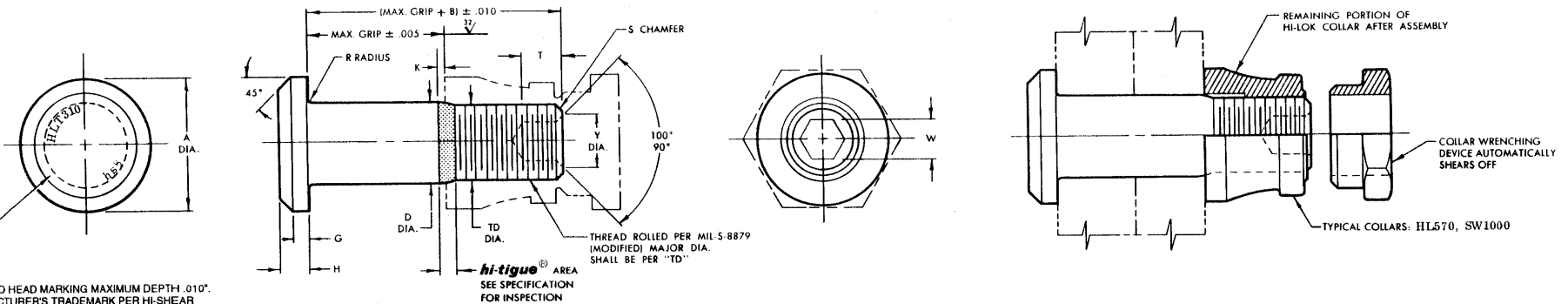


# STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197  
 Division of Hi-Shear Industries Inc., U.S.A.  
 AIR INDUSTRIES CO., INC. (Licensee - U.S. & Canada) CAGE No. 06725  
 HUCK INTERNATIONAL, INC., Deutsch Operation, U.S.A. (Licensee) CAGE No. 97928  
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56678  
 FAIRCHILD Aerospace Fastener Division, U.S.A. (Licensee) CAGE No. 92215  
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 80516  
 (Pins & Steel Collars)

HI-SHEAR FASTENERS EUROPE LTD., U.K. (Licensee) CAGE No. 0LB68  
 Division of Hi-Shear Industries Inc., U.S.A.  
 HUCK INTERNATIONAL GmbH & Co. Germany (Licensee - EEC Countries)  
 ST. CHAMOND GRANAT, S.A. France (Licensee - EEC Countries)  
 SIMMONDS, S.A. France (Licensee - EEC Countries - Collars)  
 TOKYO SCREW COMPANY, Japan (Licensee - Japan)



INDENTED HEAD MARKING MAXIMUM DEPTH .010". MANUFACTURER'S TRADEMARK PER HI-SHEAR SPEC. 363. THE NUMBER(S) FOLLOWING THE TRADEMARK INDICATE FIRST DASH NUMBER. ARRANGEMENT OPTIONAL.

HI-LOK HI-TIGUE PIN

HI-LOK HI-TIGUE PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.	TD DIA.	G REF.	H	K REF.	R RAD.	S CHAMFER REF.	THREAD	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°	8-32UNJC-3A Modified	.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°	10-32UNJF-3A Modified	.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°	1/4-28UNJF-3A Modified	.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°	5/16-24UNJF-3A Modified	.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°	3/8-24UNJF-3A Modified	.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°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	28,600	12,100
16	1/2	.770 .735	.685	.4995 .4990	.4930 .4880	.055	.115 .103	.039	.030 .020	3/64" x 37°	1/2-20UNJF-3A Modified	.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:
1. Concentricity: "A" to "D" diameter within .010 FIR.
  2. Dimensions to be met before finish.
  3. Surface texture per ANSI B46. 1.
  4. Hole preparation per NAS618.
  5. Evidence of broken edge across points.
  6. Use HLT610 for oversize replacement.

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.

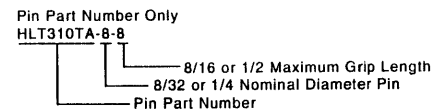
MATERIAL: 6Al-4V titanium alloy per AMS4928 or AMS4967.

HEAT TREAT: 95,000 psi shear minimum.

- FINISH:
- HLT310-( )-( ) = Cetyl alcohol lube per Hi-Shear Spec. 305.
  - ⑤ 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 MIL-L-46010, 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.

SPECIFICATION: Hi-Lok Hi-Tigue Product Specification 342.

HOW TO ORDER  
EXAMPLES:



"Hi-Lok", "HL", "Hi-Tigue", and "HLT" are internationally registered trademarks of Hi-Shear Corporation.		TITLE <b>HI-LOK® HI-TIGUE® PIN</b> PROTRUDING SHEAR HEAD TITANIUM 1/16" GRIP VARIATION
DRAWN D.P.S.	DATE 11-11-76	DRAWING NUMBER <b>HLT310</b>
APPROVED JGWilcox	DATE 11/12/76	
REVISION ⑤	DATE J.F.Obispo 9-20-95	