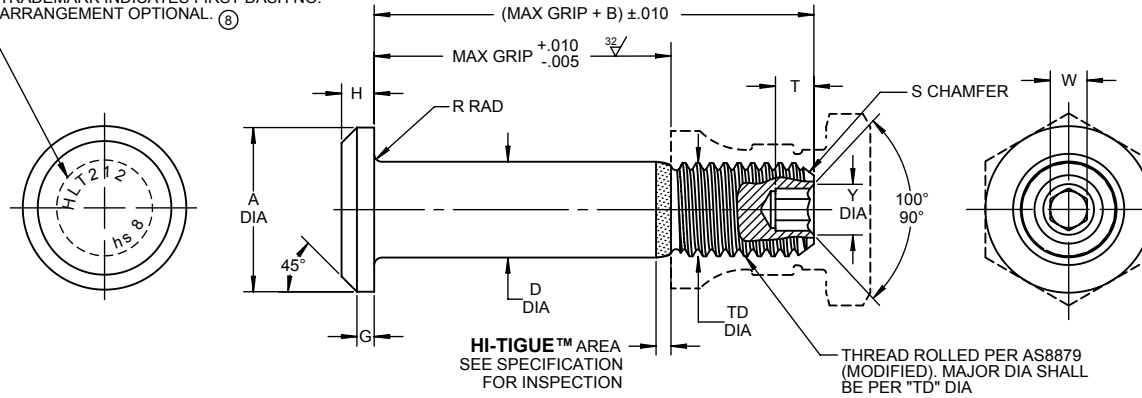
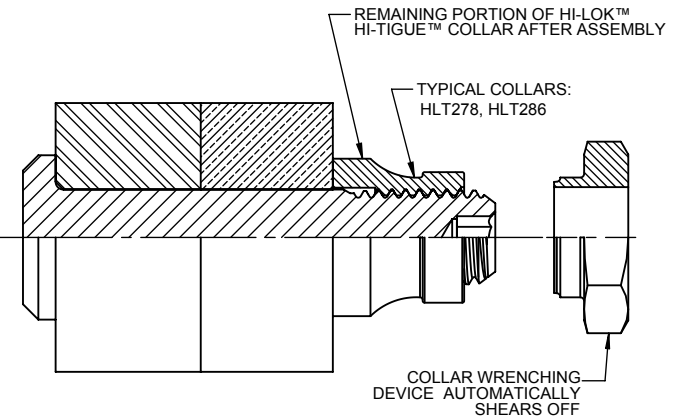


⑧

INDENTED HEAD MARKING .010 MAX DEPTH.
MANUFACTURER'S TRADEMARK "hs" PER
SPEC 363. THE NUMBER(S) FOLLOWING
TRADEMARK INDICATES FIRST DASH NO.
ARRANGEMENT OPTIONAL. ⑧



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	DDIA		TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT SOLID FILM OR COATING	AFTER SOLID FILM OR COATING							W HEX	T DEPTH	Y DIA		
5				NOTE: USE HLT12()6-() or HLT412()6-()												
6	7/32	.390 .370	.360	.2182 .2177	.2182 .2172	.1840 .1810	.035	.074 .064	.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	.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	.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	.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	.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	.100	.188 .178	.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	.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	.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 1.145	1.115	.7802 .7797	.7802 .7792	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	90,900	59,500
28	29/32	1.375 1.335	1.285	.9052 .9047	.9052 .9042	.8680 .8610	.250	.385 .370	.050 .035	5/64 x 37°	.8750-14 UNJF-3A	.3820 .3780	.400 .370	.471 .451	122,000	81,500
32	1-1/32	1.550 1.510	1.480	1.0302 1.0297	1.0302 1.0292	.9930 .9860	.300	.435 .420	.060 .045	5/64 x 37°	1.000-12 UNJF-3A	.5100 .5040	.520 .490	.618 .598	158,000	106,000

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

DRAWN BY VAN	DATE 1969-07-28	TITLE HI-LOK™ HI-TIGUE™ PIN PROTRUDING TENSION HEAD TITANIUM 1/16 GRIP VARIATION, 1/32 OVERSIZE
APPROVED R. TING	DATE 1969-07-30	
REVISION ⑧	DATE K. TRAN 2017-10-23	DRAWING NUMBER HLT212

GENERAL NOTES:

1. Concentricity: "A" to "D" diameter within .010 FIM.

2. Dimensions are in inches and to be met after finish.

③ 3. Surface texture per ASME B46.1.

4. Oversize pin for HLT12 and HLT112.

5

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:

160,000 psi tensile minimum (95,000 psi shear minimum).

FINISH:

HLT212-()-() = Cetyl alcohol lube per Hi-Shear Spec. 305.

5

HLT212AP()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

HLT212LJ()-() = Surface coating per Hi-Shear Spec. 306, Type II, and solid film lube per Spec. AS5272, Type II.

HLT212LP()-() = Surface coating per Hi-Shear Spec. 306, Type II, solid film lube per Spec. AS5272, Type II and cetyl alcohol per Hi-Shear Spec. 305.

HLT212TB()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.

⑧ HLT212HK()-() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

HLT212V()-() = Solid film lube per LUBECO #2123 plus cetyl alcohol lube per Hi-Shear Spec. 305.

HLT212VR()-() = 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 of the pin which HLT212 oversize pin replaces.

Second dash number indicates maximum grip in 1/16ths.

See Finish note for explanation of code letters.

HOW TO ORDER

③EXAMPLE:

Pin Part Number

HLT212AP-8-8

8

8

8/16 or 1/2 Maximum Grip Length

Replaces 8/32 or 1/4 Nominal Diameter Pin

Finish Code

Pin Basic Part Number

HLT212