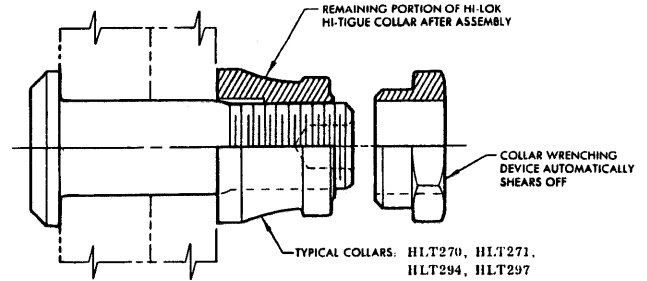
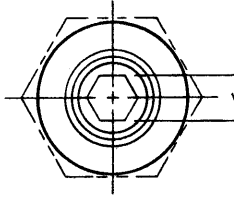
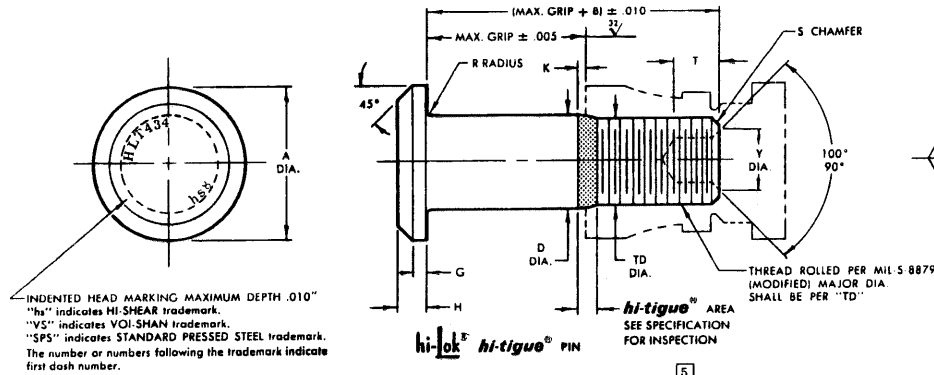


**STANDARDS COMMITTEE FOR HI-LOK<sup>®</sup> HI-TIGUE<sup>®</sup> PRODUCTS**  
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

© HI-SHEAR CORPORATION, U.S.A. (Patent Holder) U.S. Federal Code I.D. No. 73197  
 Division of Hi-Shear Industries Inc., U.S.A.  
 AIRCRAFT FASTENERS (Forged Parts) LTD., U.K. (Licensee)  
 Division of Hi-Shear Industries Inc., U.S.A.  
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 WEST COAST AEROSPACE INC., U.S.A. (Licensee—Oversize Pins & Steel Collars)  
 U.S. Federal Code I.D. No. 60516



hi-lok hi-tigue<sup>®</sup> 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		
				CETYL ALCOHOL	COATING OR SOLID FILM LUBE								W HEX.	T DEPTH	Y DIA.				
-5				NOTE: USE HLT334-6 OR HLT450-6															
-6	13/64	.315 .295	.360	.2026 .2021	.2026 .2016	.1840 .1810	.025	.055 .045	.020	.025 .015	1/32" x 37°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	6,130	2,500		
-8	17/64	.412 .387	.435	.2651 .2646	.2651 .2641	.2440 .2410	.030	.069 .059	.025	.025 .015	1/32" x 37°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	10,490	4,300		
-10	21/64	.505 .475	.545	.3276 .3271	.3276 .3266	.3060 .3020	.035	.078 .068	.031	.030 .020	3/64" x 37°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	16,000	6,300		
-12	25/64	.600 .565	.590	.3901 .3896	.3901 .3891	.3680 .3640	.040	.088 .078	.037	.030 .020	3/64" x 37°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	22,700	8,700		
-14	29/64	.676 .641	.690	.4526 .4521	.4526 .4516	.4310 .4260	.045	.105 .093	.039	.030 .020	3/64" x 37°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	30,600	12,100		
-16	33/64	.770 .735	.740	.5151 .5146	.5151 .5141	.4930 .4880	.050	.116 .103	.045	.030 .020	3/64" x 37°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	39,600	15,300		
-18	37/64	.864 .829	.825	.5771 .5766	.5771 .5761	.5550 .5500	.055	.127 .112	.043	.040 .025	1/16" x 37°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	49,700	19,000		

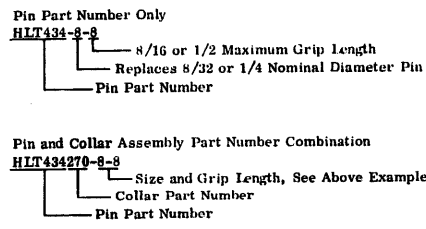
SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH.

- GENERAL NOTES:
1. Concentricity: "A" to "D" diameter within .010 FIR.
  2. Surface texture per ANSI B46.1.
  3. Hole preparation per NAS618.
  4. Use HLT634 for oversize replacement.
  5. Maximum "D" diameter may be increased by .0002 to allow for coating application.

© CODE: First dash number indicates nominal diameter in 32nds of the pin which HLT434 oversize pin replaces. Second dash number indicates maximum grip in 16ths. See "Finish" note for explanation of code letters.

MATERIAL: 6Al-4V titanium alloy per Spec. AMS4928 or AMS4967.  
 HEAT TREAT: 95,000 psi shear minimum.  
 FINISH: HLT434-( )-( ) = Cetyl alcohol lube per Hi-Shear Spec. 305.  
 HLT434AP-( )-( ) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HLT434BJ-( )-( ) = I.V.D. aluminum coating per MIL-C-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HLT434TA-( )-( ) = Ti-Shield IIIA or Ti-dize Type II, Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HLT434TB-( )-( ) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.

HOW TO ORDER EXAMPLES:



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

U.S. Patent 3,578,367 and international patents. "HL", "Hi-Lok", "HLT", and "Hi-Tigue" are internationally registered trademarks of Hi-Shear Corporation.

DRAWN Jep	DATE 3-17-69	<p>PROTRUDING SHEAR HEAD TITANIUM 1/16" GRIP VARIATION - 1/64" OVERSIZE</p>
APPROVED Uep	DATE 3-19-69	
REVISION 10	DATE D. P. S. 10-31-85	DRAWING NUMBER <b>HLT434</b>

HLT434