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

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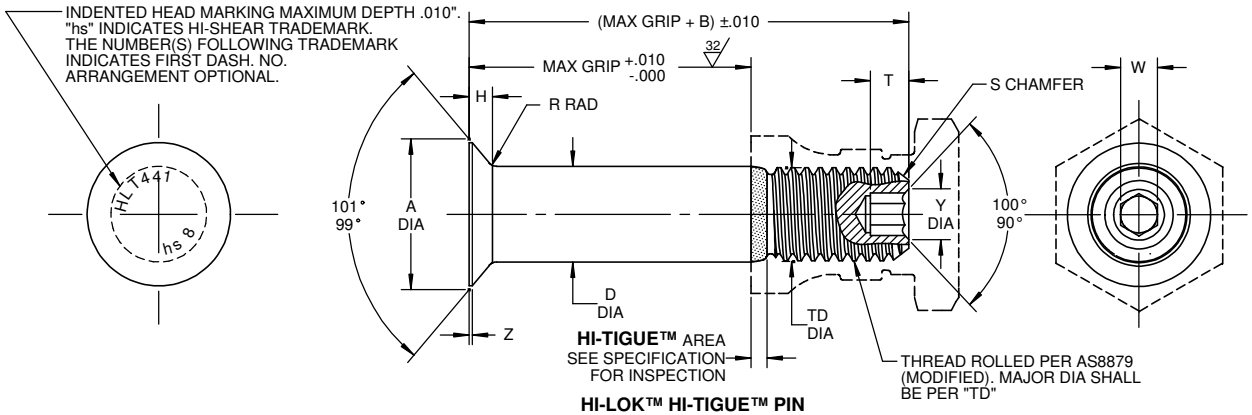
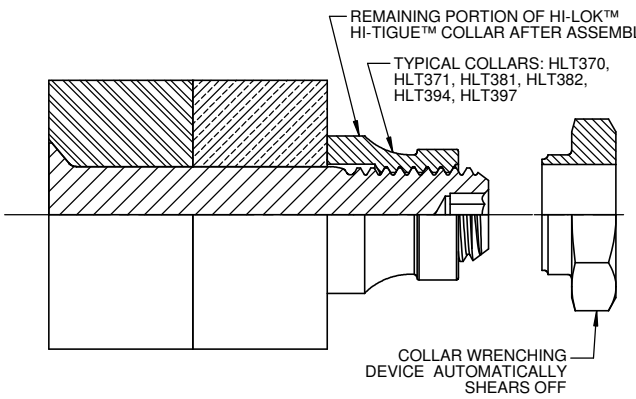


HI-LOK™ HI-TIGUE™ PIN



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 BEFORE SOLID FILM	TD DIA	F [1]	H	R RAD	Z	S CHAMFER REF	THREAD MODIFIED ⑥	SOCKET W HEX	SOCKET T DEPTH	SOCKET Y DIA	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
5	11/64	.3016 .2966	.415	.1845 .1840	.1595 .1570	.004	.0491 .0470	.025 .015	.015 .005	1/32 x 37°	.1640-32 UNJC-3A	.0645 .0635	.135 .115	.090 .075	5,000	1,290
6	13/64	.3016 .2966	.445	.2100 .2095	.1840 .1810	.005	.0384 .0363	.030 .020	.015 .005	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	6,500	2,000
8	17/64	.3948 .3898	.525	.2701 .2696	.2440 .2410	.006	.0523 .0502	.030 .020	.015 .005	1/32 x 37°	2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	10,800	3,700
10	21/64	.4739 .4689	.645	..3331 .3326	.3060 .3020	.007	.0591 .0570	.040 .030	.015 .005	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	16,400	5,000
12	25/64	.5604 .5554	.690	.3961 .3956	.3680 .3640	.008	.0689 .0668	.040 .030	.015 .005	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	23,300	7,200
14	29/64	.6680 .6620	.800	.4591 .4586	.4310 .4260	.009	.0876 .0851	.050 .040	.022 .005	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	31,300	10,000
16	33/64	.7540 .7480	.855	.5221 .5216	.4930 .4880	.010	.0973 .0948	.050 .040	.022 .005	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	40,500	13,500
20	41/64	.9250 .9180	1.010	.6481 .6476	.6180 .6120	.010	.1162 .1132	.050 .040	.022 .005	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	62,500	21,000
24	49/64	1.0970 1.0850	1.240	.7741 .7736	.7430 .7370	.012	.1355 .1305	.050 .040	.022 .005	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	89,200	30,700

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. Dimensions to be met after finish and before solid film lubricant, where applicable.
5. Surface texture per ASME B46.1.
6. Hole preparation per NAS618.
7. Use HLT641 for oversize replacement.

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

HEAT TREAT: 95,000 psi shear minimum.

FINISH: HLT441TL( )-( ) = Anodize per Hi-Shear Ti-Shield III, solid film lube per DAG-258, and cetyl alcohol lube per Hi-Shear Spec. 305; or anodize per Tiodize Type II, solid film lube per TI-O-LUBE TAL-58, 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 HLT441 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
HLT441TL8-8
- 8/16 or 1/2 Maximum Grip Length
- 8/32 or 1/4 Nominal Diameter Pin
- Finish Code
- Pin Basic Part Number

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DRAWN BY	DATE
VAN	1969-11-7

TITLE
HI-LOK™ HI-TIGUE™ PIN
100° FLUSH SHEAR HEAD
TITANIUM
1/16 GRIP VARIATION, 1/64 OVERSIZE

APPROVED	DATE
J.G.Wilcox	1969-11-11
R.Ting	1969-11-11

REVISION	DATE
⑥	J.Obispo 2017-07-18

DRAWING NUMBER
HLT441
1 of 1

HLT441