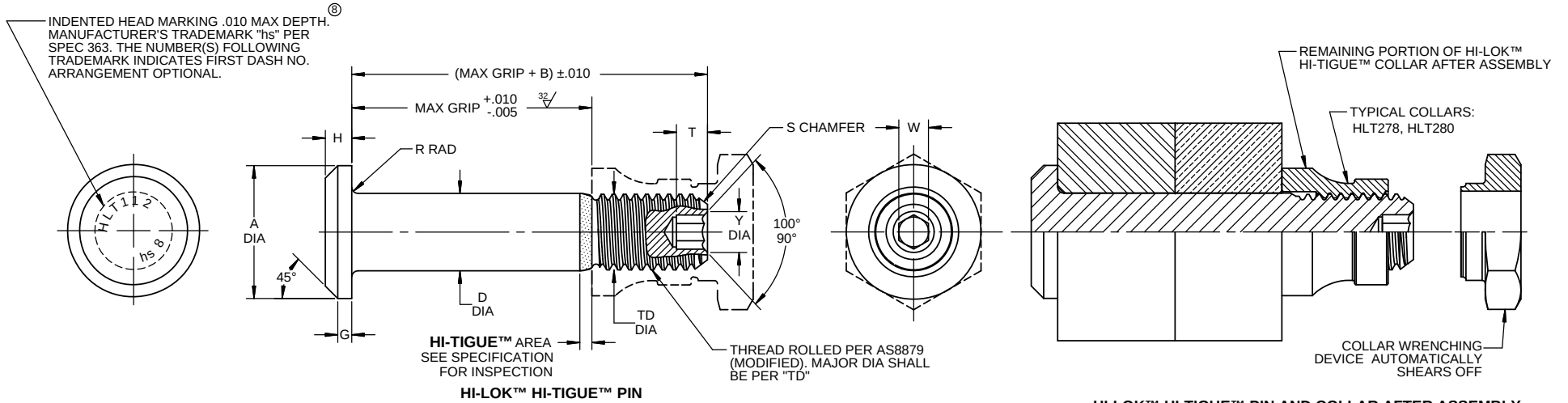


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HI-LOK™ HI-TIGUE™ PIN AND COLLAR AFTER ASSEMBLY

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 SOLID FILM OR COATING	WITH SOLID FILM OR COATING							W HEX	T DEPTH	Y DIA				
5				NOTE: USE HLT12()6-() or HLT412()-6-()														
6	13/64	.377 .357	.360	.2026 .2021	.2026 .2016	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	6,130	2,750		
8	17/64	.440 .415	.435	.2651 .2646	.2651 .2641	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	10,490	5,820		
10	21/64	.505 .472	.545	.3276 .3271	.3276 .3266	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	16,000	9,200		
12	25/64	.600 .530	.590	.3901 .3896	.3901 .3891	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	22,700	14,000		
14	29/64	.676 .592	.690	.4526 .4521	.4526 .4516	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	30,600	18,900		
16	33/64	.770 .717	.740	.5151 .5146	.5151 .5141	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	39,600	25,500		
18	37/64	.877 .842	.825	.5771 .5766	.5771 .5761	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	49,700	32,400		
20	41/64	.953 .918	.890	.6396 .6391	.6396 .6386	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	61,000	41,000		
24	49/64	1.150 1.110	1.115	.7646 .7641	.7646 .7636	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	87,200	59,500		
28	57/64	1.330 1.290	1.285	.8896 .8891	.8896 .8886	.8680 .8610	.250	.385 .370	.050 .035	5/64 x 37°	.8750-14 UNJF-3A	.3820 .3780	.400 .370	.471 .451	118,000	81,500		
32	1-1/64	1.510 1.470	1.480	1.0146 1.0141	1.0146 1.0136	.9930 .9860	.300	.435 .420	.050 .035	5/64 x 37°	1.000-12 UNJF-3A	.5100 .5040	.520 .490	.618 .598	154,000	106,000		

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 PROTRUDING TENSION HEAD TITANIUM 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED R. TING	DATE 1969-07-28	
REVISION 8	DATE M.BEARD 2017-05-17	DRAWING NUMBER HLT112

GENERAL NOTES: 1. Concentricity: "A" to "D" diameter within .010 FIM.
 ⑧ 2. Dimensions are in inches and to be met after finish.
 ⑧ 3. Surface texture per ASME B46.1.
 4. Use HLT212 for oversize replacement.
 [5] 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: HLT112(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
 [5] HLT112AP(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT112LJ(-)(-) = Surface coating per Hi-Shear Spec. 306, Type II, and solid film lube per Spec. AS5272, Type II.
 HLT112LP(-)(-) = Surface coating per Hi-Shear Spec. 306, Type II, solid film lube per Spec. AS5272, Type II and cetyl alcohol per Hi-Shear Spec. 305.
 HLT112TB(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT112V(-)(-) = Solid film lube per Lubeco #2123 plus cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT112VR(-)(-) = 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.
 ⑧ HLT112HK(-)(-) = 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 of the pin which HLT112 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

HOW TO ORDER

⑧ **EXAMPLE:** Pin Part Number

HLT112TB8-8
 └── Pin Basic Part Number
 └── 8/32 or 1/4 Nominal Diameter Pin
 └── 8/16 or 1/2 Maximum Grip Length
 └── Finish Code

HLT112

DRAWING NUMBER

HLT112

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