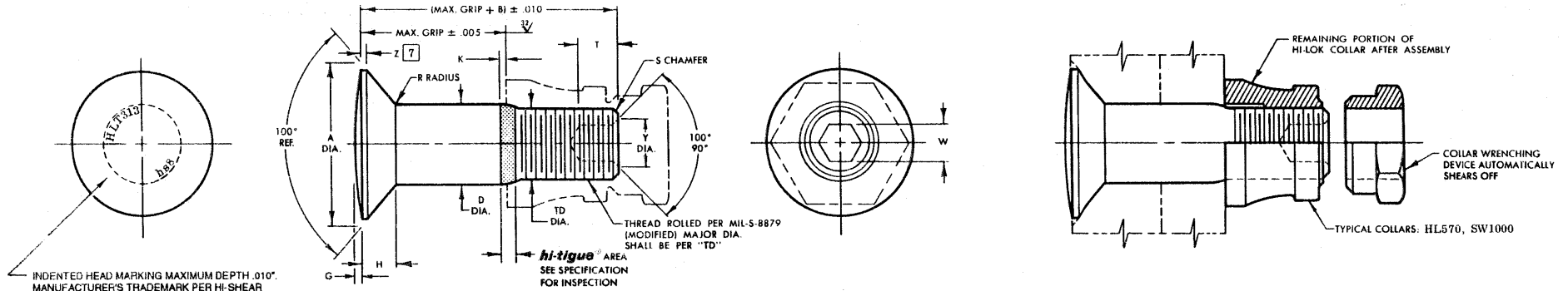


STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

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. OLB68
Division of Hi-Shear Industries Inc., U.S.A.		Division of Hi-Shear Industries Inc., U.S.A.	
AIR INDUSTRIES CO., INC. (Licensee - U.S. & Canada)	CAGE No. 06725	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. 58878	SIMMONDS S.A. France (Licensee - EEC Countries - Collars)	
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. 80516		

(Pins & Steel Collars)



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.	1		H	K REF.	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
						F	G							W HEX.	T DEPTH	Y DIA.		
5	5/32	.3304 .3256	.312	.1635 .1630	.1595 .1570	.004	.015 .010	.0698 .0678	.013	.025 .015	.010	1/32" x 37°	8-32UNJC-3A Modified	.0801 .0791	.135 .115	8	4,010	2,180
6	3/16	.3813 .3765	.325	.1895 .1890	.1840 .1810	.005	.015 .010	.0805 .0785	.016	.030 .020	.015	1/32" x 37°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	5,380	3,180
8	1/4	.5066 .5018	.395	.2495 .2490	.2440 .2410	.006	.015 .010	.1080 .1060	.021	.030 .020	.015	1/32" x 37°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	9,300	5,820
10	5/16	.6335 .6287	.500	.3120 .3115	.3060 .3020	.007	.015 .010	.1350 .1330	.026	.040 .030	.015	3/64" x 37°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	14,600	9,200
12	3/8	.7604 .7556	.545	.3745 .3740	.3680 .3640	.008	.015 .010	.1620 .1600	.030	.040 .030	.015	3/64" x 37°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	21,000	14,000
14	7/16	.8884 .8812	.635	.4370 .4365	.4310 .4260	.009	.015 .010	.1895 .1865	.035	.050 .040	.022	3/64" x 37°	7/16-20UNJF-3A Modified	.1980 .1895	.230 .210	.253 .233	28,600	18,900
16	1/2	1.0139 1.0068	.685	.4995 .4990	.4930 .4880	.010	.015 .010	.2160 .2130	.039	.050 .040	.022	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:

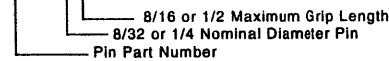
- 1 Head edge out of roundness shall not exceed "F".
2. Concentricity: Conical surface of head to "D" diameter within .005 FIR.
3. "H" is dimensioned from maximum "D" diameter.
4. Dimensions to be met before finish.
5. Surface texture per ANSI B46. 1.
6. Hole preparation per NAS618.
- 7 Curved or flat edge manufacturer's option.
- 8 Evidence of broken edge across points.
9. Use HLT437 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:

Pin Part Number Only
HLT313TA-B-8



MATERIAL:

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

HEAT TREAT:

160,000 psi tensile minimum (95,000 psi shear minimum).

FINISH:

- HLT313(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
- ⑥ HLT313AP(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT313DL(-)(-) = Solid film lube per MIL-L-46010, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT313TA(-)(-) = 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.
- HLT313TB(-)(-) = 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.

"Hi-Lok", "HL", "Hi-Tigue", and "HLT" are internationally registered trademarks of Hi-Shear Corporation.		
DRAWN	DATE	TITLE
D.P.S.	11-12-76	HI-LOK® HI-TIGUE® PIN 100° FLUSH CROWN MS24694 TENSION HEAD, TITANIUM 1/16" GRIP VARIATION
APPROVED	DATE	DRAWING NUMBER
JGWilcox	1-24-90	HLT313
REVISION	DATE	
⑥	J.F.Obispo 9-20-95	