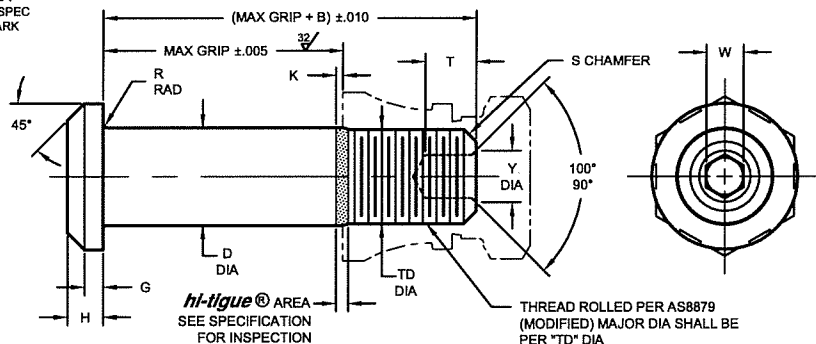
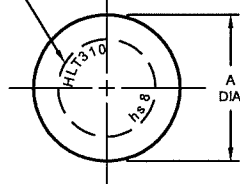
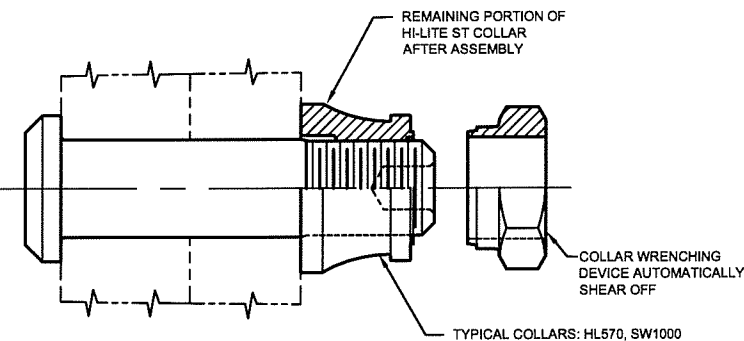


INDENTED HEAD MARKING MAXIMUM DEPTH .010".
MANUFACTURER'S TRADEMARK PER HI-SHEAR SPEC 363. THE NUMBER(S) FOLLOWING THE TRADEMARK INDICATES FIRST DASH NUMBER. ARRANGEMENT OPTIONAL.



HI-LOK® HI-TIGUE® PIN



HI-LOK® HI-TIGUE® PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN 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
												W HEX	T DEPTH	Y DIA		
5	5/32	.262 .242	.312	.1635 .1630	.1595 .1570	.020	.047 .037	.013	.025 .015	1/32" x 37°	8-32UNJC-3A Modified	.0801 .0791	.135 .115	5	4,010	1,940
6	3/16	.315 .295	.325	.1895 .1890	.1840 .1810	.025	.055 .045	.016	.025 .015	1/32" x 37°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	5,380	2,500
8	1/4	.412 .387	.395	.2495 .2490	.2440 .2410	.030	.069 .059	.021	.025 .015	1/32" x 37°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	9,300	4,300
10	5/16	.505 .475	.500	.3120 .3115	.3060 .3020	.035	.078 .068	.026	.030 .020	3/64" x 37°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	14,600	6,300
12	3/8	.600 .565	.545	.3745 .3740	.3680 .3640	.040	.088 .078	.030	.030 .020	3/64" x 37°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	21,000	8,700
14	7/16	.676 .641	.635	.4370 .4365	.4310 .4260	.045	.105 .093	.035	.030 .020	3/64" x 37°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	28,600	12,100
16	1/2	.770 .735	.685	.4995 .4990	.4930 .4880	.050	.115 .103	.039	.030 .020	3/64" x 37°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	37,300	15,300

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

GENERAL NOTES:

1. Concentricity: "A" to "D" diameter within .010 FIM.
2. Dimensions to be met before finish, except threads.
3. Surface texture per ANSI B46.1.
4. Hole preparation per NAS618.
5. Evidence of broken edge across points.
6. Use HLT610 for oversize replacement.

MATERIAL:

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

HEAT TREAT:

95,000 psi shear minimum.

FINISH:

- HLT310-()-() = Cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT310AP()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT310DL()-() = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT310TA()-() = Anodize per Ti-Shield III, Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT310TB()-() = Hi-Kote 2 solid film lube per Hi-Shear Spec.292, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION:

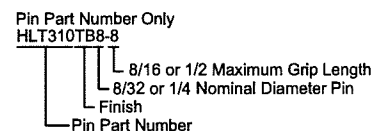
Hi-Lok Hi-Tigue Product Specification 342.

CODE:

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.

HOW TO ORDER

EXAMPLE:



HLT310

DRAWN		DATE		TITLE	
D.P.S.		11-11-76		HI-LOK® HI-TIGUE® PIN PROTRUDING SHEAR HEAD TITANIUM 1/16" GRIP VARIATION	
APPROVED		DATE		DRAWING NUMBER	
JGWlcox		11-12-76		HLT310	
REVISION		DATE		DRAWING NUMBER	
7		12-11-12		HLT310	