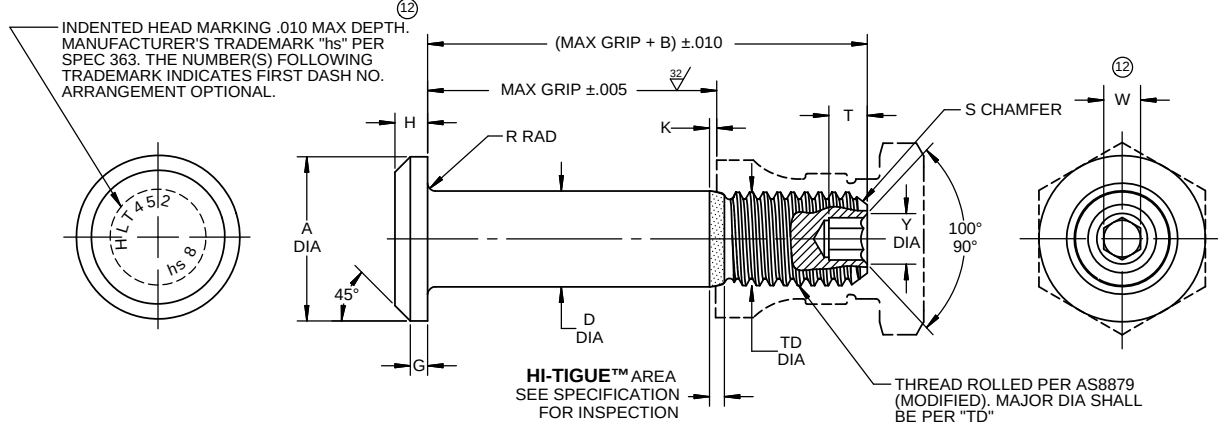
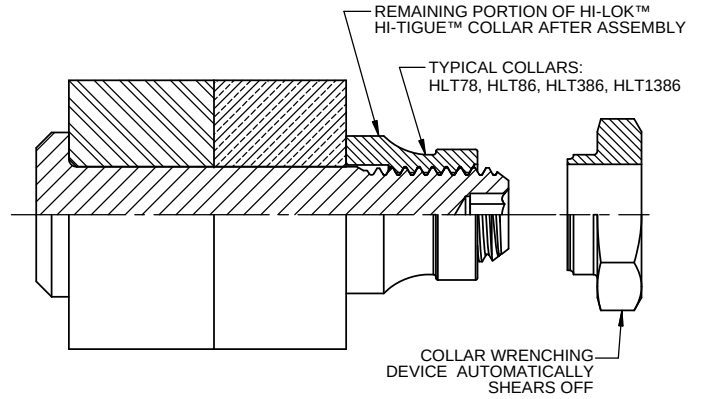


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HI-LOK™ HI-TIGUE™ PIN



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		TD DIA	G REF	H	K REF	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS	TENSION POUNDS MINIMUM
				WITHOUT COATING OR SOLID FILM	WITH COATING OR SOLID FILM								W HEX	T DEPTH	Y DIA		
5	5/32	.322 .306	.312	.1635 .1630	.1635 .1625	.1595 .1570	.030	.060 .055	.013	.025 .015	1/32 x 37°	.1640-32 UNJC-3A	.0801 .0791	.100 .080	[5]	4,010	2,180
6	3/16	.377 .357	.325	.1895 .1890	.1895 .1885	.1840 .1810	.035	.074 .064	.016	.025 .015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	5,380	2,750
8	1/4	.440 .415	.395	.2495 .2490	.2495 .2485	.2440 .2410	.045	.090 .080	.021	.025 .015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	9,300	5,820
10	5/16	.505 .475	.500	.3120 .3115	.3120 .3110	.3060 .3020	.055	.112 .102	.026	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	14,600	9,200
12	3/8	.600 .565	.545	.3745 .3740	.3745 .3735	.3680 .3640	.075	.140 .130	.030	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	21,000	14,000
14	7/16	.676 .641	.635	.4370 .4365	.4370 .4360	.4310 .4260	.095	.160 .150	.035	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	28,600	18,900
16	1/2	.770 .735	.685	.4995 .4990	.4995 .4985	.4930 .4880	.095	.188 .178	.039	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	37,300	25,500
18	9/16	.877 .842	.770	.5615 .5610	.5615 .5605	.5550 .5500	.125	.210 .200	.039	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	47,200	32,400
20	5/8	.959 .918	.825	.6240 .6235	.6240 .6230	.6180 .6120	.140	.238 .228	.044	.040 .025	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	58,300	41,000
24	3/4	1.150 1.110	1.050	.7490 .7485	.7490 .7480	.7430 .7370	.200	.335 .320	.044	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	83,900	59,500

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

DRAWN BY D.P.S.	DATE 1983-04-05	TITLE HI-LOK™ HI-TIGUE™ PIN PROTRUDING TENSION HEAD TITANIUM 1/16 GRIP VARIATION
APPROVED R.TING	DATE 1983-04-06	
REVISION [12]	DATE M.BEARD 2017-12-20	DRAWING NUMBER HLT452

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 - ⑫ 2. Surface texture per ASME B46.1.
 3. Hole preparation per NAS618.
 - ④ 4. Maximum "D" diameter may be increased by .0002 to allow for solid film lube application.
 - ⑤ 5. Evidence of broken edge across points.
 6. Use HLT436 or HLT612 for oversize replacement.
 - ⑦ 7. 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.
 - ⑫ 8. Dimensions are in inches.

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

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

- FINISH:**
- HLT452-()-() = Cetyl alcohol lube per Hi-Shear Spec. 305.
- ⑦ HLT452AP()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT452FB()-() = Grit blast top of head, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT452FS()-() = Grit blast top of head, HI-KOTE™ 2 solid film lube on threads only per Hi-Shear Spec. 292, with color light blue on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT452MA()-() = Solid film lube per KALGARD RA.
- HLT452SS()-() = Grit blast top of head, with color light blue on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- ⑦ HLT452SU()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec.294, with color light blue on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT452TB()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT452TF()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
- ⑫ HLT452HK()-() = 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
 ⑫ **EXAMPLE:**

Pin Part Number
 HLT452TF8-8

└─ 8/16 or 1/2 Threaded Stud Grip
 └─ 8/32 or 1/4 Nominal Diameter Pin
 └─ Finish Code
 └─ Pin Basic Part Number