

INDENTED HEAD MARKING MAXIMUM DEPTH .010"
"hs" indicates HI-SHEAR trademark.
"VS" indicates VOI-SHAN trademark.
"SPS" indicates STANDARD PRESSED STEEL trademark.
The number or numbers following the trademark indicate first dash number.

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.		TD DIA.	F	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	MIN. GRIP LENGTH
				WITHOUT SOLID FILM LUBE	WITH SOLID FILM LUBE								W HEX.	T DEPTH	Y DIA.			
-5	5/32	.3304 .3256	.312	.1695 .1690	.1695 .1685	.1595 .1570	.004	.0675 .0655	.025 .015	.010	1/32" x 3/70	8-32UNJC-3A Modified	.0645 .0635	.100 .080	.090 .075	4,210	2,180	-2
-6	3/16	.3813 .3765	.325	.1955 .1950	.1955 .1945	.1840 .1810	.005	.0780 .0760	.030 .020	.015	1/32" x 3/70	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	5,550	2,750	-3
-8	1/4	.5066 .5018	.395	.2555 .2550	.2555 .2545	.2440 .2410	.006	.1054 .1034	.030 .020	.015	1/32" x 3/70	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	9,620	5,820	-3
-10	5/16	.6335 .6287	.500	.3180 .3175	.3180 .3170	.3060 .3020	.007	.1324 .1304	.040 .030	.015	3/64" x 3/70	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	14,890	9,200	-3
-12	3/8	.7604 .7556	.545	.3805 .3800	.3805 .3795	.3680 .3640	.008	.1594 .1574	.040 .030	.015	3/64" x 3/70	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	21,430	14,000	-4
-14	7/16	.8884 .8812	.635	.4430 .4425	.4430 .4420	.4310 .4260	.009	.1869 .1839	.050 .040	.022	3/64" x 3/70	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	29,000	18,900	-5
-16	1/2	1.0139 1.0068	.685	.5055 .5050	.5055 .5045	.4930 .4880	.010	.2133 .2103	.050 .040	.022	3/64" x 3/70	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	37,900	25,500	-5

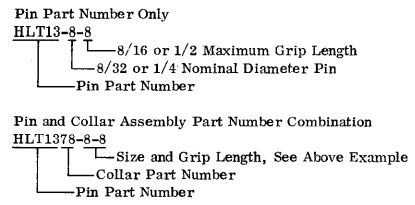
SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH.

① GENERAL NOTES:

- Head edge out of roundness shall not exceed "F."
- Concentricity: Conical surface of head to "D" diameter within .005 FIR.
- "H" is dimensioned from maximum "D" diameter.
- Dimensions to be met after finish.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618 (Column "B") for interference application.
- Use HLT113 for oversize replacement.
- Install per Hi-Shear Spec. 299.
- Minimum required for head and Hi-Tigue feature.
- Curved or flat edge manufacturer's option.

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 EXAMPLES:



MATERIAL: 6Al-4V titanium alloy per Spec. AMS4928 or AMS4967.
HEAT TREAT: 160,000 psi tensile minimum (95,000 psi shear minimum).
FINISH: HLT13-()-() = Cetyl alcohol lube per Hi-Shear Spec. 305.
HLT13AP-()-() = HI-Kote 1 per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT13TB-()-() = HI-Kote 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.
SPECIFICATION: HI-Lok Hi-Tigue Product Specification 342.

U.S. patents 3,138,987; 3,390,906; 3,578,367; and foreign patents. "Hi-Lok," "HL," "Hi-Tigue" and "HLT" are Registered Trademarks of Hi-Shear Corporation.	
DRAWN VAN 7-1-68	DATE
APPROVED R. TING 7-25-68	DATE
REVISION 9	DATE D. P. S. 10-29-81
hi-lok hi-tigue PIN 100° FLUSH MS24694 TENSION HEAD TITANIUM 1/16" GRIP VARIATION DRAWING NUMBER HLT13	

HLT13