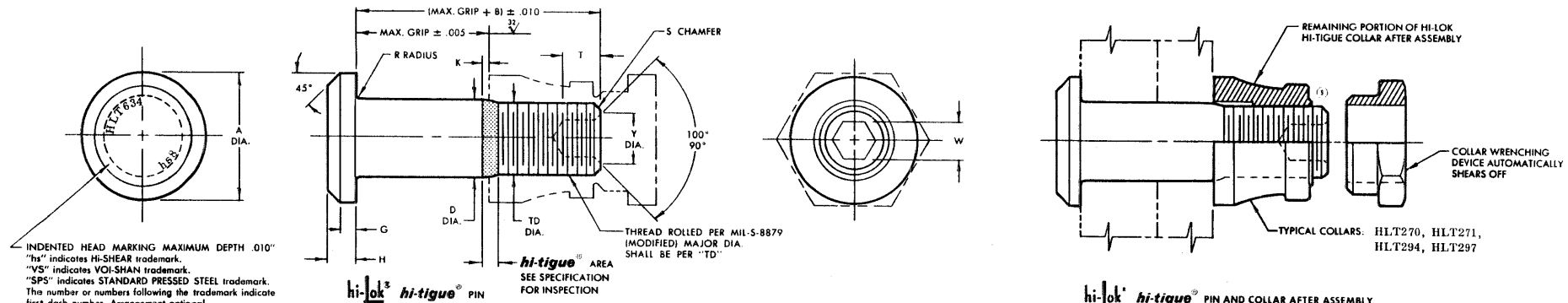


STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

① 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. (Licensee)
 AIRCRAFT FASTENERS (Forged Parts) LTD., U.S.A. (Licensee)
 Division of Hi-Shear Industries Inc., U.S.A.
 VOI-SHAN, Division of VSI Corp., U.S.A. (Licensee) U.S. Federal Code I.D. No. 92215
 SPS TECHNOLOGIES, U.S.A. (Licensee) U.S. Federal Code I.D. No. 56878
 ST. CHAMOND-GRAMAT, S.A. France (Licensee—EEC Countries)
 KAMAX WERKE, Germany (Licensee—EEC Countries)
 Rudolph Kellerman GmbH & Co.
 SIMMONDS, S.A. France (Licensee—EEC Countries—Collars)
 TOKYO SCREW COMPANY, Japan (Licensee—Japan)
 WEST COAST AEROSPACE INC., U.S.A. (Licensee—Oversize Pins & Steel Collars)
 U.S. Federal Code I.D. No. 60516



INDENTED HEAD MARKING MAXIMUM DEPTH .010"
 "hs" indicates HI-SHEAR trademark.
 "VS" indicates VOI-SHAN trademark.
 "SPS" indicates STANDARD PRESSED STEEL trademark.
 The number or numbers following the trademark indicate first dash number. Arrangement optional.

hi-lok hi-tigue PIN
 hi-tigue AREA
 SEE SPECIFICATION FOR INSPECTION

hi-lok hi-tigue PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	①	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 OF SOLID FILM LUBE								W HEX.	T DEPTH	Y DIA.			
-5					① NOTE: USE HLT334-6 OR HLT450-6														
-6	7/32	.315 .295	.360		.2182 .2177	.2182 .2172	.1840 .1810	.025	.055 .045	.022	.025 .015	1/32" x 37°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	7,100	2,500	
-8	9/32	.412 .387	.435		.2807 .2802	.2807 .2797	.2440 .2410	.030	.069 .059	.027	.025 .015	1/32" x 37°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	11,800	4,300	
-10	11/32	.505 .475	.545		.3432 .3427	.3432 .3422	.3060 .3020	.035	.078 .068	.032	.030 .020	3/64" x 37°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	17,600	6,300	
-12	13/32	.600 .565	.590		.4057 .4052	.4057 .4047	.3680 .3640	.040	.088 .078	.036	.030 .020	3/64" x 37°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	24,600	8,700	
-14	15/32	.676 .641	.690		.4682 .4677	.4682 .4672	.4310 .4260	.045	.105 .095	.035	.030 .020	3/64" x 37°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	32,700	12,100	
-16	17/32	.770 .735	.740		.5307 .5302	.5307 .5297	.4930 .4880	.050	.115 .103	.045	.030 .020	3/64" x 37°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	42,000	15,300	
-18	19/32	.864 .829	.825		.5027 .5922	.5927 .5917	.5550 .5500	.055	.127 .122	.041	.040 .025	1/16" x 37°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	52,400	19,000	

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

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

- ① CODE: First dash number indicates nominal diameter in 32nds of the pin which HLT634 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: HLT634-()-() = Cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT634AP-()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT634BJ-()-() = I.V.D. aluminum coating per MIL-C-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT634TA-()-() = Ti-Shield IIIA or Tiodize Type II, Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT634TB-()-() = 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.

HOW TO ORDER

- EXAMPLES: Pin Part Number Only
 HLT634-8-8
 — 8/16 or 1/2 Maximum Grip Length
 — Replaces 8/32 or 1/4 Nominal Diameter Pin
 Pin Part Number
 Pin and Collar Assembly Part Number Combination
 HLT634270-8-8
 — Size and Grip Length, See Above Example
 — Collar Part Number
 Pin Part Number

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

hi-lok hi-tigue PIN
 PROTRUDING SHEAR HEAD
 TITANIUM
 1/16" GRIP VARIATION - 1/32" OVERSIZE

DRAWN DATE
 V. J. Chapman 3-20-69
 APPROVED DATE
 H. J. Miller 3-24-69
 REVISION DATE
 9 D. P. S. 10-31-85
 DRAWING NUMBER
 HLT634

HLT634