	HI-SHEAR Corporation, USA Design Holder CAGE No. 73197 a LISI AEROSPACE Company
[[J]	For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at:
hr-shear corporation 2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.	HTTP://WWW.LISI-AEROSPACE.COM/LICENSES
INDENTED HEAD MARKING MAXIMUM DEPTH .010. MANUFACTURER'S TRADEMARK PER HI-SHEAR SPEC 363. THE NUMBER(S) FOLLOWING THE TRADEMARK INDICATES FIRST DASH NUMBER. ARRANGEMENT OPTIONAL. MAX GRIP ±.005	REMAINING PORTION OF HI-LOK™ HI-TIGUE™ COLLAR AFTER ASSEMBLY TYPICAL COLLARS: HLT270, HLT271, HLT294, HLT297
$\left(\begin{array}{c} \left(\overrightarrow{z} + \overrightarrow{w}\right) \\ \left(\overrightarrow{z} + \overrightarrow{w}\right) \\ \left(\overrightarrow{y} + \overrightarrow{w}\right) $	
PR1436G SEALANT (FOR "HG" CODE ONLY)	
HI-LOK™ HI-TIGUE™ PIN	HI-LOK™ HI-TIGUE™ PIN AND COLLAR AFTER ASSEMBLY
8 1 7	SEE COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH
FIRST PIN A A' B DDIA TO FIER TD F H K R Z CHAMFER THREAD W T Y	DOUBLE SHEAR TENSION POLINDS POUNDS
NO. DIA DIA MIN REF ORSOLD DESCUD DESCUD DIA DIA REF RAD MAX REF MODIFIED HEX DEPTH DIA	
5 13/64 NOTE: USE HLT335-6-() or HLT451-6-()	7.400 0.000
b         1/32         .3253         .299         .360         .2177         .2172         .1810         .005         .0449         .022         .020         .015         1/32 X 3/*         UNJF-3A         .0791         .080         .104           8         9/32         .4260         395         .435         .2807         .2440         006         .0610         027         .030         015         1/32 X 3/*         UNJF-3A         .0791         .080         .104	7,100 2,000
10 11/32 .5051 474 545 3432 .3432 .3060 007 .0679 032 .040 015 3/64 x 37° .3125-24 .1295 .130 .180	17.600 5.000
12 13/32 5916 560 590 4057 4057 3680 008 0780 036 040 015 3/64 x 37° 3750-24 1617 160 217	24,600 7,200
14         15/32         6992         651         .690         4682         4310         .009         .0969         .035         040         .022         3/64 x 37°         .1382         .140         .197           14         15/32         6992         .651         .690         .669         .4682         .4310         .009         .0969         .035         .022         3/64 x 37°         .1382         .140         .197           14         15/32         6992         .651         .690         .4682         .4310         .009         .0969         .035         .040         .022         3/64 x 37°         .1930         .1900         .1900         .253	32,700 10,000
16 17/32 7782 737 740 5302 5297 4980 .010 1043 .045 040 .022 3/64 x 37° 100-2242 .220 .289	42,000 13,500
18 19/32 8692 821 825 5922 5917 5500 .010 1131 .041 050 .022 1/16 x 37° .5625-18 .2555 .260 .326	52,400 17,000
20 21/32 <u>9562</u> <u>906</u> <u>890</u> <u>6552</u> <u>6552</u> <u>6552</u> <u>6180</u> <u>1263</u> <u>.010</u> <u>1263</u> <u>.040</u> <u>.022</u> <u>1/16 x 37°</u> <u>.6250-18</u> <u>.2555</u> <u>.260</u> <u>.326</u> <u>.326</u>	64,100 21,000
24         25/32         1.1282         1.080         1.115         .7802         .7802         .7430         .012         .1460         .045         .050         .022         1/16 x 37°         .7500-16         .3185         .330         .398           24         25/32         1.1162         1.080         1.115         .7797         .7792         .7370         .012         .1460         .045         .022         1/16 x 37°         .7500-16         .3185         .330         .398           .310         .310         .3792         .7370         .012         .1410         .045         .040         .022         1/16 x 37°         .7500-16         .3185         .330         .398	90,900 30,700
	"HI-LOK", "HI-TIGUE", AND "HI-KOTE".
	ARE TRADEMARKS OF HI-SHEAR CORPORATION
	DRAWN BY DATE TITLE VAN 1950.02.00 HI-LOK™ HI-TIGUE™ PIN
	APPROVED DATE 100° FLUSH SHEAR HEAD
	MILLER 1969-03-24 1/16 GRIP VARIATION, 1/32 OVERSIZE
	REVISION DATE DRAWING NUMBER (15) 2017-05-16 DRAWING NUMBER HLT635 1 OF 2

**HLT635** 

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GENERAL NOTES: 1 Head edge o	ut of roundness shall not exceed "F".	SPECIFICATION:	HI-LOK™ HI-TIGUE™ Product S
2. Concentricity 3. "H" is dimens (5) 4. Surface textu (5) 5. Dimensions a 6. Hole prepara [7] Curved or fac	: Conical surface of head to "D" diameter within .005 FIR. ioned from maximum "D" diameter. re per ASME B46.1. are in inches and to be met after finish. tion per NAS618.	CODE:	First dash number indicates nomi of the pin which HLT635 oversize Second dash number indicates n See Finish note for explanation o
8 Maximum "D' aluminum co	' diameter may be increased by .0002 to allow for ating application.	HOW TO ORDER 15 EXAMPLE:	Pin Part Number HLT635TB8-8
9. Oversize rep [10] After Februa Hi-Shear Spe aluminum pig European Un	acement pin for HL1451, HL1335 and HL1435. y, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per cc. 294 will be replaced by REACH compliant HI-KOTE™ 1 NC mented coating per Hi-Shear Spec. 294 on fasteners coated in ion.		8/16 or 1/2 Maxi 8/32 or 1/4 Nomina Finish Code Pin Basic Part Number
MATERIAL: 6AI-4V titanium a	Iloy per AMS4928 or AMS4967.		
HEAT TREAT: 95,000 psi shear	minimum.		
FINISH: HLT635-( )-( ) 10 HLT635AP( )-( )	= Cetyl alcohol lube per Hi-Shear Spec. 305. = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294 and		
10 HLT635AZ()-()	cetyl alconol lube per Hi-Snear Spec. 305. = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, color black		
HLT635BJ( )-( )	<ul> <li>and cetyl alcohol lube per Hi-Shear Spec. 305.</li> <li>I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.</li> </ul>		
HLT635FB( )-( ) HLT635FW( )-( )	<ul> <li>= Grit blast top of head and cetyl alcohol lube per Hi-Shear Spec. 305.</li> <li>= Grit blast top of head, HI-KOTE<sup>™</sup> 2 solid film lube on threads only per Hi-Spec. 292, with color black on thread end, and cetyl alcohol lube</li> </ul>		
HLT635HG( )-( )	<ul> <li>Per Fil-Snear Spec. 305.</li> <li>I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and apply precoat No. PR1436G sealant (.002005 thick), and cetyl alcohol lube per Hi-Shear Spec. 305</li> </ul>		
HLT635TA( )-( )	= 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		
HLT635TB( )-( )	= HI-KOTE ™ 2 solid film lube per Hi-Shear Spec.292, and cetyl		
HLT635YT( )-( )	= Grit blast top of head, color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.		

(15) HLT635HK()-() = HI-KOTE<sup>™</sup> 4 NC aluminum coating per Hi-Shear Spec. 397.

Product Specification 342.

ates nominal diameter in 1/32nds 5 oversize pin replaces.. ndicates maximum grip in 1/16ths. lanation of code letters.

<sup>-</sup> 1/2 Maximum Grip Length /4 Nominal Diameter Pin

**HLT635** 

DRAWING NUMBER **HLT635** 

2 OF 2