lisi AEROSPACE
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR Corporation, USA
a LISI AEROSPACE Company

Design Holder

CAGE No. 73197

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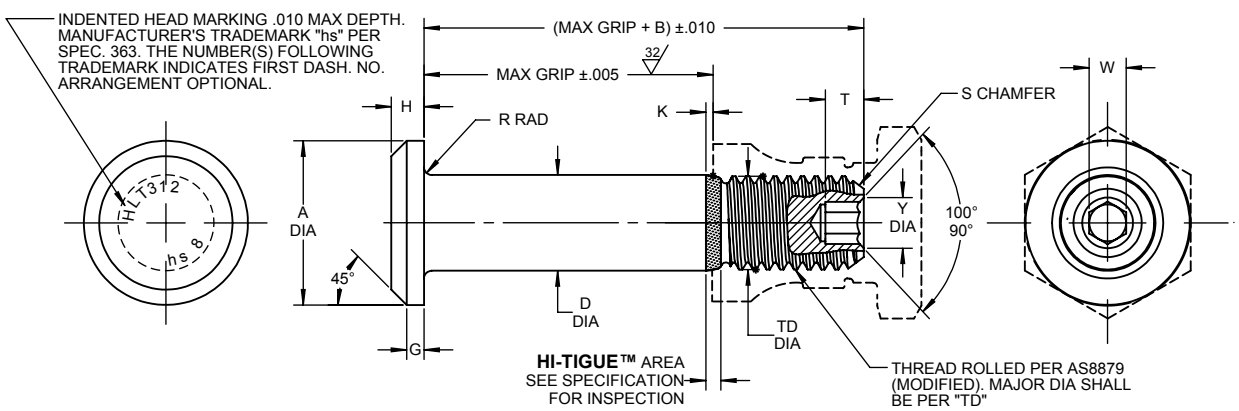
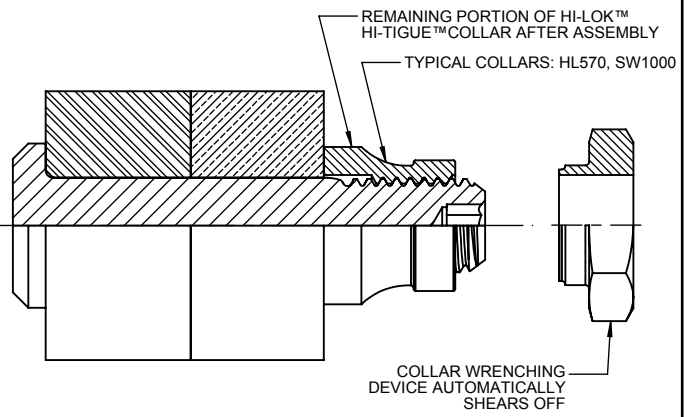
HTTP://WWW.LISI-AEROSPACE.COM/LICENSES



HI-LOK™ HI-TIGUE™ PIN



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**	**K** REF	**R** RAD	**S** CHAMFER REF	**THREAD** MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
												W HEX	**T** DEPTH	**Y** DIA		
5	5/32	.322 .306	.312	.1635 .1630	.1595 .1570	.030	.065 .055	.013	.025 .015	1/32 x 37°	.1640-32 UNJC-3A	.0801 .0791	.135 .115	5	4,010	2,180
6	3/16	.377 .357	.325	.1895 .1890	.1840 .1810	.035	.074 .064	.016	.025 .015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	5,380	3,180
8	1/4	.440 .415	.395	.2495 .2490	.2440 .2410	.045	.090 .080	.021	.025 .015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	9,300	5,820
10	5/16	.505 .475	.500	.3120 .3115	.3060 .3020	.055	.112 .102	.026	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	14,600	9,200
12	3/8	.600 .565	.545	.3745 .3740	.3680 .3640	.075	.140 .130	.030	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	21,000	14,000
14	7/16	.676 .641	.635	.4370 .4365	.4310 .4260	.095	.160 .150	.035	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	28,600	18,900
16	1/2	.770 .735	.685	.4995 .4990	.4930 .4880	.095	.188 .178	.039	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	37,300	25,500

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	DATE	TITLE
D.P.S.	1978-11-11	HI-LOK™ HI-TIGUE™ PIN PROTRUDING TENSION HEAD TITANIUM 1/16 GRIP VARIATION
APPROVED	DATE	
JGWILCOX	1978-11-12	
REVISION	DATE	DRAWING NUMBER
11	S. WILEY 2018-09-11	**HLT312** 1 OF 2

HLT312

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GENERAL NOTES:
1. Concentricity: "A" to "D" diameter within .010 FIM.
2. Dimensions are in inches and to be met before finish.
3. Surface texture per ASME B46.1.
4. Hole preparation per NAS618.
5. Evidence of broken edge across points.
6. Use HLT612 for oversize replacement.
7. 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.

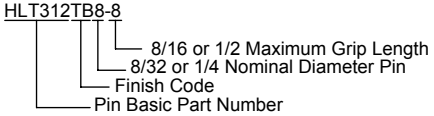
HEAT TREAT: 95,000 psi shear minimum.

FINISH:
(11) HLT312-( )-( ) = Cetyl alcohol lube per Hi-Shear Spec. 305.
HLT312AP( )-( ) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305. [7]
HLT312DL( )-( ) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT312TA( )-( ) = Anodize per Ti-Shield III, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT312TB( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT312HK( )-( ) = 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.
Second dash number indicates maximum grip in 1/16ths.
See Finish note for explanation of code letters.

HOW TO ORDER EXAMPLE: Pin Part Number
HLT312TB8-8



HLT312

DRAWING NUMBER
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