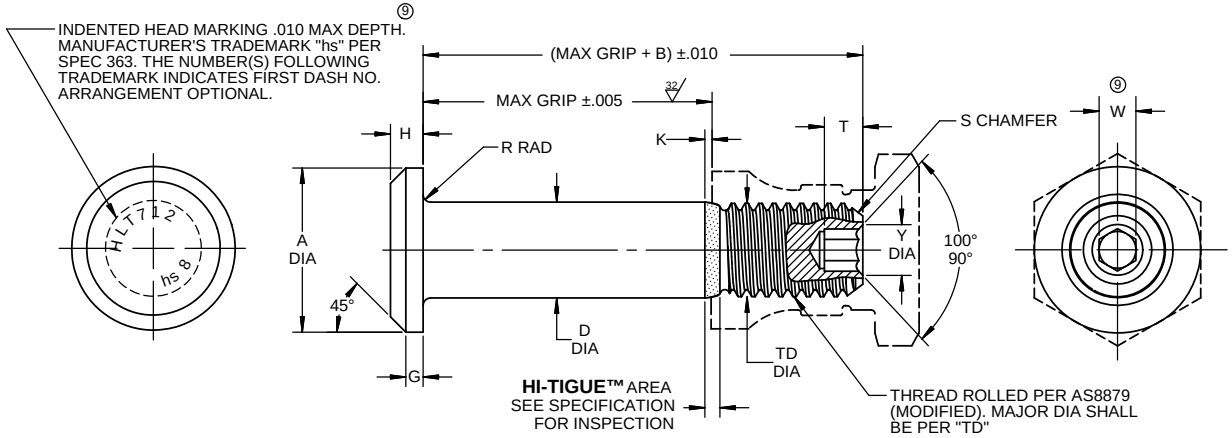
lisi AEROSPACE
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR Corporation, USA
a LISI AEROSPACE Company

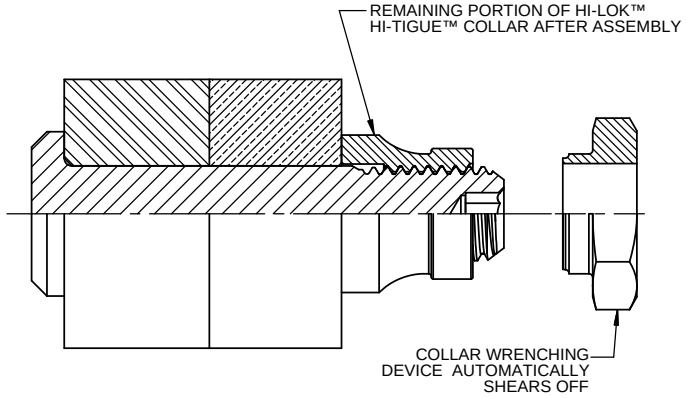
Design Holder

CAGE No. 73197

⑨ For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at:
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

FIRST DASH NO.	PIN NOM DIA	**A** DIA	**B** REF	**D** DIA WITHOUT COATING	**D** DIA WITH COATING	**TD** DIA	**G** REF	**H**	**K** REF	**R** RAD	**S** CHAMFER REF	**THREAD** MODIFIED	SOCKET **W** HEX	SOCKET **T** DEPTH	SOCKET **Y** DIA	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
5				NOTE: USE HLT612( )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	.545	.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 .585	.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 .690	.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 .755	.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	26,500
18	19/32	.900 .865	.825	.5927 .5922	.5927 .5917	.5550 .5500	.125	.210 .200	.043	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	52,400	32,400
20	21/32	.970 .935	.890	.6552 .6547	.6552 .6542	.6180 .6120	.140	.238 .228	.045	.040 .025	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	64,100	41,000
24	25/32	1.185 1.745	1.115	.7802 .7797	.7802 .7792	.7430 .7370	.200	.335 .320	.045	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	90,900	59,500

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

DRAWN BY	DATE	TITLE
D.P.S.	1977-05-11	HI-LOK™ HI-TIGUE™ PIN PROTRUDING TENSION HEAD TITANIUM 1/16 GRIP VARIATION, 1/32 OVERSIZE
APPROVED	DATE	
R.TING	1977-05-12	
REVISION	DATE	DRAWING NUMBER
⑨	M.BEARD 2017-07-24	**HLT712** 1 OF 2

HLT712

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GENERAL NOTES: 1. Concentricity: "A" to "D" diameter within .010 FIM.
ⓖ 2. Dimensions are in inches and to be met after finish.
ⓖ 3. Surface texture per ASME B46.1.
4. Hole preparation per NAS618.
5. Oversize pin for HLT452 and HLT612.
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.

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

HEAT TREAT: 160,000 psi tensile minimum (95,000 psi shear minimum).

FINISH:
HLT712-( )-( ) = Cetyl alcohol lube per Hi-Shear Spec. 305.
6 HLT712AP( )-( ) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
6 HLT712FD( )-( ) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, red identification thread end, and cetyl alcohol lube per Hi-Shear Spec. 305
HLT712FE( )-( ) = Grit blast top of head, with color red on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT712FH( )-( ) = Red identification on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT712FU( )-( ) = Grit blast top of head, HI-KOTE™ 2 solid film lube on threads only per Hi-Shear Spec. 292, with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
6 HLT712KM( )-( ) = 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.
HLT712MA( )-( ) = Solid film lube per Kat-Gard RA.
HLT712ST( )-( ) = Grit blast top of head, with color white on thread end, 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 HLT712 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER
ⓖ **EXAMPLE:** Pin Part Number
HLT712AP8-8
- 8/16 or 1/2 Maximum Grip Length
- Replaces 8/32 or 1/4 Nominal Diameter Pin
- Finish Code
- Pin Basic Part Number

HLT712

DRAWING NUMBER
HLT712