corporation ark drive, torrance, California 90509 U.S.A.	HI-SHEAR Corporation, USA Design Holder CAGE No. 731 a LISI AEROSPACE Company For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at: HTTP://WWW.LISI-AEROSPACE.COM/LICENSES
INDENTED HEAD MARKING .010 MAX DEPTH. The "INDICATES HI-SHEAR TRADEMARK THE NUMBER. ARRANGEMENT OPTIONAL	REMAINING PORTION OF HI-LOK HI-TIGUE TM COLLAR AFTER ASSEMBLY TYPICAL COLLARS: HIT278, HIT286, HI 1386 HIT278, HIT286, HI 1386 COLLAR WRENCHING DEVICE AUTOMATICALLY SHEARS OFF
8 1 7	
B I T DASH NOM DIA BREF DIA TD MODIO OR SOLID OR SOLID DIA F H K REF REF MODIFIED W T Y MINIMUUE MINIMUE	AR I LENSION LOWER STRENGTH (PIN OR DS POUNDS COLLAR) DETERMINES
FIRST PIN A B DIA DIA DIA DIA DIA DIA CONTING CONTING CONTING CONTING CONTING CONTING CONTING CONTING DIA F H K REF RAD MAX CHAMFER MODIFIED W T Y POUND	LE TENSION FOR COLLAR STRENGTHS. RR POUNDS COLLAR STRENGTH (PIN OR COLLAR) DETERMINES
FIRST DASH DASH PIN DIA A DIA B REF D DIA TD DIA F H K REF RAD S CHAMFER REF MODIFIED W REF W T Y DIA D DIA MODIFIED NOM NOM NOM NOM REF CONTING	LE TENSION FOR COLLAR STRENGTHS. AR POUNDS COLLAR STRENGTH (PIN OR DO NOR DO N
FIRST DASH NO. PIN DIA A DIA B REF D DIA WTHOUT CONTING CONTING FILM LUBE FILM LUBE F	LE TENSION FOR COLLAR STRENGTHS. POUNDS COLLAR STRENGTH (PIN OR COLLAR) DETERMINES UM MINIMUM SYSTEM STRENGTH 0 2,750
$ \begin{array}{ c c c c c c c c c c c c c c c c c c c$	LE TENSION POUNDS COLLAR STRENGTHS. DO 2,750 0 5,820 FOR COLLAR STRENGTH (PIN OR LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH
$ \begin{array}{ c c c c c c c c c c c c c c c c c c c$	LE TENSION POUNDS COLLAR STRENGTHS. NINIMUM FOR COLLAR STRENGTH (PIN OR COLLAR) DETERMINES UM SYSTEM STRENGTH 0 2,750 10 5,820 10 9,200
$ \begin{array}{ c c c c c c c c c c c c c c c c c c c$	LE TENSION POUNDS UM POUNDS MINIMUM 0 2,750 00 5,820 00 9,200 00 14,000
$ \begin{array}{ c c c c c c c c c c c c c c c c c c c$	LE TENSION POUNDS UM POUNDS MINIMUM 0 2,750 00 5,820 00 9,200 00 14,000 00 18,900
$ \begin{array}{ c c c c c c c c c c c c c c c c c c c$	LE TENSION POUNDS UM POUNDS MINIMUM 0 2,750 0 5,820 00 9,200 00 14,000 00 18,900
$ \begin{array}{ c c c c c c c c c c c c c c c c c c c$	LE RR POUNDS UM FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH 0 2,750 00 5,820 00 14,000 00 18,900 00 32,400

DATE F.CARINGELLA 2018-10-11 ©2018 Hi-Shear Corporation

DATE

1969-03-18

DATE

1969-03-19

^{TITLE} HI-LOK™ HI-TIGUE™ PIN

100° FLUSH MS24694 TENSION HEAD

TITANIUM

1/16 GRIP VARIATION, 1/64 OVERSIZE DRAWING NUMBER

1 OF 2

DRAWN BY

APPROVED

MILLER

REVISION 21

VAN



SPECIFICATION: HI-LOK™ HI-TIGUE™ Product Specification 342. GENERAL NOTES: 1 Head edge out of roundness shall not exceed "F". Concentricity: Conical surface of head to "D" diameter within .005 FIM. 3. "H" is dimensioned from maximum "D" diameter. **CODE:** First dash number indicates nominal diameter in 1/32nds. Surface texture per ASME B46.1. of which HLT437 oversize pin replaces. 5. Dimensions are in inches and to be met after finish. Second dash number indicates maximum grip in 1/16ths. 6. Hole preparation per NAS618. See Finish note for explanation of code letters. 7 Curved or flat edge manufacturer's option. HOW TO ORDER 8 Maximum "D" diameter may be increased by .0002 to allow for EXAMPLE: Pin Part Number aluminum coating application. HLT437TB8-8 9. Use HLT637 for oversize replacement. 10 After February, 21st of 2015, HI-KOTE[™] 1 aluminum pigmented coating per └── 8/16 or 1/2 Maximum Grip Length 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. - 8/32 or 1/4 Nominal Diameter Pin Finish Code Pin Basic Part Number MATERIAL: 6AI-4V titanium allov per AMS4928 or AMS4967. HEAT TREAT: 95,000 psi shear minimum. **FINISH:** HLT437-()-() = Cetyl alcohol lube per Hi-Shear Spec. 305. = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear 10 HLT437AP()-() Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305. 10 HLT437AZ()-() = HI-KOTE[™] 1 aluminum coating per Hi-Shear Spec. 294, color black on thread end and cetyl alcohol lube per Hi-Shear Spec. 305. HLT437BJ()-() = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305. (2) 10 HLT427FD()-() = HI-KOTE[™] 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color red on thread end, and cetvl alcohol lube per Hi-Shear Spec. 305. (21) HLT437FE()-() = Grit blast top of head with red on thread end and cetvl alcohol lube per Hi-Shear Spec. 305. HLT437FB()-() = Grit blast top of head and cetyl alcohol lube per Hi-Shear Spec. 305. HLT437FW()-() = Grit blast top of head, HI-KOTE[™] 2 solid film lube on threads only per Hi-Spec. 292, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305. HLT437HG()-() = 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. (2) 10 HLT437KM()-() = HI-KOTE[™] 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305. HLT437ST()-() = Grit blast top of head, color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305. HLT437TA()-() = Surface preparation per Ti-Shield III, HI-KOTE[™] 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305. HLT437TB()-() = HI-KOTE[™] 2 solid film lube per Hi-Shear Spec.292, and cetyl alcohol lube per Hi-Shear Spec. 305. HLT437YT()-() = Grit blast top of head, color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305. HLT437HK()-() = HI-KOTE[™] 4 NC aluminum coating per Hi-Shear Spec. 397.

©2018 Hi-Shear Corporation

DRAWING NUMBER

2 OF 2