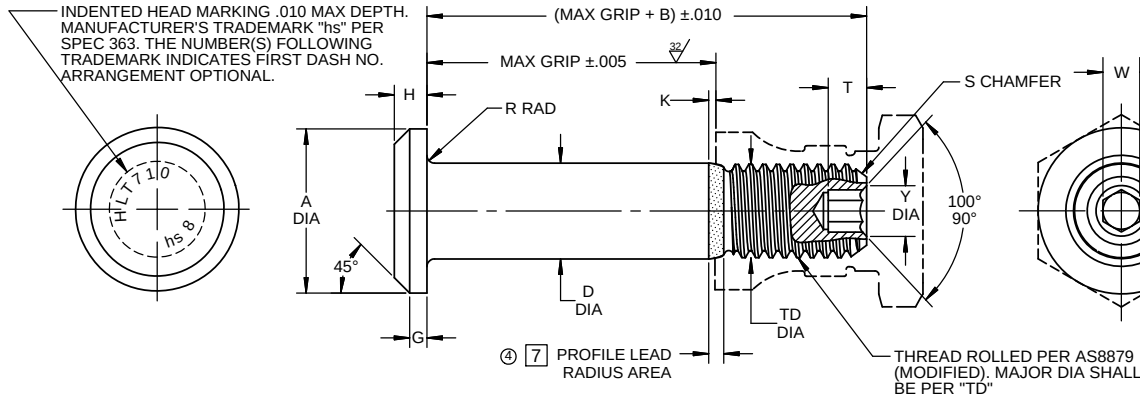
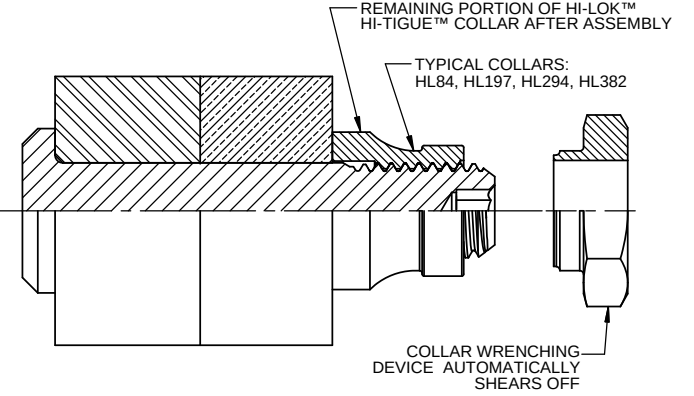


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For the current list of licensed manufacturers, please visit the
LISI AEROSPACE website at:
[HTTP://WWW.LISI-AEROSPACE.COM/LICENSES](http://www.lisi-aerospace.com/licenses)



HI-LOK™ HI-TIGUE™ PIN



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

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

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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 MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT HI-KOTE 1	WITH HI-KOTE 1								W HEX	T DEPTH	Y DIA		
5				NOTE: USE HLT310()6-(), 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 37°	.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 .3610	.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	.115 .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	.043	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	52,400	19,000
20	21/32	.953 .918	.890	.6552 .6547	.6552 .6542	.6180 .6120	.060	.137 .122	.045	.040 .025	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	64,100	23,000
24	25/32	1.108 1.066	1.115	.7802 .7797	.7802 .7792	.7430 .7370	.070	.151 .136	.045	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	90,900	30,700

HLT710

"HI-LOK", "HI-TIGUE", AND "HI-KOTE",
ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY D.P.S.	DATE 1977-05-11	TITLE HI-LOK™ HI-TIGUE™ PIN PROTRUDING SHEAR HEAD TITANIUM 1/16 GRIP VARIATION, 1/32 OVERSIZE
APPROVED R.TING	DATE 1977-05-12	
REVISION ④	DATE M.BEARD 2017-10-19	DRAWING NUMBER HLT710

1 OF 2

- GENERAL NOTES:**
- 1. Concentricity: "A" to "D" diameter within .010 FIR.
 - ④ 2. Dimensions are in inches and to be met after finish.
 - ④ 3. Surface texture per ASME B46.1.
 - 4. Hole preparation per NAS618.
 - 5. Oversize pin for HLT450 and HLT610.
 - ④ 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.
 - ④ ⑦ This area has a special profile lead radius instead of the HI-TIGUE™ feature.

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

HEAT TREAT: 95,000 psi shear minimum.

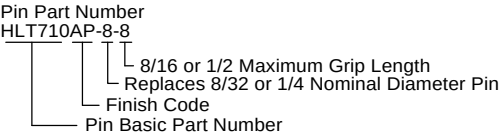
- FINISH:**
- HLT710-()-() = Cetyl alcohol lube per Hi-Shear Spec. 305.
 - ④ ⑥ HLT710AP()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ④ ⑥ HLT710AZ()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ④ ⑥ HLT710FD()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, red identification on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT710FE()-() = Grit blast top of head, red identification on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT710FH()-() = Cetyl alcohol lube per Hi-Shear Spec. 305, and red identification on thread end.
 - HLT710YT()-() = Grit blast top of head, color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LOK™ HI-TIGUE™ Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HLT710 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER

④ **EXAMPLE:**



HLT710

DRAWING NUMBER

HLT710

2 OF 2