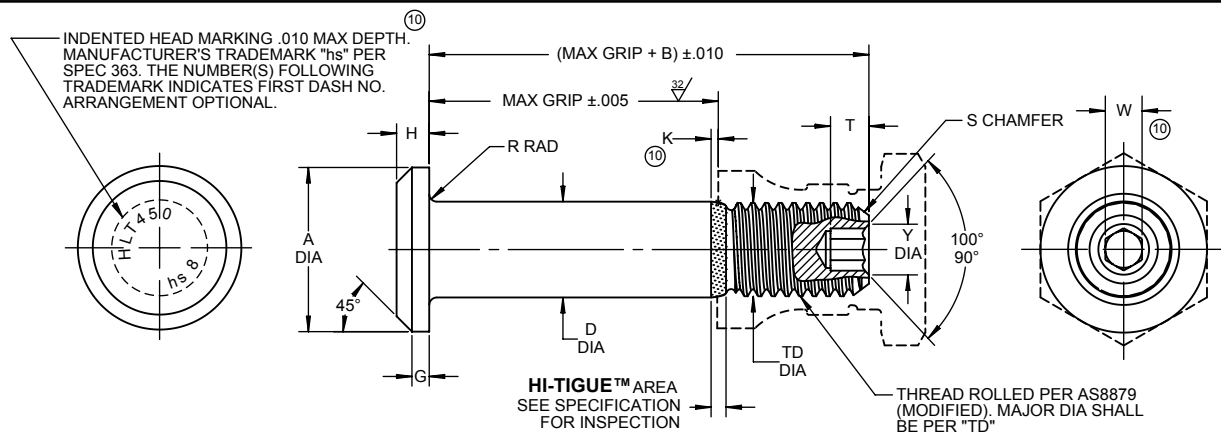
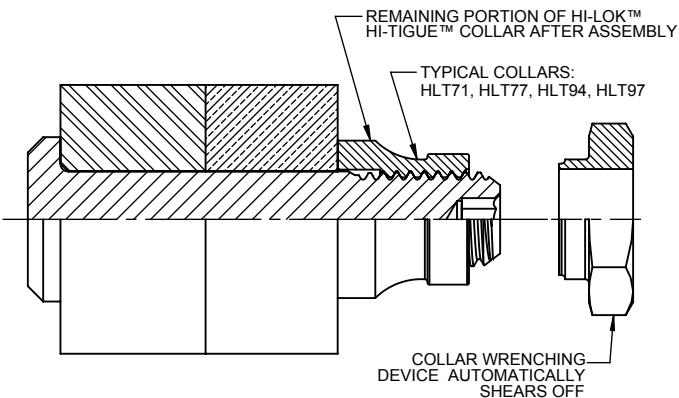


For the current list of licensed manufacturers, please visit the  
 LISI AEROSPACE website at:  
[HTTP://WWW.LISI-AEROSPACE.COM/LICENSES](http://www.lisi-aerospace.com/licenses)



HI-LOK™ HI-TIGUE™ PIN



HI-LOK™ HI-TIGUE™ PIN AND COLLAR AFTER ASSEMBLY

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 MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING OR SOLID FILM LUBE	AFTER COATING OR SOLID FILM LUBE								W HEX	T DEPTH	Y DIA		
4	1/8	.250 .230	.294	.1375 .1370	.1375 .1365	.1335 .1310	.020	.042 .032	.010	.020 .010	1/32 x 37°	.1380-32 UNJC-3A	.0645 .0635	.100 .080	5	2,840	1,350
5	5/32	.262 .242	.312	.1635 .1630	.1635 .1625	.1595 .1570	.020	.047 .037	.013	.025 .015	1/32 x 37°	.1640-32 UNJC-3A	.0801 .0791	.100 .080	5	4,010	1,940
6	3/16	.315 .295	.325	.1895 .1890	.1895 .1885	.1840 .1810	.025	.055 .045	.016	.025 .015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	5,380	2,500
8	1/4	.412 .387	.395	.2495 .2490	.2495 .2485	.2440 .2410	.030	.069 .059	.021	.025 .015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	9,300	4,300
10	5/16	.505 .475	.500	.3120 .3115	.3120 .3110	.3060 .3020	.035	.078 .068	.026	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	14,600	6,300
12	3/8	.600 .565	.545	.3745 .3740	.3745 .3735	.3680 .3640	.040	.088 .078	.030	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	21,000	8,700
14	7/16	.676 .641	.635	.4370 .4365	.4370 .4360	.4310 .4260	.045	.105 .093	.035	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	28,600	12,100
16	1/2	.770 .735	.685	.4995 .4990	.4995 .4985	.4930 .4880	.050	.116 .103	.039	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	37,300	15,300
18	9/16	.864 .829	.770	.5615 .5610	.5615 .5605	.5550 .5500	.055	.127 .112	.039	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	47,200	19,000
20	5/8	.953 .918	.825	.6240 .6235	.6240 .6230	.6180 .6120	.060	.137 .122	.044	.040 .025	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	58,300	23,000
24	3/4	1.108 1.066	1.050	.7490 .7485	.7490 .7480	.7430 .7370	.070	.151 .136	.044	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	83,900	30,700

"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 SHEAR HEAD TITANIUM 1/16 GRIP VARIATION	
APPROVED R.TING	DATE 1983-04-06		
REVISION 10	DATE M.BEARD 2017-05-08	DRAWING NUMBER <b>HLT450</b>	

- GENERAL NOTES:

1. Concentricity: "A" to "D" diameter within .010 FIM.

2. Surface texture per ASME B46.1.

3. Hole preparation per NAS618.

4]Maximum "D" diameter may be increased by .0002 to allow for solid film lube application.

5]Evidence of broken edge across points.

6. Use HLT434 for oversize replacement.

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.

8. Dimensions are in inches.

MATERIAL:

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

HEAT TREAT:

95,000 psi shear minimum.

- FINISH:

HLT450-( )-( ) = Cetyl alcohol lube per Hi-Shear Spec. 305.

7] HLT450AP( )-( ) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

HLT450FB( )-( ) = Grit blast top of head, and cetyl alcohol lube per Hi-Shear Spec. 305.

HLT450TB( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.

HLT450TF( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.

10] HLT450MA( )-( ) = Solid film lube per KALGARD RA.

10] HLT450HK( )-( ) = 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

10] EXAMPLE:

Pin Part Number

HLT450TF8-8

8/16 or 1/2 Maximum Grip Length

8/32 or 1/4 Nominal Diameter Pin

Finish Code

Pin Basic Part Number

HLT450