



1																			8																		
FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	F	G	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM																			
				WITHOUT COATING PLATING OR S.F.L.	AFTER COATING PLATING OR S.F.L.									W HEX	T DEPTH	Y DIA																					
5						NOTE: Use HLT11 () 6 (-)																															
6	13/64	.3016 .2966	.360	.2026 .2021	.2026 .2016	.1840 .1810	.005	.0080 .0050	.0415 .0394	.030 .020	.015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	6,130	2,000																			
8	17/64	.3948 .3898	.435	.2651 .2646	.2651 .2641	.2440 .2410	.006	.0100 .0070	.0544 .0523	.030 .020	.015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	10,490	3,700																			
10	21/64	.4739 .4689	.545	.3276 .3271	.3276 .3266	.3060 .3020	.007	.0110 .0080	.0614 .0593	.040 .030	.015	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	16,000	5,000																			
12	25/64	.5604 .5554	.590	.3901 .3896	.3901 .3891	.3680 .3640	.008	.0125 .0095	.0714 .0693	.040 .030	.015	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	22,700	7,200																			
14	29/64	.6680 .6620	.690	.4526 .4521	.4526 .4516	.4310 .4260	.009	.0150 .0120	.0904 .0879	.050 .040	.022	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	30,600	10,000																			
16	33/64	.7540 .7480	.740	.5151 .5146	.5151 .5141	.4930 .4880	.010	.0165 .0135	.1002 .0977	.050 .040	.022	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	39,600	13,500																			
18	37/64	.8380 .8310	.825	.5771 .5766	.5771 .5761	.5550 .5500	.010	.0200 .0150	.1094 .1065	.050 .040	.022	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	49,700	17,000																			
20	41/64	.9250 .9180	.890	.6396 .6391	.6396 .6386	.6180 .6120	.010	.0250 .0200	.1197 .1168	.050 .040	.022	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	61,000	21,000																			
24	49/64	1.0970 1.0850	1.115	.7646 .7641	.7646 .7636	.7430 .7370	.012	.0310 .0260	.1394 .1344	.050 .040	.022	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	87,200	30,700																			
28	57/64	1.3197 1.3030	1.285	.8896 .8891	.8896 .8886	.8680 .8610	.014	.0400 .0350	.1804 .1734	.050 .040	.022	5/64 x 37°	.8750-14 UNJF-3A	.3820 .3780	.400 .370	.471 .451	118,000	42,000																			
32	1-1/64	1.5186 1.4995	1.480	1.0146 1.0141	1.0146 1.0136	.9930 .9860	.014	.0500 .0450	.2114 .2034	.050 .040	.022	5/64 x 37°	1.0000-12 UNJF-3A	.5100 .5040	.520 .490	.618 .598	154,000	55,000																			

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 VAN	DATE 1969-07-25	TITLE HI-LOK™ HI-TIGUE™ PIN 100° FLUSH CROWN SHEAR HEAD TITANIUM 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED R. TING	DATE 1969-07-25	
REVISION 9	DATE M. BEARD 2017-05-17	DRAWING NUMBER HLT111

- GENERAL NOTES:**
- 1 Head edge out of roundness shall not exceed "F".
 - 2. Concentricity: Conical surface of head to "D" diameter within .005 FIM.
 - 3. "H" is dimensioned from maximum "D" diameter.
 - ④ 4. Surface texture per ASME B46.1.
 - ⑤ 5. Dimensions are in inches and to be met after finish.
 - 6. Hole preparation per NAS618.
 - 7. Use HLT211 for oversize replacement.
 - 8 Curved or flat edge manufacturer's option.
 - 9 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 Spec. AMS4928 OR AMS4967.

HEAT TREAT: 95,000 psi shear minimum.

- FINISH:**
- HLT111(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
 - ⑨ HLT111AP(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305
 - HLT111LJ(-)(-) = Surface coating per Hi-Shear Spec. 306, Type II, and solid film lube per AS5272, type II.
 - HLT111TB(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec.292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT111V(-)(-) = Solid film lube per Lubeco #2123 plus cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT111VR(-)(-) = Surface coating per HI-Shear Spec. 306, Type II, and solid film lube per Electrofilm #4396 plus cetyl alcohol lube per Hi-Shear Spec. 305.
 - ⑨ HLT111HK(-)(-) = 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 which HLT111 oversize pin replaces..
 Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER

⑨ **EXAMPLE:**

Pin Part Number
 HLT111TB8-8

8/16 or 1/2 Maximum Grip Length
 8/32 or 1/4 Nominal Diameter Pin
 Finish Code
 Pin Basic Part Number

HLT111

DRAWING NUMBER

HLT111

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