



1 HI-LOK™ HI-TIGUE™ PIN

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

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	F	G	H	K REF	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
														W HEX	T DEPTH	Y DIA		
5	5/32	.2612 .2564	.312	.1635 .1630	.1595 .1570	.004	.015 .010	.0408 .0388	.013	.025 .015	.010	1/32 x 37°	.1640-32 UNJC-3A	.0801 .0791	.135 .115	8	4,010	1,750
6	3/16	.3016 .2966	.325	.1895 .1890	.1840 .1810	.005	.015 .010	.0470 .0449	.016	.030 .020	.015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	5,380	2,000
8	1/4	.3948 .3898	.395	.2495 .2490	.2440 .2410	.006	.015 .010	.0610 .0589	.021	.030 .020	.015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	9,300	3,700
10	5/16	.4739 .4689	.500	.3120 .3115	.3060 .3020	.007	.015 .010	.0679 .0658	.026	.040 .030	.015	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	14,600	5,500
12	3/8	.5604 .5554	.545	.3745 .3740	.3680 .3640	.008	.015 .010	.0780 .0759	.030	.040 .030	.015	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	21,000	7,200
14	7/16	.6680 .6620	.635	.4370 .4365	.4310 .4260	.009	.015 .010	.0969 .0944	.035	.050 .040	.022	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	28,600	10,000
16	1/2	.7540 .7480	.685	.4995 .4990	.4930 .4880	.010	.015 .010	.1068 .1043	.039	.050 .040	.022	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	37,300	13,500

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

- 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 Dimensions are in inches and to be met before finish.
 - 4 Surface texture per ASME B46.1.
 - 5 Hole preparation per NAS618.
 - 6 "H" is dimensioned from maximum "D" diameter.
 - 7 Curved or flat edge manufacturer's option.
 - 8 Evidence of broken edge across points.
 - 9 Use HLT435 for oversize replacement.

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

HEAT TREAT: 95,000 psi shear minimum.

FINISH: ⑫ HLT311(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT311DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT311TA(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT311TB(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT311HK(-)(-) = 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.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

**HOW TO ORDER
 EXAMPLE:**

Pin Part Number
 HLT311TB8-8
 8/16 or 1/2 Maximum Grip Length
 8/32 or 1/4 Nominal Diameter Pin
 Finish Code
 Pin Basic Part Number

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

DRAWN BY D.P.S.	DATE 1976-11-11	TITLE HI-LOK™ HI-TIGUE™ PIN 100° FLUSH CROWN SHEAR HEAD TITANIUM 1/16 GRIP VARIATION
APPROVED JGWILCOX	DATE 1976-11-15	
REVISION ⑫	DATE S. WILEY 2018-09-11	DRAWING NUMBER HLT311