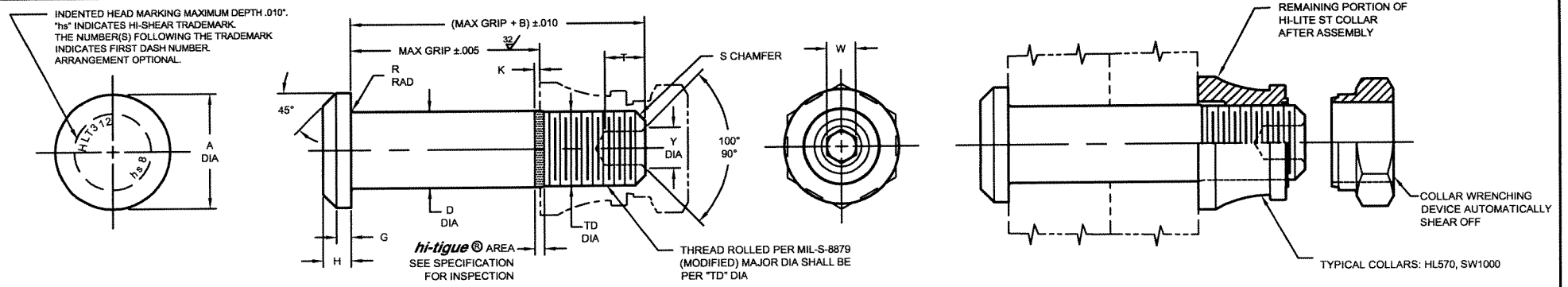


STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
 a GFI 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. 97528
 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. 0LB68
 a GFI AEROSPACE Company
 HUCK S.A. France (Licensee - ECC Countries)
 BLANC AERO S.A. France (Licensee - ECC Countries)
 a GFI AEROSPACE Company
 TOKYO SCREW COMPANY, Japan (Licensee - Japan)



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	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	.322 .306	.312	.1635 .1630	.1595 .1570	.030	.065 .055	.013	.025 .015	1/32" x 37°	8-32UNJC-3A Modified	.0801 .0791	.135 .115	5	4,010	2,180
6	3/16	.377 .357	.325	.1895 .1890	.1840 .1810	.035	.074 .064	.016	.025 .015	1/32" x 37°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	5,380	3,180
8	1/4	.440 .415	.395	.2495 .2490	.2440 .2410	.045	.090 .080	.021	.025 .015	1/32" x 37°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	9,300	5,820
10	5/16	.505 .475	.500	.3120 .3115	.3060 .3020	.055	.112 .102	.026	.030 .020	3/64" x 37°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	14,600	9,200
12	3/8	.600 .565	.545	.3745 .3740	.3680 .3640	.075	.140 .130	.030	.030 .020	3/64" x 37°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	21,000	14,000
14	7/16	.676 .641	.635	.4370 .4365	.4310 .4260	.095	.160 .150	.035	.030 .020	3/64" x 37°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	28,600	18,900
16	1/2	.770 .735	.685	.4995 .4990	.4930 .4880	.095	.188 .178	.039	.030 .020	3/64" x 37°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	37,300	25,500

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

- GENERAL NOTES:**
- Concentricity: "A" to "D" diameter within .010 FIM.
 - Dimensions to be met before finish, except "AP" thread dimensions after finish.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - 5 Evidence of broken edge across points.
 - Use HLT612 for oversize replacement.

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
 HLT312TA-8-8
 8/16 or 1/2 Threaded Stud Grip
 Replaces 8/32 or 1/4 Nominal Diameter Pin
 Pin Part Number with Type II Cadmium Plate

- MATERIAL:** 6Al-4V titanium alloy per AMS4928 or AMS4967.
- HEAT TREAT:** 95,000 psi shear minimum.
- FINISH:**
- HLT312(-)(-) = Cetyl alcohol luber per Hi-Shear Spec 305.
 - HLT312AP(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec 305.
 - HLT312DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec 305.
 - HLT312TA(-)(-) = 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.
 - HLT312TB(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec 292, and cetyl alcohol lube per Hi-Shear Spec 305.

DRAWN DATE		TITLE	
D.P.S.	11-11-76	HI-LOK® HI-TIGUE® PIN	
APPROVED DATE		PROTRUDING TENSION HEAD	
JGWilcox	11/12/76	TITANIUM	
REVISION DATE		DRAWING NUMBER	
7	10-18-01	HLT312	

HLT312