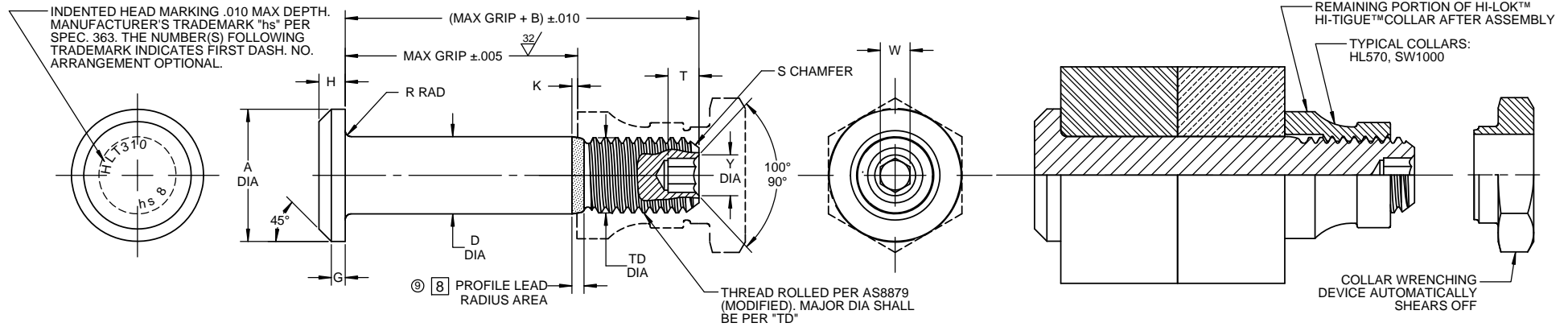


⑨ For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at:  
[HTTP://WWW.LISI-AEROSPACE.COM/LICENSES](http://WWW.LISI-AEROSPACE.COM/LICENSES)



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	G REF	H	K REF	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
												W HEX	T DEPTH	Y DIA		
5	5/32	.262 .242	.312	.1635 .1630	.1595 .1570	.020	.047 .037	.013	.025 .015	1/32 x 37°	.1640-32 UNJC-3A	.0801 .0791	.135 .115	5	4,010	1,940
6	3/16	.315 .295	.325	.1895 .1890	.1840 .1810	.025	.055 .045	.016	.025 .015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	5,380	2,500
8	1/4	.412 .387	.395	.2495 .2490	.2440 .2410	.030	.069 .059	.021	.025 .015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	9,300	4,300
10	5/16	.505 .475	.500	.3120 .3115	.3060 .3020	.035	.078 .068	.026	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	14,600	6,300
12	3/8	.600 .565	.545	.3745 .3740	.3680 .3640	.040	.088 .078	.030	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	21,000	8,700
14	7/16	.676 .641	.635	.4370 .4365	.4310 .4260	.045	.105 .093	.035	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	28,600	12,100
16	1/2	.770 .735	.685	.4995 .4990	.4930 .4880	.050	.115 .103	.039	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	37,300	15,300

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

- GENERAL NOTES:**
- Concentricity: "A" to "D" diameter within .010 FIM.
  - Dimensions are in inches and to be met before finish.
  - Surface texture per ASME B46.1.
  - Hole preparation per NAS618.
  - Evidence of broken edge across points.
  - Use HLT610 for oversize replacement.
  - 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.
  - This area has a special profile lead radius instead of the HI-TIGUE™ feature.

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

**HEAT TREAT:** 95,000 psi shear minimum.

- FINISH:**
- HLT310(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
  - HLT310AP(-)(-) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HLT310DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HLT310TA(-)(-) = Anodize per Ti-Shield III, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HLT310TB(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HLT310HK(-)(-) = 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**

- ⑨ **EXAMPLE:** Pin Part Number HLT310TB8-8
- 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 PROTRUDING SHEAR HEAD TITANIUM 1/16 GRIP VARIATION
APPROVED JGWILCOX	DATE 1976-11-12	DRAWING NUMBER HLT310
REVISION 9	DATE M.BEARD 2017-07-05	1 OF 1