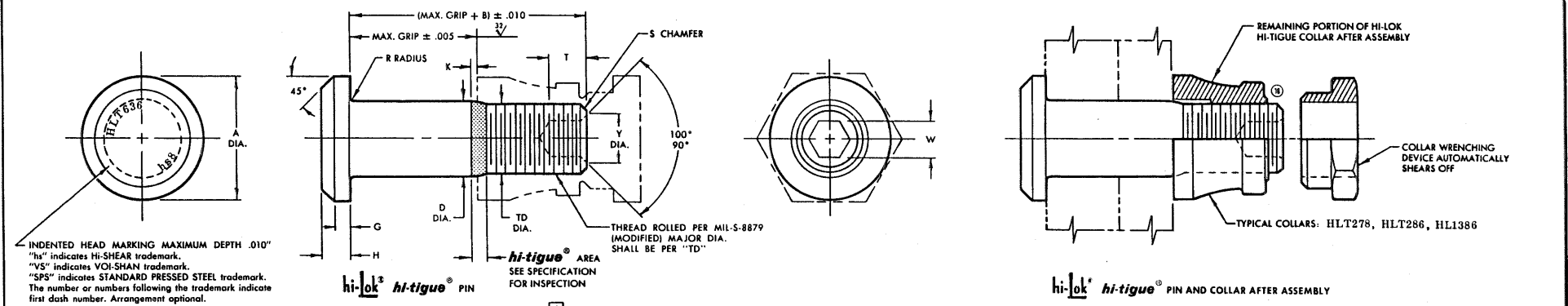


**STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS**  
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) U.S. Federal Code I.D. No. 73197  
 Division of Hi-Shear Industries Inc., U.S.A. (Licensee)  
 AIRCRAFT FASTENERS (Forged Parts) LTD., U.K. (Licensee)  
 Division of Hi-Shear Industries Inc., U.S.A. (Licensee)  
 YOKI-SHAW, Division of VSI Corp., U.S.A. (Licensee) U.S. Federal Code I.D. No. 92218  
 YOKI-SHAW, U.S.A. (Licensee) U.S. Federal Code I.D. No. 56878  
 SPS TECHNOLOGIES, U.S.A. (Licensee) U.S. Federal Code I.D. No. 60516  
 ST. CHAMOND-GRANAT, S.A. France (Licensee—EEC Countries)  
 KAMAX-WERKE, Germany (Licensee—EEC Countries)  
 Rudolf Kellerman GmbH & Co. (Licensee—EEC Countries)  
 SIMMONDS, S.A. France (Licensee—EEC Countries)  
 TOKYO SCREW COMPANY, Japan (Licensee—Japan)  
 WEST COAST AEROSPACE INC., U.S.A. (Licensee—Overize Pins & Steel Collars)  
 U.S. Federal Code I.D. No. 60516



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.		
④ NOTE: USE HLT336-6 OR HST452-6																	
-5				.2182	.2182	.1840	.074	.025	.025	.025	1/32" x 37°	10-32UNJF-3A Modified	.0806	.100	.119	7,100	2,750
-6	7/32	.390 .370	.360	.2177	.2172	.1810	.064	.022	.015	.015	1/32" x 37°	1/4-28UNJF-3A Modified	.0791	.080	.104	7,100	2,750
-8	9/32	.460 .435	.435	.2807	.2807	.2440	.090	.027	.025	.025	1/32" x 37°	1/4-28UNJF-3A Modified	.0967	.110	.142	11,800	5,820
-10	11/32	.520 .490	.545	.3432	.3432	.3060	.112	.032	.030	.030	3/64" x 37°	5/16-24UNJF-3A Modified	.1295	.130	.180	17,600	9,200
-12	13/32	.620 .550	.590	.4057	.4057	.3680	.140	.036	.030	.030	3/64" x 37°	3/8-24UNJF-3A Modified	.1617	.160	.217	24,600	14,000
-14	15/32	.695 .615	.690	.4682	.4682	.4310	.160	.035	.030	.030	3/64" x 37°	7/16-20UNJF-3A Modified	.1930	.190	.253	32,700	18,900
-16	17/32	.790 .740	.740	.5307	.5307	.4930	.188	.045	.030	.030	3/64" x 37°	1/2-20UNJF-3A Modified	.2242	.220	.289	42,000	25,500
-18	19/32	.900 .865	.825	.5927	.5927	.5550	.210	.041	.040	.040	1/16" x 37°	9/16-18UNJF-3A Modified	.2555	.260	.326	52,400	32,400

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 coating application.

④ CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HLT636 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See "Finish" note for explanation of code letters.

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

HEAT TREAT: 160,000 psi tensile minimum (95,000 psi shear minimum).

FINISH: HLT636-( )-( ) = Cetyl alcohol lube per Hi-Shear Spec. 305.  
 HLT636AP-( )-( ) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HLT636BJ-( )-( ) = I.V.D. aluminum coating per MIL-C-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HLT636TA-( )-( ) = Ti-Shield IIIA or Tioidize Type II, Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HLT636TB-( )-( ) = 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  
 HLT636-8-8  
 — 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  
 HLT636278-8-8  
 — Size and Grip Length, See Above Example  
 — Collar Part Number  
 Pin Part Number

U.S. Patent 3,578,367 and international patents. "HLI", "HI-LOK", "HLT", and "HI-TIGUE" are internationally registered trademarks of Hi-Shear Corporation.

DRAWN DATE  
 Van 3-21-69  
 APPROVED DATE  
 [Signature] 3-24-69  
 REVISION DATE  
 10 10-31-85

hi-lok hi-tigue® PIN  
 PROTRUDING TENSION HEAD  
 TITANIUM  
 1/16" GRIP VARIATION - 1/32" OVERSIZE  
 DRAWING NUMBER  
**HLT636**

HLT636