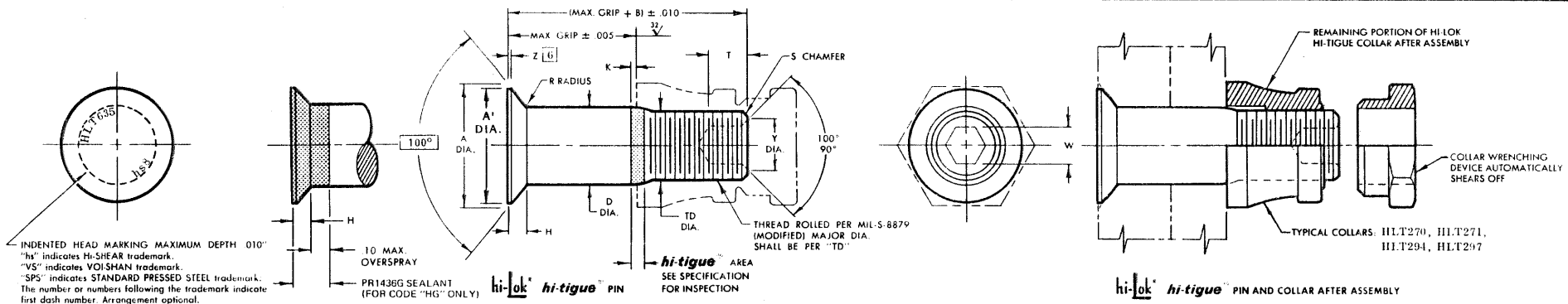


**STANDARDS COMMITTEE FOR  
HI-LOK® HI-TIGUE® PRODUCTS**  
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

HI-SHEAR CORPORATION U.S.A. (Patent Holder) U.S. Federal Code I.D. No. 73197	HI-SHEAR FASTENER EUROPE LTD. U.K. (Licensee)
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. Federal Code I.D. No. 06725	KAMAX-WERKE Germany (Licensee - EEC Countries)
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VOI-SHAN Division of YSI Corp. U.S.A. (Licensee) U.S. Federal Code I.D. No. 92215	SIMMONDS S.A. France (Licensee - EEC Countries - Collars)
WEST COAST AEROSPACE INC. U.S.A. (Licensee) U.S. Federal Code I.D. No. 80516	TOKYO SCREW COMPANY Japan (Licensee - Japan)
Pin & Sheet Collars	



FIRST DASH NO.	NOM. DIA.	A DIA.	A' DIA. MIN.	B REF.	D DIA. [7]		TD DIA.	F	H	K REF.	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
					WITH CETYL ALCOHOL	WITH COATING OR SOLID FILM LUBE									W HEX.	T DEPTH	Y DIA.		
-5					NOTE: USE HLT335-6 or HLT451-6														
-6	7/32	.3303 .3253	.299	.360	.2182 .2177	.2182 .2172	.1840 .1810	.005	.0470 .0449	.022	.030 .020	.015	1/32" x 37°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	7,100	2,000
-8	9/32	.4260 .4210	.395	.435	.2807 .2802	.2807 .2797	.2440 .2410	.006	.0610 .0589	.027	.030 .020	.015	1/32" x 37°	1/4-28UNJF-3A Modified	.0987 .0947	.110 .090	.142 .122	11,800	3,700
-10	11/32	.5051 .5001	.474	.545	.3432 .3427	.3432 .3422	.3060 .3020	.007	.0679 .0658	.032	.040 .030	.015	3/64" x 37°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	17,600	5,000
-12	13/32	.5916 .5866	.560	.590	.4057 .4052	.4047 .4037	.3680 .3640	.008	.0780 .0759	.036	.040 .030	.015	3/64" x 37°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	24,600	7,200
-14	15/32	.6992 .6932	.651	.690	.4682 .4677	.4682 .4672	.4310 .4260	.009	.0969 .0944	.035	.050 .040	.022	3/64" x 37°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	32,700	10,000
-16	17/32	.7852 .7792	.737	.740	.5307 .5302	.5307 .5297	.4930 .4880	.010	.1068 .1043	.045	.050 .040	.022	3/64" x 37°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	42,000	13,500
-18	19/32	.8692 .8622	.821	.825	.5927 .5922	.5927 .5917	.5550 .5500	.010	.1160 .1131	.041	.050 .040	.022	1/16" x 37°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	52,400	17,000
-20	21/32	.9562 .9492	.908	.890	.6562 .6547	.6562 .6542	.6180 .6120	.010	.1263 .1233	.045	.050 .040	.022	1/16" x 37°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	64,100	21,000
-24	25/32	1.1282 1.1162	1.080	1.115	.7802 .7797	.7802 .7792	.7430 .7370	.012	.1460 .1410	.045	.050 .040	.022	1/16" x 37°	3/4-16UNJF-3A Modified	.3185 .3150	.330 .300	.398 .378	90,900	30,700

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

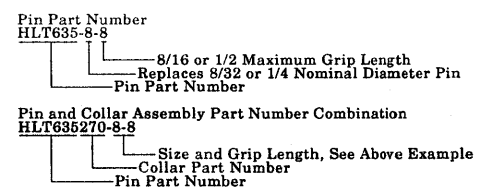
- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
  - Concentricity: Conical surface of head to "D" diameter within .005 FIR.
  - "H" is dimensioned from maximum "D" diameter.
  - Surface texture per ANSI B46.1.
  - Hole preparation per NAS618.
  - Curved or flat edge manufacturer's option.
  - Maximum "D" diameter may be increased by .0002 to allow for coating application.
  - Oversize pin for HLT451, HLT335 and HLT435.

**MATERIAL:** 6Al-4V titanium alloy per Spec. AMS4928 or AMS4967.  
**HEAT TREAT:** 95,000 psi shear minimum.

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

**CODE:** First dash number indicates nominal diameter in 1/32nds of the pin which HLT635 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See finish note for explanation of code letters.

**HOW TO ORDER EXAMPLES:**



- FINISH:**
- HLT635(-)(-) = Bright clean per Hi-Shear Spec. 211, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HLT635AP(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HLT635AZ(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HLT635BJ(-)(-) = I.V.D. aluminum coating per MIL-C-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HLT635FB(-)(-) = Grit blast top of head and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HLT635FW(-)(-) = Grit blast top of head, Hi-Kote 2 solid film lube on threads only per Hi-Shear Spec. 292, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

DRAWN DATE		TITLE	
Van 3-20-69		HI-LOK® / HI-TIGUE® PIN	
APPROVED DATE		100° FLUSH SHEAR HEAD TITANIUM	
J. Miller 3-24-69		1/16" GRIP VARIATION - 1/32" OVERSIZE	
REVISION	DATE	DRAWING NUMBER	
(11)	D.P.S. 8-11-92	<b>HLT635</b>	

HLT635