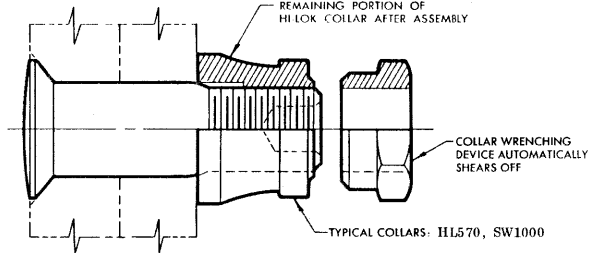
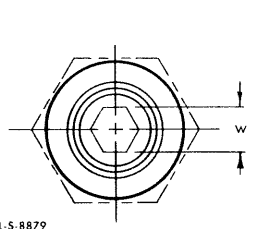
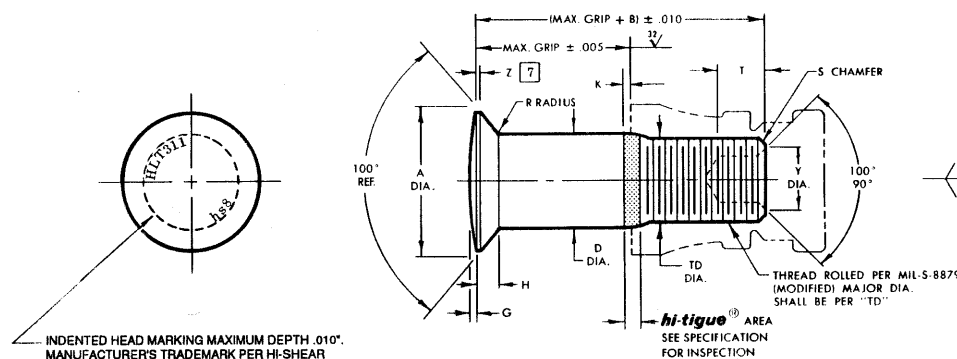


# STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197	HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee) CAGE No. 0LB68
Division of Hi-Shear Industries Inc., U.S.A.	Division of Hi-Shear Industries Inc., U.S.A.
AR INDUSTRIES CO., INC. (Licensee - U.S. & Canada) CAGE No. 08725	HUCK INTERNATIONAL GmbH & Co. Germany (Licensee - EEC Countries)
HUCK INTERNATIONAL, INC., Deutsch Operation, U.S.A. (Licensee) CAGE No. 97928	ST. CHAMOND GRANAT, S.A. France (Licensee - EEC Countries)
SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 66876	SIMMONDS, S.A. France (Licensee - EEC Countries - Collara)
FAIRCHILD Aerospace Fastener Division, U.S.A. (Licensee) CAGE No. 92215	TOKYO SCREW COMPANY, Japan (Licensee - Japan)
WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60616	

(Pins & Sheet Collars)



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.	F	G	H	K REF.	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
														W HEX.	T DEPTH	Y DIA.		
5	5/32	.2812 .2564	.312	.1635 .1630	.1595 .1570	.004	.015 .010	.0408 .0388	.013	.025 .015	.010	1/32" x 37°	8-32UNJC-3A Modified	.0801 .0791	.135 .115	[8]	4,010	1,750
6	3/16	.3016 .2966	.325	.1895 .1890	.1840 .1810	.005	.015 .010	.0470 .0449	.016	.030 .020	.015	1/32" x 37°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	5,380	2,000
8	1/4	.3948 .3898	.395	.2495 .2490	.2440 .2410	.006	.015 .010	.0610 .0589	.021	.030 .020	.015	1/32" x 37°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	9,300	3,700
10	5/16	.4739 .4689	.500	.3120 .3115	.3060 .3020	.007	.015 .010	.0679 .0658	.026	.040 .030	.015	3/64" x 37°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	14,600	5,500
12	3/8	.5604 .5554	.545	.3745 .3740	.3680 .3640	.008	.015 .010	.0780 .0759	.030	.040 .030	.015	3/64" x 37°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	21,000	7,200
14	7/16	.6680 .6620	.635	.4370 .4365	.4310 .4260	.009	.015 .010	.0969 .0944	.035	.050 .040	.022	3/64" x 37°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	28,600	10,000
16	1/2	.7540 .7480	.685	.4995 .4990	.4930 .4880	.010	.015 .010	.1068 .1043	.039	.050 .040	.022	3/64" x 37°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	37,300	13,500

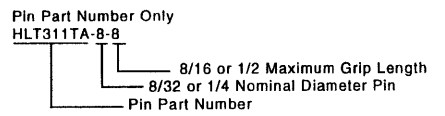
SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH.

GENERAL NOTES:

- 1 Head edge out of roundness shall not exceed "F".
- 2 Concentricity: Conical surface of head to "D" diameter within .005 FIR.
- 3 "H" is dimensioned from maximum "D" diameter.
- 4 Dimensions to be met before finish.
- 5 Surface texture per ANSI B46. 1.
- 6 Hole preparation per NAS618.
- 7 Curved or flat edge manufacturer's option.
- 8 Evidence of broken edge across points.
- 9 Use HLT435 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.

HOW TO ORDER EXAMPLES:



- MATERIAL: 6Al-4V titanium alloy per AMS4928 or AMS4967.
- HEAT TREAT: 95,000 psi shear minimum.
- FINISH: HLT311(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.  
 HLT311AP(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HLT311DL(-)(-) = Solid film lube per MIL-L-46010, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HLT311TA(-)(-) = 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.  
 HLT311TB(-)(-) = 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.

DRAWN DATE		TITLE	
D.P.S.	11-11-76	HI-LOK® HI-TIGUE® PIN 100° FLUSH CROWN SHEAR HEAD TITANIUM 1/16" GRIP VARIATION	
APPROVED DATE		DRAWING NUMBER	
JGWilcox	11/15/76	HLT311	
REVISION	DATE		
⑥	J.F.Obispo 07-03-96		

HLT311