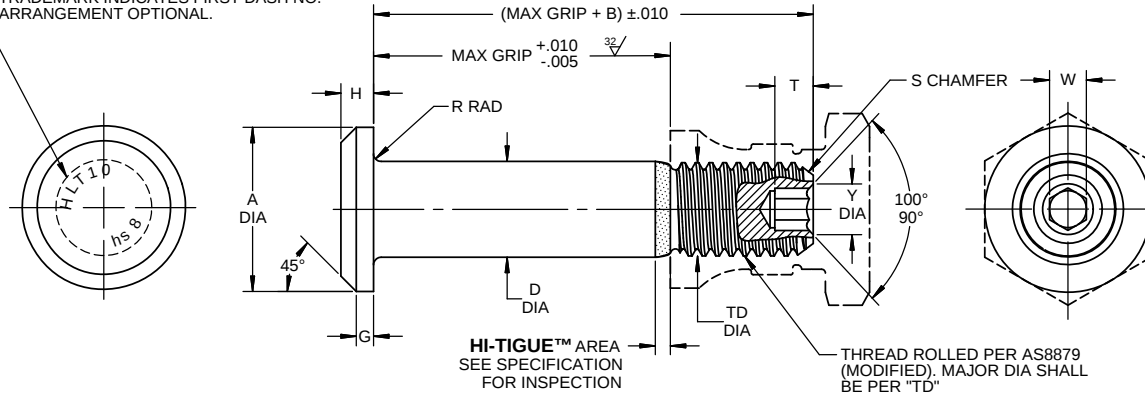


INDENTED HEAD MARKING .010 MAX DEPTH.
 MANUFACTURER'S TRADEMARK "hs" PER
 SPEC 363. THE NUMBER(S) FOLLOWING
 TRADEMARK INDICATES FIRST DASH NO.
 ARRANGEMENT OPTIONAL.



HI-LOK™ HI-TIGUE™ PIN

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING OR SOLID FILM LUBE	WITH COATING OR SOLID FILM LUBE							W HEX	T DEPTH	Y DIA		
5	5/32	.262	.312	.1695	.1695	.1595	.020	.047	.025	1/32 x 37°	.1640-32 UNJC-3A	.0645	.100	.090	4,210	1,940
		.242		.1690	.1685							.0635	.080	.075		
6	3/16	.315	.325	.1955	.1955	.1840	.025	.055	.025	1/32 x 37°	.1900-32 UNJF-3A	.0806	.100	.119	5,550	2,500
		.295		.1950	.1945							.0791	.080	.104		
8	1/4	.412	.395	.2555	.2555	.2440	.030	.069	.025	1/32 x 37°	.2500-28 UNJF-3A	.0967	.110	.142	9,620	4,300
		.387		.2550	.2545							.0947	.090	.122		
10	5/16	.505	.500	.3180	.3180	.3060	.035	.078	.030	3/64 x 37°	.3125-24 UNJF-3A	.1295	.130	.180	14,890	6,300
		.475		.3175	.3170							.1270	.110	.160		
12	3/8	.600	.545	.3805	.3805	.3680	.040	.088	.030	3/64 x 37°	.3750-24 UNJF-3A	.1617	.160	.217	21,430	8,700
		.565		.3800	.3795							.1582	.140	.197		
14	7/16	.676	.635	.4430	.4430	.4310	.045	.105	.030	3/64 x 37°	.4375-20 UNJF-3A	.1930	.190	.253	29,000	12,100
		.641		.4425	.4420							.1895	.170	.233		
16	1/2	.770	.685	.5055	.5055	.4930	.050	.115	.030	3/64 x 37°	.5000-20 UNJF-3A	.2242	.220	.289	37,900	15,300
		.735		.5050	.5045							.2207	.200	.269		

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

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

GENERAL NOTES:

1. Concentricity: "A" to "D" diameter within .010 FIM.
2. Dimensions are in inches and to be met after finish.
3. Surface texture per ASME B46.1.
4. Hole preparation per NAS618 (Column "B") for interference application.
5. Use HLT110 for oversize replacement.
6. Install per Hi-Shear Spec. 299.
7. After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 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: 95,000 psi shear minimum.

- FINISH:
- HLT10(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT10AP(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT10BJ(-)(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT10BV(-)(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, with color code blue on thread end.
 - HLT10TB(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT10HK(-)(-) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397

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

EXAMPLE: Pin Part Number
 HLT10TB8-8
 8/16 or 1/2 Maximum Grip Length
 Replaces 8/32 or 1/4 Nominal Diameter Pin
 Finish Code
 Pin Basic Part number

"HI-LOK", "HI-TIGUE", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY VAN	DATE 1968-06-28	TITLE HI-LOK™ HI-TIGUE™ PIN PROTRUDING SHEAR HEAD TITANIUM 1/16 GRIP VARIATION	
APPROVED R. TING	DATE 1968-07-25	DRAWING NUMBER HLT10	
REVISION 12	DATE KEVIN TRAN 2017-07-06	1 OF 1	

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