



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	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING OR SOLID FILM LUBE	WITH COATING OR SOLID FILM LUBE									W HEX	T DEPTH	Y DIA		
5	5/32	.2612 .2564	.312	.1695 .1690	.1695 .1685	.1595 .1570	.004	.0070 .0040	.0385 .0365	.025 .015	.010	1/32 x 37°	.1640-32 UNJC-3A	.0645 .0635	.100 .080	.090 .075	4,210	1,290
6	3/16	.3016 .2966	.325	.1955 .1950	.1955 .1945	.1840 .1810	.005	.0080 .0050	.0445 .0424	.030 .020	.015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	5,550	2,000
8	1/4	.3948 .3898	.395	.2555 .2550	.2555 .2545	.2440 .2410	.006	.0100 .0070	.0584 .0563	.030 .020	.015	3/64 x 37°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	9,620	3,700
10	5/16	.4739 .4689	.500	.3180 .3175	.3180 .3170	.3060 .3020	.007	.0110 .0080	.0654 .0633	.040 .030	.015	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	14,890	5,000
12	3/8	.5604 .5554	.545	.3805 .3800	.3805 .3795	.3680 .3640	.008	.0125 .0095	.0755 .0734	.040 .030	.015	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	21,430	7,200
14	7/16	.6680 .6620	.635	.4430 .4425	.4430 .4420	.4310 .4260	.009	.0150 .0120	.0944 .0919	.050 .040	.022	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	29,000	10,000
16	1/2	.7540 .7480	.685	.5055 .5050	.5055 .5045	.4930 .4880	.010	.0165 .0135	.1042 .1017	.050 .040	.022	1/16 x 37°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	37,900	13,500

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

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
  - Concentricity: Conical surface of head to "D" diameter within .005 FIM.
  - "H" is dimensioned from maximum "D" diameter.
  - Surface texture per ASME B46.1.
  - Dimensions are in inches and to be met after finish.
  - Hole preparation per NAS618 (Column "B") for interference application.
  - Use HLT111 for oversize replacement.
  - Curved or flat edge manufacturer's option.
  - 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:** 95,000 psi shear minimum.

**FINISH:** HLT11-( )-( ) = Cetyl alcohol lube per Hi-Shear Spec. 305.  
 [9] HLT11AP( )-( ) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305  
 HLT11TB( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec.292, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HLT11HK( )-( ) = 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  
 HLT11TB8-8  
 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 VAN	DATE 1968-06-28	TITLE HI-LOK™ HI-TIGUE™ PIN 100° FLUSH CROWN SHEAR HEAD TITANIUM 1/16 GRIP VARIATION
APPROVED R. TING	DATE 1968-07-25	
REVISION 13	DATE F. CARINGELLA 2018-10-09	DRAWING NUMBER <b>HLT11</b>