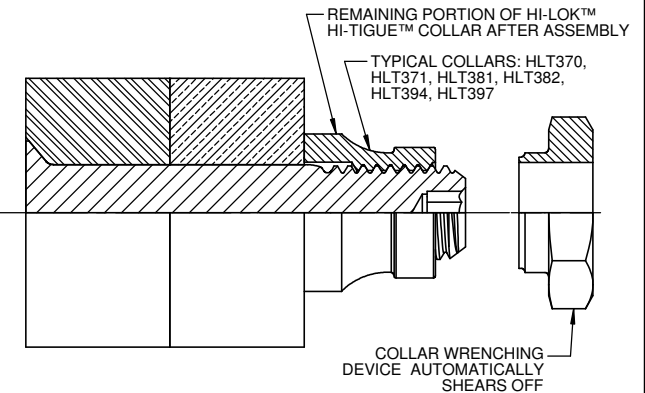
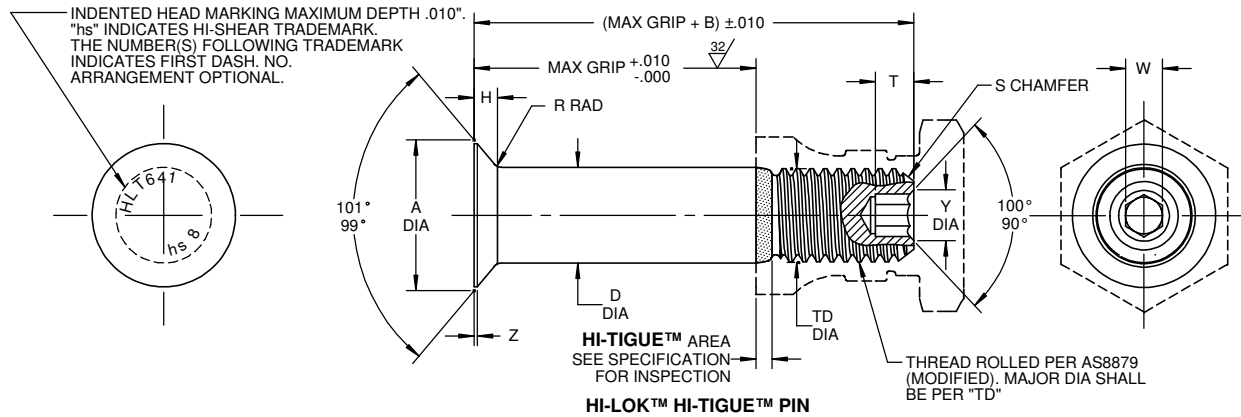


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HI-LOK™ HI-TIGUE™ PIN AND COLLAR AFTER ASSEMBLY

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 BEFORE SOLID FILM	TD DIA	F	H	R RAD	Z	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
												W HEX	T DEPTH	Y DIA		
6	7/32	.3303 .3253	.445	.2255 .2250	.1840 .1810	.005	.0440 .0419	.030 .020	.015 .005	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	7,500	2,000
8	9/32	.4260 .4210	.525	.2857 .2852	.2440 .2410	.006	.0589 .0568	.030 .020	.015 .005	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	12,100	3,700
10	11/32	.5051 .5001	.645	.3488 .3483	.3060 .3020	.007	.0656 .0635	.040 .030	.015 .005	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	18,000	5,000
12	13/32	.5916 .5866	.690	.4117 .4112	.3680 .3640	.008	.0755 .0734	.040 .030	.015 .005	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	25,100	7,200
14	15/32	.6992 .6932	.800	.4748 .4743	.4310 .4260	.009	.0941 .0916	.050 .040	.022 .005	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	33,500	10,000
16	17/32	.7852 .7792	.855	.5377 .5372	.4930 .4880	.010	.1038 .1013	.050 .040	.022 .005	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	43,000	13,500
20	21/32	.9562 .9492	1.010	.6637 .6632	.6180 .6120	.010	.1227 .1197	.050 .040	.022 .005	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	65,600	21,000
24	25/32	1.1282 1.1162	1.240	.7897 .7892	.7430 .7370	.012	.1420 .1370	.050 .040	.022 .005	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	92,800	30,700

- 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.
 - Dimensions to be met after finish and before solid film lubricant, where applicable.
 - Surface texture per ASME B46.1.
 - Hole preparation per NAS618.
 - Oversize pin for HLT341 and HLT441.

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

HEAT TREAT: 95,000 psi shear minimum.

FINISH: HLT641TL(-)() = Anodize per Hi-Shear Ti-Shield III, solid film lube per DAG-258, and cetyl alcohol lube per Hi-Shear Spec. 305; or anodize per Tiodize Type II, solid film lube per TI-O-LUBE TAL-58, and cetyl alcohol lube per Hi-Shear Spec. 305.

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

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HLT641 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See Finish note for explanation of code letters.

HOW TO ORDER

EXAMPLE: Pin Part Number
HLT641TL8-8

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

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DRAWN BY VAN		DATE 1969-11-10		TITLE HI-LOK™ HI-TIGUE™ PIN	
APPROVED J.G.Wilcox R.Ting		DATE 1969-11-10 1969-11-11		100° FLUSH SHEAR HEAD TITANIUM 1/16 GRIP VARIATION, 1/32 OVERSIZE	
REVISION ⑦		DATE J.Obispo 2017-07-20		DRAWING NUMBER HLT641	