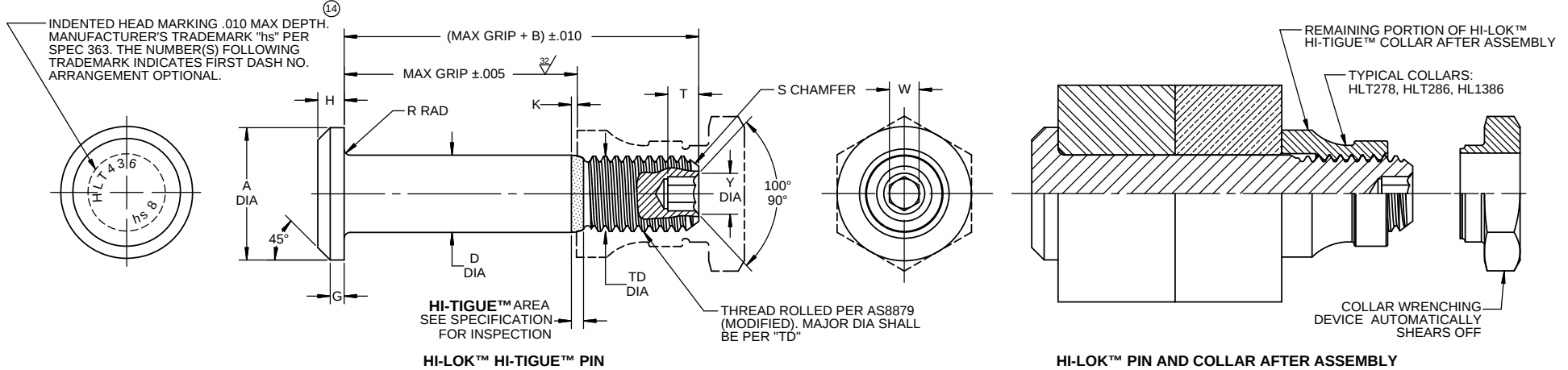


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FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	G REF	H	K REF	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS	TENSION POUNDS MINIMUM
				CETYL ALCOHOL	WITH COATING OR SOLID FILM								W HEX	T DEPTH	Y DIA		
5				NOTE: USE HLT336-6 OR HLT452-6													
6	13/64	.377 .357	.360	.2026 .2021	.2026 .2016	.1840 .1810	.035	.074 .064	.020	.025 .015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	6,130	2,750
8	17/64	.440 .415	.435	.2651 .2646	.2651 .2641	.2440 .2410	.045	.090 .080	.025	.025 .015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	10,490	5,820
10	21/64	.505 .475	.546	.3276 .3271	.3276 .3266	.3060 .3020	.055	.112 .102	.031	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	16,000	9,200
12	25/64	.600 .530	.590	.3901 .3896	.3901 .3891	.3680 .3640	.075	.140 .130	.037	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	22,700	14,000
14	29/64	.676 .592	.690	.4526 .4521	.4526 .4516	.4310 .4260	.095	.160 .150	.039	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	30,600	18,900
16	33/64	.770 .717	.740	.5151 .5146	.5151 .5141	.4930 .4880	.095	.188 .178	.045	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	39,600	25,500
18	37/64	.877 .842	.825	.5771 .5766	.5771 .5761	.5550 .5500	.125	.210 .200	.043	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	49,700	32,400

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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 VAN	DATE 1969-03-17	TITLE HI-LOK™ HI-TIGUE™ PIN PROTRUDING TENSION HEAD TITANIUM 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED VON MILLER	DATE 1969-03-19	
REVISION 14	DATE M.BEARD 2017-10-24	DRAWING NUMBER HLT436

1 OF 2

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 - ⑭ 2. Surface texture per ASME B46.1.
 3. Hole preparation per NAS618.
 4. Use HLT636 for oversize replacement.
 - ⑤ 5. Maximum "D" diameter may be increased by .0002 to allow for coating application.
 - ⑥ 6. 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 European Union.
 - ⑭ 7. All dimensions are in inches.

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

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

- FINISH:**
- HLT436-()-() = Cetyl alcohol lube per Hi-Shear Spec. 305.
 - ⑥ HLT436AP()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT436BJ()-() = I.V.D. aluminum coating per MIL-DLT-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT436FE()-() = Grit blast top of head, cetyl alcohol lube per Hi-Shear Spec. 305 and red identification on thread end.
 - HLT436TA()-() = Ti-Shield IIIA or Tiodize, Type II, HI-KOTE™ 2 solid film lube per Hi-Shear Spec 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT436TB()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ⑭ HLT436HK()-() = 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 HLT436 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

HOW TO ORDER

⑭ **EXAMPLE:** Pin Part Number
 HLT436TB8-8

