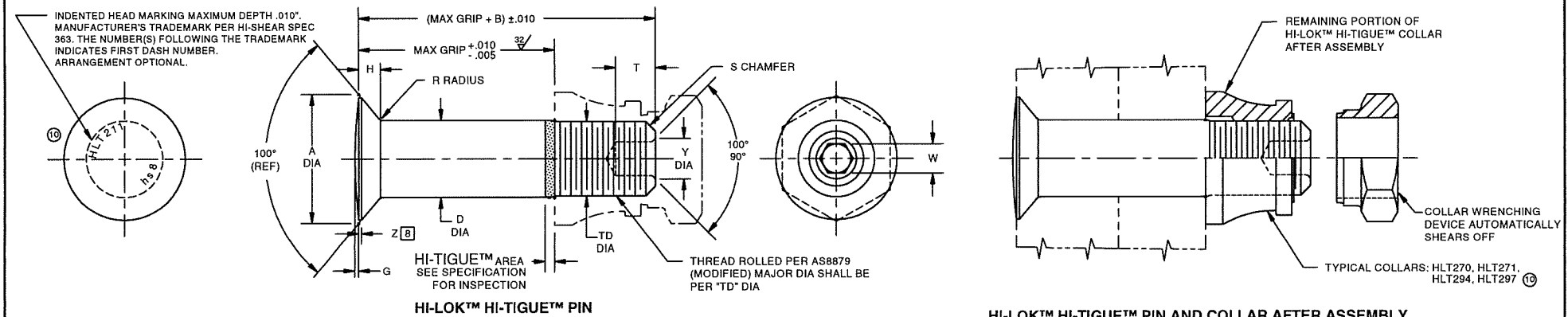


Hi-Shear Corporation, U.S.A. a LISI AEROSPACE Company	Design Holder	CAGE No. 73197	SPS TECHNOLOGIES, UK SPS TECHNOLOGIES, USA MINEBEA, Japan	Licensee	CAGE No. K5673 CAGE No. 56878 CAGE No. 5B962
BLANC AERO INDUSTRIES UK Ltd a LISI AEROSPACE Company	Licensee	CAGE No. U6300		Licensee (Japan)	
BLANC AERO INDUSTRIES SA, France a LISI AEROSPACE Company	Licensee	CAGE No. F0188-C	WEST COAST AEROSPACE, USA	Licensee (WW except Japan for oversize, USA & Canada for nominal)	CAGE No. 60516
LI SI AEROSPACE CANADA, Canada a LISI AEROSPACE Company	Licensee	CAGE No. L4528	AFS Hildesheim, Germany	Licensee	CAGE No. C4293 CAGE No. 1RC86 CAGE No. 06950
ANKIT FASTENERS Ltd, India Air Industries CO., USA	Licensee (Steel WW, Titanium India) Licensee (USA, Carson)	CAGE No. SEM10 CAGE No. 06725	AFS City of Industry, USA AFS Carson, USA	Licensee	CAGE No. 17446



1																	8																
FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	F	G	H	R RAD	Z MAX	S CHAMFER REF	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM															
				WITHOUT COATING PLATING OR S.F.L.	AFTER COATING PLATING OR S.F.L.									W HEX	T DEPTH	Y DIA																	
5						NOTE: Use HLT111()6-()																											
6	7/32	.3303 .3253	.360	.2182 .2177	.2182 .2172	.1840 .1810	.005	.0080 .0050	.0470 .0449	.030 .020	.015	1/32 x 37°	.1900-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	7,100	2,000															
8	9/32	.4260 .4210	.435	.2807 .2802	.2807 .2797	.2440 .2410	.006	.0100 .0070	.0610 .0589	.030 .020	.015	1/32 x 37°	.2500-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	11,800	3,700															
10	11/32	.5051 .5001	.545	.3432 .3427	.3432 .3422	.3060 .3020	.007	.0110 .0080	.0679 .0658	.040 .030	.015	3/64 x 37°	.3125-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	17,600	5,000															
12	13/32	.5916 .5866	.590	.4057 .4052	.4057 .4047	.3680 .3640	.008	.0125 .0095	.0780 .0759	.040 .030	.015	3/64 x 37°	.3750-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	24,600	7,200															
14	15/32	.6992 .6932	.690	.4682 .4677	.4682 .4672	.4310 .4260	.009	.0150 .0120	.0969 .0944	.050 .040	.022	3/64 x 37°	.4375-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	32,700	10,000															
16	17/32	.7852 .7792	.740	.5307 .5302	.5307 .5297	.4930 .4880	.010	.0165 .0135	.1068 .1043	.050 .040	.022	3/64 x 37°	.5000-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	42,000	13,500															
18	19/32	.8692 .8622	.825	.5927 .5922	.5927 .5917	.5550 .5500	.010	.0200 .0150	.1160 .1131	.050 .040	.022	1/16 x 37°	.5625-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	52,400	17,000															
20	21/32	.9562 .9492	.890	.6552 .6547	.6552 .6542	.6180 .6120	.010	.0250 .0200	.1263 .1233	.050 .040	.022	1/16 x 37°	.6250-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	64,100	21,000															
24	25/32	1.1282 1.1162	1.115	.7802 .7797	.7802 .7792	.7430 .7370	.012	.0310 .0260	.1460 .1410	.050 .040	.022	1/16 x 37°	.7500-16UNJF-3A Modified	.3185 .3150	.330 .300	.398 .378	90,900	30,700															
28	29/32	1.3509 1.3342	1.285	.9052 .9047	.9052 .9042	.8680 .8610	.014	.0400 .0350	.1870 .1800	.050 .040	.022	5/64 x 37°	.8750-14UNJF-3A Modified	.3820 .3780	.400 .370	.471 .451	122,000	42,000															
32	1-1/32	1.5498 1.5307	1.480	1.0302 1.0297	1.0302 1.0292	.9930 .9860	.014	.0500 .0450	.2180 .2100	.050 .040	.022	5/64 x 37°	1.0000-12UNJF-3A Modified	.5100 .5040	.520 .490	.618 .598	158,000	55,000															

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 7-23-69	TITLE HI-LOK™/ HI-TIGUE™ PIN 100° FLUSH CROWN SHEAR HEAD TITANIUM 1/16 GRIP VARIATION, 1/32 OVERSIZE
APPROVED R. Ting	DATE 7-25-69	
REVISION ⑩	DATE FC 7-22-15	
DRAWING NUMBER HLT211		1 OF 2

- GENERAL NOTES:**
- 1 Head edge out of roundness shall not exceed "F".
 - 2 Concentricity: Conical surface of head to "D" diameter within .005 FIM.
 - 3 "H" is dimensioned from maximum "D" diameter.
 - 4 Surface texture per ANSI B46.1.
 - 5 Dimensions to be met after finish. Ⓢ
 - 6 Hole preparation per NAS618 for interference application.
 - 7 Oversize replacement pin for HLT111 and HLT11.
 - 8 Curved or flat edge manufacturer's option.
 - 9 After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating 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:**
- | | |
|-------------------|--|
| HLT211-()-() | = Cetyl alcohol lube per Hi-Shear Spec. 305. |
| 9 HLT211AP()-() | = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305. |
| HLT211LJ()-() | = Surface coating per Hi-Shear Spec. 306, Type II, and solid film lube per AS5272, Type II. |
| HLT211TB()-() | = HI-KOTE™ 2 solid film lube per Hi-Shear Spec.292, and cetyl alcohol lube per Hi-Shear Spec. 305. |
| HLT211V()-() | = Solid film lube per Lubeco #2123 plus cetyl alcohol lube per Hi-Shear Spec. 305. |
| HLT211VR()-() | = Surface coating per Hi-Shear Spec. 306, Type II, and solid film lube per Electrofilm #4396 plus cetyl alcohol lube per Hi-Shear Spec. 305. |

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

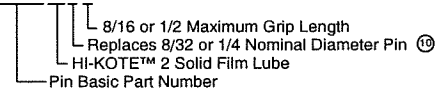
CODE: First dash number indicates nominal diameter in 1/32nds, which HL211 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER

EXAMPLE:

Pin Part Number Only

HLT211TB8-8



HLT211