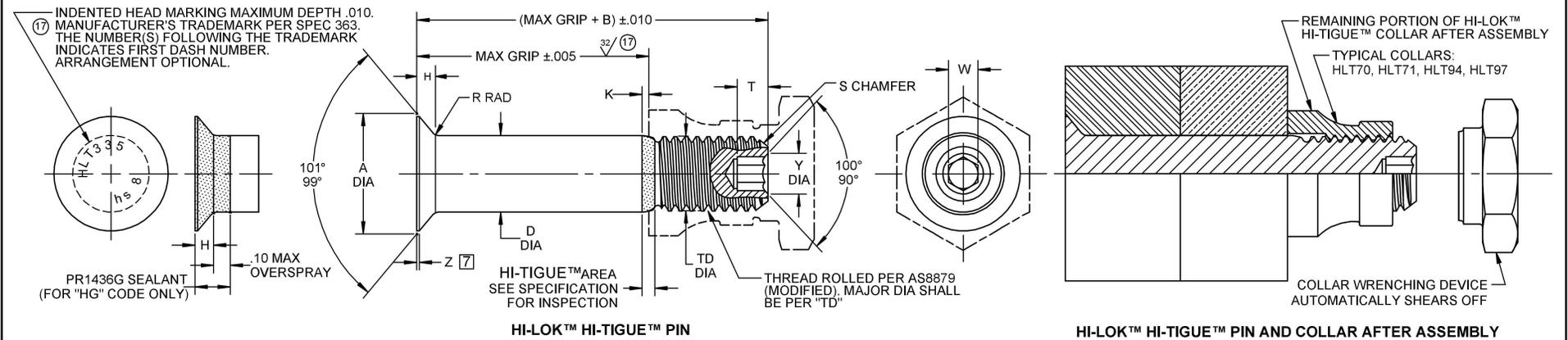


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HI-LOK™ HI-TIGUE™ PIN

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

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	F	H	K REF	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING OR SOLID FILM LUBE	AFTER COATING OR SOLID FILM LUBE									W HEX	T DEPTH	Y DIA		
4	1/8	.2219	.294	.1375	.1375	.1335	.003	.0354	.010	.020	.010	1/32 x 37°	.1380-32 UNJC-3A	.0645	.100	.090	2,840	950
		.2171		.1370	.1365	.0635								.080	.075			
5	5/32	.2612	.312	.1640	.1640	.1595	.004	.0408	.013	.025	.015	1/32 x 37°	.1640-32 UNJC-3A	.0645	.100	.090	4,010	1,290
		.2564		.1635	.1630	.0635								.080	.075			
6	3/16	.3016	.325	.1895	.1895	.1840	.005	.0470	.016	.030	.015	1/32 x 37°	.1900-32 UNJF-3A	.0806	.100	.119	5,380	2,000
		.2966		.1890	.1885	.0791								.080	.104			
8	1/4	.3948	.395	.2495	.2495	.2440	.006	.0610	.021	.030	.015	1/32 x 37°	.2500-28 UNJF-3A	.0967	.110	.142	9,300	3,700
		.3898		.2490	.2485	.0947								.090	.122			
10	5/16	.4739	.500	.3120	.3120	.3060	.007	.0679	.026	.040	.015	3/64 x 37°	.3125-24 UNJF-3A	.1295	.130	.180	14,600	5,000
		.4689		.3115	.3110	.1270								.110	.160			
12	3/8	.5604	.545	.3745	.3745	.3680	.008	.0780	.030	.040	.015	3/64 x 37°	.3750-24 UNJF-3A	.1617	.160	.217	21,000	7,200
		.5554		.3740	.3735	.1582								.140	.197			
14	7/16	.6680	.635	.4370	.4370	.4310	.009	.0969	.035	.050	.022	3/64 x 37°	.4375-20 UNJF-3A	.1930	.190	.253	28,600	10,000
		.6620		.4365	.4360	.1895								.170	.233			
16	1/2	.7540	.685	.4995	.4995	.4930	.010	.1068	.039	.050	.022	3/64 x 37°	.5000-20 UNJF-3A	.2242	.220	.289	37,300	13,500
		.7480		.4990	.4985	.2207								.200	.269			
18	9/16	.8380	.770	.5615	.5615	.5550	.010	.1160	.039	.050	.022	1/16 x 37°	.5625-18 UNJF-3A	.2555	.260	.326	47,200	17,000
		.8310		.5610	.5605	.2520								.240	.306			

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

HLT335

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

DRAWN BY VAN	DATE 1969-02-12	TITLE HI-LOK™ HI-TIGUE™ PIN 100° FLUSH SHEAR HEAD TITANIUM 1/16 GRIP VARIATION
APPROVED MILLER	DATE 1969-02-17	DRAWING NUMBER HLT335
REVISION 17	DATE Kevin Pham 2022-04-07	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 FIR.
- 3 "H" is dimensioned from maximum "D" diameter.
- 4 Surface texture per ASME B46.1.
- 5 Dimensions are in inches and to be met after finish.
- 6 Hole preparation per NAS618.
- 7 Curved or flat edge manufacturer's option.
- 8 Maximum "D" diameter may be increased by .0002 to allow for aluminum coating application.
- 9 Use HLT435 for oversize replacement.
- 10 After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in UK and European Union.

MATERIAL: 6Al-4V titanium alloy per AMS4928 or AMS4967.

HEAT TREAT: 95,000 psi shear minimum.

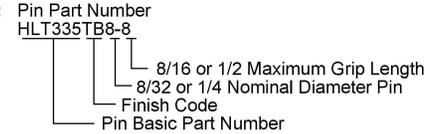
- 17 **FINISH:** HLT335(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
- 17 10 HLT335AP(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT335BJ(-)(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT335HG(-)(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and apply precoat No. PR1436G sealant (.002-.005 thick), and cetyl alcohol lube per Hi-Shear Spec. 305.
- 17 HLT335TA(-)(-) = Ti-Shield III or Tiodize Type II, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT335TB(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec.292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT335HK(-)(-) = 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:



HLT335

DRAWING NUMBER

HLT335

2 OF 2