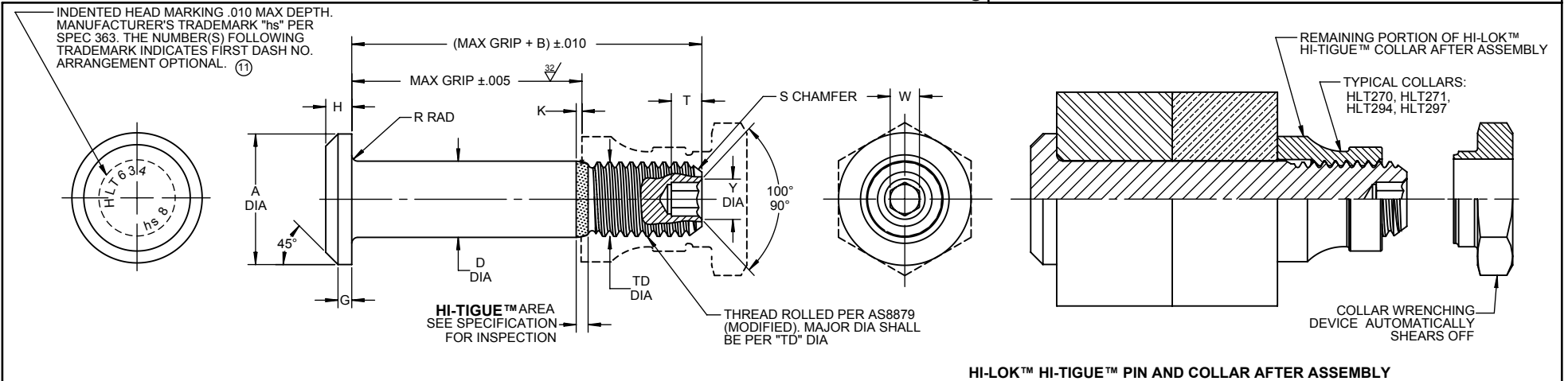




HI-LOK™ HI-TIGUE™ PIN

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

5																	
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
				WITH CETYL ALCOHOL	AFTER COATING OR S.F.L								W HEX	T DEPTH	Y DIA		
5				NOTE: USE HLT334-6 OR HLT450-6													
6	7/32	.315 .295	.360	.2182 .2177	.2182 .2172	.1840 .1810	.025	.055 .045	.022	.025 .015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	7,100	2,500
8	9/32	.412 .387	.435	.2807 .2802	.2807 .2797	.2440 .2410	.030	.069 .059	.027	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	11,800	4,300
10	11/32	.505 .475	.545	.3432 .3427	.3432 .3422	.3060 .3020	.035	.078 .068	.032	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	17,600	6,300
12	13/32	.600 .565	.590	.4057 .4052	.4057 .4047	.3680 .3640	.040	.088 .078	.036	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	24,600	8,700
14	15/32	.676 .641	.690	.4682 .4677	.4682 .4672	.4310 .4260	.045	.105 .093	.035	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	32,700	12,100
16	17/32	.770 .735	.740	.5307 .5302	.5307 .5297	.4930 .4880	.050	.116 .103	.045	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	42,000	15,300
18	19/32	.864 .829	.825	.5927 .5922	.5927 .5917	.5550 .5500	.055	.127 .112	.041	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	52,400	19,000

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

HLT634

"HI-LOK", "HI-TIGUE", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION		
DRAWN BY VAN	DATE 1969-03-20	TITLE HI-LOK™ HI-TIGUE™ PIN PROTRUDING SHEAR HEAD TITANIUM 1/16 GRIP VARIATION, 1/32 OVERSIZE
APPROVED VON MILLER	DATE 1969-03-24	
REVISION 11	DATE K. TRAN 2017-10-25	DRAWING NUMBER HLT634 1 OF 2

GENERAL NOTES:

1. Concentricity: "A" to "D" diameter within .010 FIM.
- ① 2. Surface texture per ASME B46.1.
3. Hole preparation per NAS618.
- ① 4. Dimensions are in inches and to be met after finish.
- ⑤ 5. Maximum "D" diameter may be increased by .0002 to allow for coating application.
6. Oversize replacement for HTL434 and HLT334.
- ⑦ 7. 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.

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

HEAT TREAT: 95,000 psi shear minimum.

FINISH:

- HLT634-()-() = Cetyl alcohol lube per Hi-Shear Spec. 305.
- ⑦ HLT634AP()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT634BJ()-() = I.V.D. aluminum coating per MIL-DLT-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT634TA()-() = 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.
- HLT634TB()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- ① HLT634HK()-() = 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 HLT634 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER

① **EXAMPLE:** Pin Part Number
 HLT634TB8-8

8/16 or 1/2 Maximum Grip Length
 8/32 or 1/4 Nominal Diameter Pin
 Finish Code
 Pin Basic Part Number

HLT634

DRAWING NUMBER

HLT634

2 OF 2