



FIRST DASH NO.	PIN NOM DIA	A DIA	B MIN	C DIA MIN	D DIA		TD DIA	G DIA	H	K	R RAD	V	X	Z	S CHAMFER REF	THREAD MODIFIED	SOCKET				DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
					WITHOUT COATING	WITH COATING											W HEX	T DEPTH MAX	T1 DEPTH MIN	Y DIA		
6	3/16	.376 .367	.410	.359	.1895 .1890	.1895 .1885	.1840 .1810	.200 .180	.125 .110	.088 .073	.020 .010	.010	.0045	.0040	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.140	.080	.119 .104	5,380	3,620
8	1/4	.439 .430	.482	.422	.2495 .2490	.2495 .2485	.2440 .2410	.260 .240	.140 .125	.098 .083	.020 .010	.010	.0045	.0030	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.160	.090	.142 .122	9,300	6,470
10	5/16	.502 .492	.552	.484	.3120 .3115	.3120 .3110	.3060 .3020	.320 .300	.171 .156	.119 .104	.020 .010	.012	.0045	.0030	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.200	.110	.180 .160	14,600	10,200

- GENERAL NOTES:**
1. Dimensioning and tolerance per ANSI Y14.5M-1982.
  2. Dimensions are in inches and to be met after finish.
  3. Surface texture per ASME B46.1.
  4. Hole preparation per NAS618.
  5. Bearing surface to be perpendicular to shank diameter within .003 FIM.
  6. Washer face "C" diameter not to exceed actual width across flats.
  7. Shank straightness to be within "Z" FIM per inch of length.
  8. Runout of "D" diameter to thread pitch diameter shall be within "X" FIM.
  9. "W" hex to be true position with thread pitch diameter within "V" FIM.
  10. Grip length of bolt to be measured from underside of head to end of full cylindrical portion of shank.
  11. 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:** 11 HL1320AD( ) = HI-KOTE™ 1 aluminum coating on threads only per Hi-Shear Spec. 294 and cety alcohol lube per Hi-Shear Spec. 305.  
11 HL1320AP( ) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, and cety alcohol lube per Hi-Shear Spec. 305.

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

**CODE:** First dash number indicates nominal diameter in 1/32nds  
Second dash number indicates maximum grip in 1/16ths.  
Third dash number indicates thread length in 1/16ths.  
See Finish note for explanation of code letters.

**HOW TO ORDER**  
EXAMPLE:

Pin Part Number  
HL1320AD8-8-8  
L-8/16 or 1/2 Thread Length  
8/16 or 1/2 Maximum Grip Length  
8/32 or 1/4 Nominal Diameter Pin  
Finish Code  
Pin Basic Part Number

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

DRAWN BY J.F. OBISPO	DATE 2005-03-31	TITLE HI-LOK™ PIN HEX TENSION HEAD TITANIUM 1/16 GRIP VARIATION	
APPROVED E.E. Beeles	DATE 2005-03-31	DRAWING NUMBER HL1320	
REVISION 4	DATE KEVIN TRAN 2017-07-31	1 OF 1	