

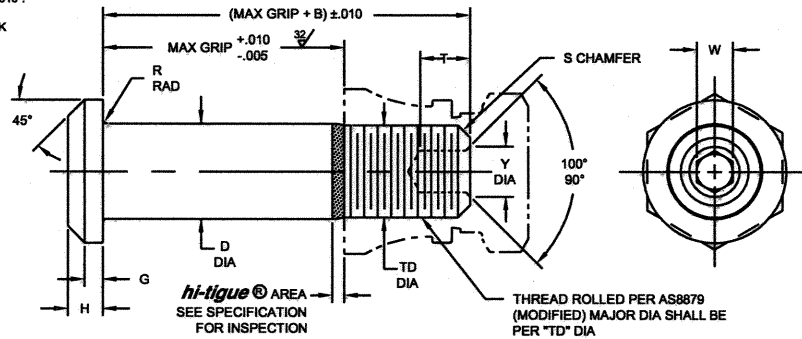
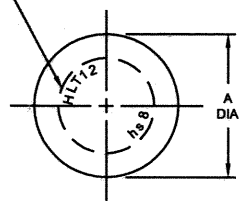
STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

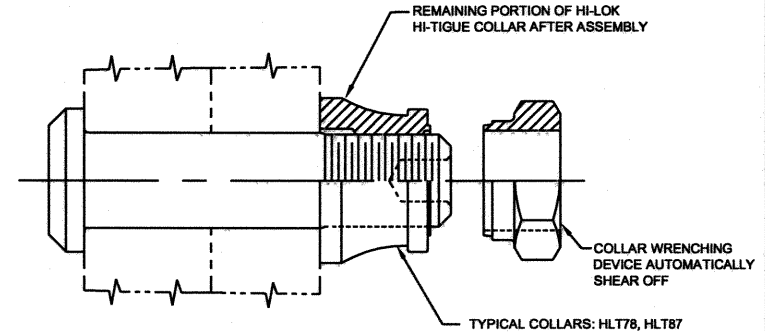
HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
 a LISI AEROSPACE Company
 AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A. & Canada) CAGE No. 06725
 HUCK INTERNATIONAL, INC., U.S.A. (Licensee) CAGE No. 87828
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878
 FAIRCHILD Aerospace Fastener Division (Licensee) CAGE No. 92215
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516
 (Pins & Steel Collars)

BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE No. OLB68
 a LISI AEROSPACE Company
 HUCK S.A. France (Licensee - ECC Countries)
 BLANC AERO S.A. France (Licensee - ECC Countries)
 a LISI AEROSPACE Company
 TOKYO SCREW COMPANY, Japan (Licensee - Japan)

INDENTED HEAD MARKING MAXIMUM DEPTH .010".
 "H" INDICATES HI-SHEAR TRADEMARK.
 THE NUMBER(S) FOLLOWING THE TRADEMARK
 INDICATES FIRST DASH NUMBER.
 ARRANGEMENT OPTIONAL.



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	R RAD	S CHAMFER REF	THREAD	SOCKET			DOUBLE SHEAR POUNDS	TENSION POUNDS MINIMUM	MIN. GRIP LENGTH
				WITHOUT COATING OR SOLID FILM	WITH COATING OR SOLID FILM							W HEX	T DEPTH	Y DIA			
5	5/32	.322 .306	.312	.1695 .1690	.1695 .1685	.1595 .1570	.030	.060 .055	.025 .015	1/32" x 37°	8-32UNJC-3A Modified	.0645 .0635	.100 .080	.090 .075	4,210	2,180	2
6	3/16	.377 .357	.325	.1955 .1950	.1955 .1945	.1840 .1810	.035	.074 .064	.025 .015	1/32" x 37°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	5,550	2,750	2
8	1/4	.440 .415	.395	.2555 .2550	.2555 .2545	.2440 .2410	.045	.090 .080	.025 .015	1/32" x 37°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	9,620	5,820	2
10	5/16	.505 .475	.500	.3180 .3175	.3180 .3170	.3060 .3020	.055	.112 .102	.030 .020	3/64" x 37°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	14,890	9,200	2
12	3/8	.600 .565	.545	.3805 .3800	.3805 .3795	.3680 .3640	.075	.140 .130	.030 .020	3/64" x 37°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	21,430	14,000	3
14	7/16	.676 .641	.635	.4430 .4425	.4430 .4420	.4310 .4260	.095	.160 .150	.030 .020	3/64" x 37°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	29,000	18,900	4
16	1/2	.770 .735	.685	.5055 .5045	.5055 .5045	.4930 .4880	.095	.188 .178	.030 .020	3/64" x 37°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	37,900	25,500	4

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

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 2. Dimensions to be met after finish.
 3. Surface texture per ANSI B46.1.
 4. Hole preparation per NAS618 (Column B) for interference application.
 5. Use HLT112 for oversize replacement.
 6. Install per Hi-Shear Spec. 299.
 7. Minimum required for head and Hi-Tigue feature.

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

HEAT TREAT: 160,000 psi tensile minimum (95,000 psi shear minimum).

- FINISH:**
- HLT12(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT12AP(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT12TB(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - Ⓣ HLT12UV(-)(-) = Anodize per Hi-Shear Spec. 306, Type II, Hi-Kote 2 solid film lube per Hi-Shear Spec 292 (spray only) and cetyl alcohol lube (water base) per Hi-Shear Spec. 305.

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 Only
 HLT12-8-8
 ↳ 8/16 or 1/2 Threaded Stud Grip
 ↳ 8/32 or 1/4 Nominal Diameter Pin
 ↳ Pin Part Number

Pin and Collar Assembly Part Number Combination
 HLT1278-8-8
 ↳ Size and grip length, see above example
 ↳ Collar Part Number
 ↳ Pin Part Number

"Hi-Lok", "HL", Hi-Tigue, and "HLT" are internationally registered trademark of Hi-Shear Corporation.		TITLE
DRAWN	DATE	HI-LOK® HI-TIGUE® PIN
VAN	7-1-88	PROTRUDING TENSION HEAD
APPROVED	DATE	TITANIUM
R.Ting	7-25-88	1/16" GRIP VARIATION
REVISION	DATE	DRAWING NUMBER
Ⓣ	JO 10-24-06	HLT12

HLT112