

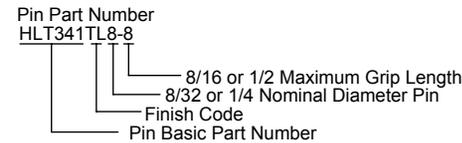
SEE COLLAR STANDARDS
 FOR COLLAR STRENGTHS.
 LOWER STRENGTH (PIN OR
 COLLAR) DETERMINES
 SYSTEM STRENGTH

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	F	H	R RAD	Z	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
												W HEX	T DEPTH	Y DIA		
5	5/32	.2612 .2564	.395	.1685 .1680	.1595 .1570	.004	.0389 .0369	.025 .015	.010 .005	1/32 x 37°	.1640-32 UNJC-3A	.0645 .0635	.135 .115	.090 .075	4,210	1,290
6	3/16	.3016 .2966	.410	.1945 .1940	.1840 .1810	.005	.0449 .0428	.030 .020	.015 .005	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	5,550	2,000
8	1/4	.3948 .3898	.485	.2545 .2540	.2440 .2410	.006	.0598 .0568	.030 .020	.015 .005	1/32 x 37°	2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	9,620	3,700
10	5/16	.4739 .4689	.600	.3175 .3170	.3060 .3020	.007	.0656 .0635	.040 .030	.015 .005	1/32 x 37°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	14,900	5,000
12	3/8	.5604 .5554	.645	.3805 .3800	.3680 .3640	.008	.0755 .0734	.040 .030	.015 .005	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	21,500	7,200
14	7/16	.6680 .6620	.745	.4435 .4430	.4310 .4260	.009	.0942 .0917	.050 .040	.022 .005	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	29,200	10,000
16	1/2	.7540 .7480	.800	.5065 .5060	.4930 .4880	.010	.1038 .1013	.050 .040	.022 .005	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	38,100	13,500
20	5/8	.9250 .9180	.950	.6325 .6320	.6180 .6120	.010	.1227 .1197	.050 .040	.022 .005	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	59,500	21,000
24	3/4	1.0970 1.0850	1.170	.7585 .7580	.7430 .7370	.012	.1420 .1370	.050 .040	.022 .005	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	85,600	30,700

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .005 FIM.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions in inches, to be met after finish and before solid film lubricant, where applicable.
 - Surface texture per ASME B46.1.
 - Hole preparation per NAS618.
 - Use HLT441 for oversize replacement.
 - Curve or flat edge manufacturer's option.

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:



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

HEAT TREAT: 95,000 psi shear minimum.

FINISH: HLT341TL(-)(-) = Anodize per Tiodize Type II, solid film lube per TI-O-LUBE TAL-58, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LOK™ HI-TIGUE™ Product Specification 342.

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

DRAWN BY VAN	DATE 1969-06-12	TITLE HI-LOK™ HI-TIGUE™ PIN 100° FLUSH SHEAR HEAD TITANIUM 1/16 GRIP VARIATION
APPROVED Von Miller	DATE 1969-06-13	DRAWING NUMBER HLT341
REVISION 13	DATE F. CARINGELLA 2019-09-11	1 OF 1