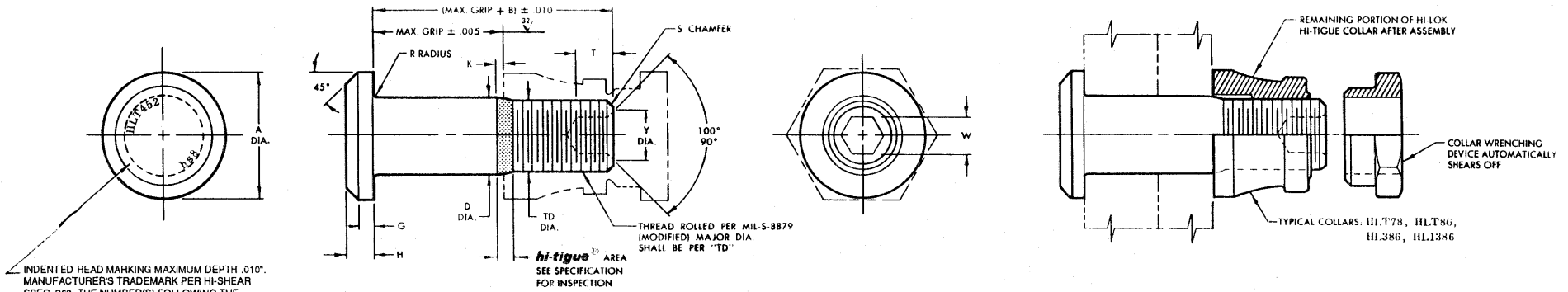


STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
 A Subsidiary of GFI Industries, France
 AIR INDUSTRIES CO., INC. (Licensee - U.S. & Canada) CAGE No. 06725
 HUCK INTERNATIONAL, INC., Deutsch Operation, U.S.A. (Licensee) CAGE No. 87928
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878
 FAIRCHILD Aerospace Fastener Division, U.S.A. (Licensee) CAGE No. 92215
 WESTCAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 80518
 (Pins & Steel Collars)

HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee) CAGE No. 0LB68
 A Subsidiary of GFI Industries, France
 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)



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. [4]		TD DIA.	G REF.	H	K REF.	R RAD.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT HI-KOTE 1 OR HI-KOTE 2	WITH HI-KOTE 1 OR HI-KOTE 2								W HEX.	T DEPTH	Y DIA.		
5	5/32	.322 .306	.312	.1635 .1630	.1635 .1625	.1595 .1570	.030	.065 .055	.013	.025 .015	1/32" x 37°	8-32UNJC-3A Modified	.0801 .0791	.100 .080	[5]	4,010	2,180
6	3/16	.377 .357	.325	.1895 .1890	.1895 .1885	.1840 .1810	.035	.074 .064	.016	.025 .015	1/32" x 37°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	5,380	2,750
8	1/4	.440 .415	.395	.2495 .2490	.2495 .2485	.2440 .2410	.045	.090 .080	.021	.025 .015	1/32" x 37°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	9,300	5,820
10	5/16	.505 .475	.500	.3120 .3115	.3120 .3110	.3060 .3020	.055	.112 .102	.026	.030 .020	3/64" x 37°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	14,600	9,200
12	3/8	.600 .565	.545	.3745 .3740	.3745 .3735	.3680 .3640	.075	.140 .130	.030	.030 .020	3/64" x 37°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	21,000	14,000
14	7/16	.676 .641	.635	.4370 .4365	.4370 .4360	.4310 .4260	.095	.160 .150	.035	.030 .020	3/64" x 37°	7/16-20UNJF-3A Modified	.1830 .1895	.190 .170	.253 .233	28,600	18,900
16	1/2	.770 .735	.685	.4995 .4990	.4995 .4985	.4930 .4880	.095	.188 .178	.039	.030 .020	3/64" x 37°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	37,300	25,500
18	9/16	.877 .842	.770	.5615 .5610	.5615 .5605	.5550 .5500	.125	.210 .200	.039	.040 .025	1/16" x 37°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	47,200	32,400
20	5/8	.953 .918	.825	.6240 .6235	.6240 .6230	.6180 .6120	.140	.238 .228	.044	.040 .025	1/16" x 37°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	58,300	41,000
24	3/4	1.150 1.110	1.050	.7490 .7485	.7490 .7480	.7430 .7370	.200	.335 .320	.044	.045 .030	1/16" x 37°	3/4-16UNJF-3A Modified	.3185 .3150	.330 .300	.398 .378	83,900	59,500

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

GENERAL NOTES:

- Concentricity: "A" to "D" diameter within .010 FIR.
- Surface texture per ANSI B46. 1.
- Hole preparation per NAS618.
- Maximum "D" diameter may be increased by .0002 to allow for solid film lube application.
- Evidence of broken edge across points.
- Use HLT436 or HLT612 for oversize replacement.

MATERIAL:
HEAT TREAT:
FINISH:

- 6Al-4V titanium alloy per Spec. AMS4928 or AMS4967.
 160,000 psi tensile minimum (95,000 psi shear minimum).
 HLT452(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT452AP(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT452FB(-)(-) = Grit blast top of head, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT452FS(-)(-) = Grit blast top of head, Hi-Kote 2 solid film lube on threads only per Hi-Shear Spec. 292, with color light blue on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT452MA(-)(-) = Solid film lube per Kalgard RA.
 HLT452SS(-)(-) = Grit blast top of head, with color light blue on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT452SU(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, with color light blue on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION:

CODE:

HOW TO ORDER EXAMPLE:

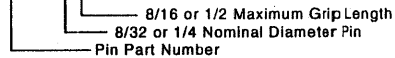
⑨ HLT452TB(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.

HLT452TF(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292. Hi-Lok Hi-Tigue Product Specification 342.

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.

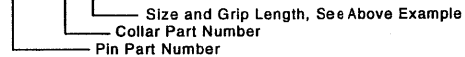
Pin Part Number Only

HLT452TF-8-8



Pin and Collar Assembly Part Number Combination

HLT452TF78-8-8



DRAWN DATE		TITLE	
D.P.S.	4-5-83	HI-LOK® HI-TIGUE® PIN PROTRUDING TENSION HEAD TITANIUM 1/16" GRIP VARIATION	
APPROVED DATE		DRAWING NUMBER	
R.Ting	4-6-83	HLT452	
REVISION DATE			
⑩	J.Henderson 1-20-98		