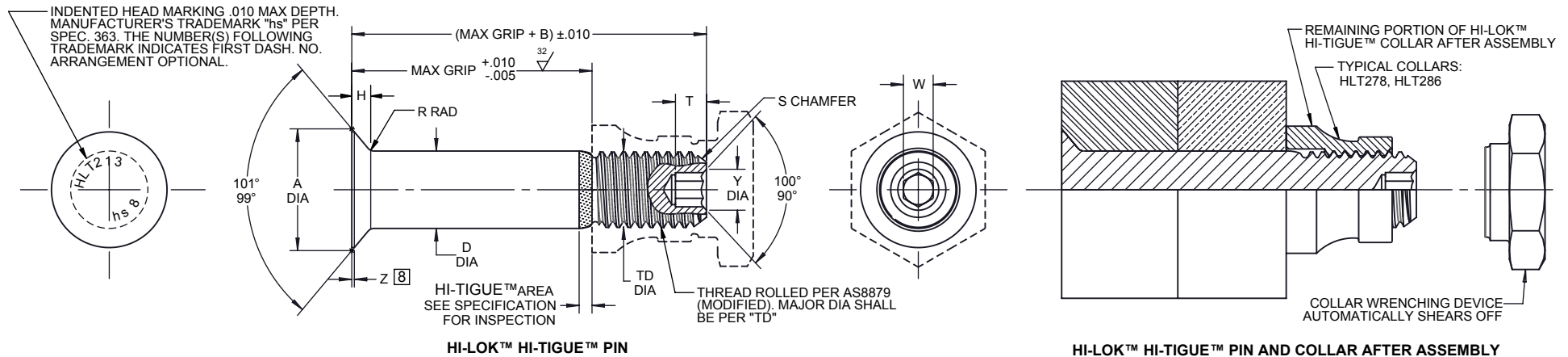




SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH

1																	8																
FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	F	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 HLT113() (6- ()																												
6	7/32	.3813 .3765	.360	.2182 .2177	.2182 .2172	.1840 .1810	.005	.0684 .0664	.030 .020	.015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	7,100	2,750																
8	9/32	.5066 .5018	.435	.2807 .2802	.2807 .2797	.2440 .2410	.006	.0948 .0928	.030 .020	.015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	11,800	5,820																
10	11/32	.6335 .6287	.545	.3432 .3427	.3432 .3422	.3060 .3020	.007	.1218 .1198	.040 .030	.015	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	17,600	9,200																
12	13/32	.7604 .7556	.590	.4057 .4052	.4057 .4047	.3680 .3640	.008	.1488 .1468	.040 .030	.015	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	24,600	14,000																
14	15/32	.8884 .8812	.690	.4682 .4677	.4682 .4672	.4310 .4260	.009	.1763 .1733	.050 .040	.022	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	32,700	18,900																
16	17/32	1.0139 1.0068	.740	.5307 .5302	.5307 .5297	.4930 .4880	.010	.2027 .1997	.050 .040	.022	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	42,000	25,500																
18	19/32	1.1408 1.1337	.825	.5927 .5922	.5927 .5917	.5550 .5500	.010	.2300 .2270	.050 .040	.025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	52,400	32,400																
20	21/32	1.2723 1.2651	.890	.6552 .6547	.6552 .6542	.6180 .6120	.010	.2589 .2559	.050 .040	.025	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	64,100	41,000																
24	25/32	1.5308 1.5236	1.115	.7802 .7797	.7802 .7792	.7430 .7370	.012	.3149 .3119	.050 .040	.025	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	90,900	59,500																
28	29/32	1.7845 1.7773	1.285	.9052 .9047	.9052 .9042	.8680 .8610	.014	.3689 .3659	.050 .040	.025	5/64 x 37°	.8750-14 UNJF-3A	.3820 .3780	.400 .370	.471 .451	122,000	81,500																
32	1-1/32	2.0405 2.0310	1.480	1.0302 1.0297	1.0302 1.0292	.9930 .9860	.014	.4239 .4199	.050 .040	.025	5/64 x 37°	1.0000-12 UNJF-3A	.5100 .5040	.520 .490	.618 .598	158,000	106,000																

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

DRAWN BY VAN	DATE 1969-07-29	TITLE HI-LOK™ HI-TIGUE™ PIN 100° FLUSH MS24694 TENSION HEAD TITANIUM 1/16 GRIP VARIATION, 1/32 OVERSIZE	
APPROVED R. TING	DATE 1969-07-30	DRAWING NUMBER HLT213	
REVISION 10	DATE F. CARINGELLA 2019-01-10	1 OF 2	

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. Dimensions are in inches and to be met after finish.
5. Surface texture per ASME B46.1.
6. Hole preparation per NAS618.
7. Oversize replacement pin for HLT1113 and HLT413.
- 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 AMS4928 OR AMS4967.

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

- FINISH:**
- HLT213-()-() = Cetyl alcohol lube per Hi-Shear Spec. 305.
 - 9 HLT213AP()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT213LJ()-() = Surface coating per Hi-Shear Spec. 306, Type II and solid film lube per AS5272.
 - HLT213LP()-() = Surface coating per Hi-Shear Spec. 306, Type II, solid film lube per Spec. AS5272 except top surface of head shall be uncoated, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 10 HLT213TB()-() = HI-KOTE™ 2 per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT213V()-() = Solid film lube per Lubeco #2123 plus cetyl alcohol.
 - HLT213VR()-() = 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.
 - HLT213HK()-() = 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 HLT213 oversize pin replaces..
 Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

**HOW TO ORDER
 EXAMPLE:**

Pin Part Number
 HLT213TB8-8

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