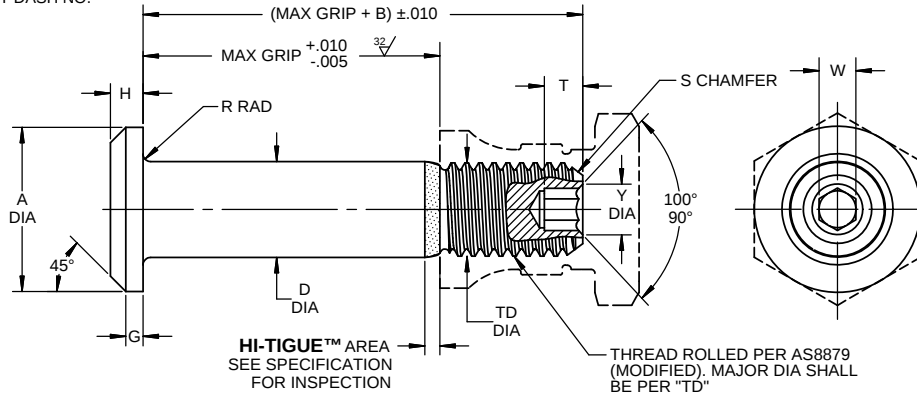
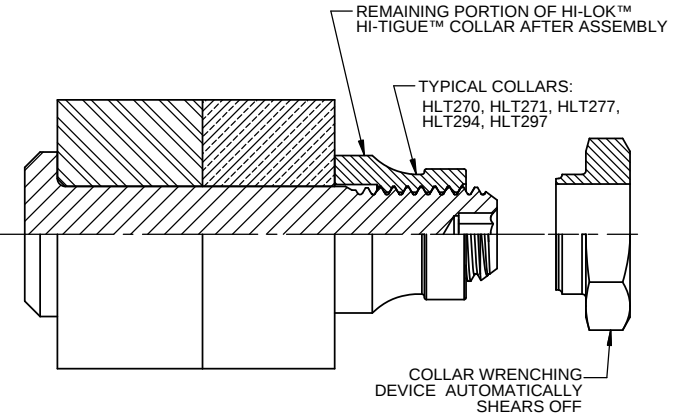


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INDENTED HEAD MARKING .010 MAX DEPTH. ⑨
MANUFACTURER'S TRADEMARK "hs" PER
SPEC 363. THE NUMBER(S) FOLLOWING
TRADEMARK INDICATES FIRST DASH NO.
ARRANGEMENT OPTIONAL.



HI-LOK™ HI-TIGUE™ PIN



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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

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
				WITH CETYL ALCOHOL ONLY	WITH SOLID FILM OR HIKOTE™							W HEX	T DEPTH	Y DIA		
5				NOTE: USE HLT110() 6(-)												
6	7/32	.315 .295	.360	.2182 .2177	.2182 .2172	.1840 .1810	.025	.055 .045	.025 .015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	7,100	2,500
8	9/32	.412 .387	.435	.2807 .2802	.2807 .2797	.2440 .2410	.030	.069 .059	.025 .015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	11,800	4,300
10	11/32	.505 .475	.545	.3432 .3427	.3432 .3422	.3060 .3020	.035	.078 .068	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	17,600	6,300
12	13/32	.600 .565	.590	.4057 .4052	.4057 .4047	.3680 .3640	.040	.088 .078	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	24,600	8,700
14	15/32	.676 .641	.690	.4682 .4677	.4682 .4672	.4310 .4260	.045	.105 .093	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	32,700	12,100
16	17/32	.770 .735	.740	.5307 .5302	.5307 .5297	.4930 .4880	.050	.115 .103	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	42,000	15,300
18	19/32	.864 .829	.825	.5927 .5922	.5927 .5917	.5550 .5500	.055	.127 .112	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	52,400	19,000
20	21/32	.953 .918	.890	.6552 .6547	.6552 .6542	.6180 .6120	.060	.137 .122	.040 .025	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	64,100	23,000
24	25/32	1.108 1.066	1.115	.7802 .7797	.7802 .7792	.7430 .7370	.070	.151 .136	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	90,900	30,700
28	29/32	1.285 1.241	1.285	.9052 .9047	.9052 .9042	.8680 .8610	.090	.187 .172	.050 .035	5/64 x 37°	.8750-14 UNJF-3A	.3820 .3780	.400 .370	.471 .451	122,000	45,000
32	1-1/32	1.468 1.424	1.480	1.0302 1.0297	1.0302 1.0292	.9930 .9860	.110	.218 .203	.060 .045	5/64 x 37°	1.000-12 UNJF-3A	.5100 .5040	.520 .490	.618 .598	158,000	60,900

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

DRAWN BY VAN	DATE 1969-07-23	TITLE HI-LOK™ HI-TIGUE™ PIN PROTRUDING SHEAR HEAD TITANIUM 1/16 GRIP VARIATION, 1/32 OVERSIZE
APPROVED R. TING	DATE 1969-07-25	
REVISION 9	DATE M.BEARD 2017-05-31	DRAWING NUMBER HLT210

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 - ⑨ 2. Dimensions are in inches and to be met after finish.
 - ⑨ 3. Surface texture per ASME B46.1.
 4. Oversize pin for HLT410 and HLT110.
 - 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: 95,000 psi shear minimum.

- FINISH:**
- HLT210(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
 - ⑤ HLT210AP(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT210LJ(-)(-) = Surface coating per Hi-Shear Spec. 306, Type II, and solid film lube per Spec. AS5272, Type II.
 - HLT210LP(-)(-) = Surface coating per Hi-Shear Spec. 306, Type II, solid film lube per Spec. AS5272, Type II and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT210TB(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT210V(-)(-) = Solid film lube per Lubeco #2123 plus cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT210VR(-)(-) = 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 HLT210HK(-)(-) = 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 HLT210 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
 HLT210TB8-8

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

HLT210

DRAWING NUMBER

HLT210

2 OF 2