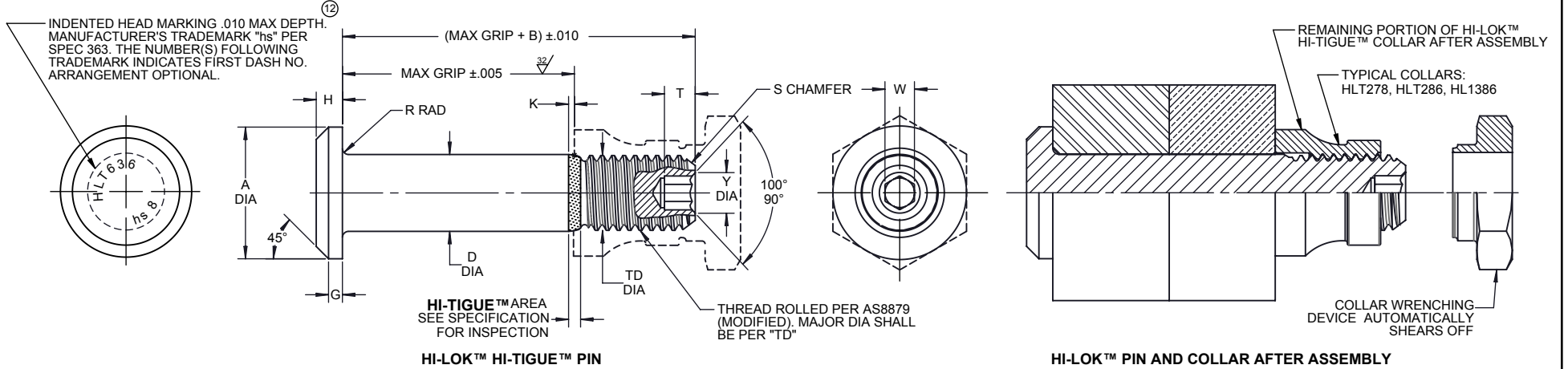


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FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	G REF	H	K REF	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS	TENSION POUNDS MINIMUM
				CETYL ALCOHOL	WITH COATING OR SOLID FILM								W HEX	T DEPTH	Y DIA		
5				NOTE: USE HLT336-6 OR HLT452-6													
6	7/32	.390 .370	.360	.2182 .2177	.2182 .2172	.1840 .1810	.035	.074 .064	.022	.025 .015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	7,100	2,750
8	9/32	.460 .435	.435	.2807 .2802	.2807 .2797	.2440 .2410	.045	.090 .080	.027	.025 .015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	11,800	5,820
10	11/32	.520 .490	.546	.3432 .3427	.3432 .3422	.3060 .3020	.055	.112 .102	.032	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	17,600	9,200
12	13/32	.620 .550	.590	.4057 .4052	.4057 .4047	.3680 .3640	.075	.140 .130	.036	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	24,600	14,000
14	15/32	.695 .615	.690	.4682 .4677	.4682 .4672	.4310 .4260	.095	.160 .150	.035	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	32,700	18,900
16	17/32	.790 .740	.740	.5307 .5302	.5307 .5297	.4930 .4880	.095	.188 .178	.045	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	42,000	25,500
18	19/32	.900 .865	.825	.5927 .5922	.5927 .5917	.5550 .5500	.125	.210 .200	.041	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	52,400	32,400

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 1969-03-21	TITLE HI-LOK™ HI-TIGUE™ PIN PROTRUDING TENSION HEAD TITANIUM 1/16 GRIP VARIATION, 1/32 OVERSIZE
APPROVED VON MILLER	DATE 1969-03-24	
REVISION 12	DATE M.BEARD 2017-10-24	DRAWING NUMBER HLT636

1 OF 2

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 - ⑫ 2. Surface texture per ASME B46.1.
 3. Hole preparation per NAS618.
 4. Oversize replacement for HLT436 and HLT336.
 - 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.
 - ⑫ 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:**
- HLT636-()-() = Cetyl alcohol lube per Hi-Shear Spec. 305.
 - ⑥ HLT636AP()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT636BJ()-() = I.V.D. aluminum coating per MIL-DLT-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT636TA()-() = 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.
 - HLT636TB()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ⑫ HLT636HK()-() = 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 HLT636 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

HOW TO ORDER

⑫ **EXAMPLE:** Pin Part Number
 HLT636TB8-8

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

HLT636

DRAWING NUMBER

HLT636

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