

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<br>.242 | .312  | .1635<br>.1630 | .1595<br>.1570 | .020  | .047<br>.037 | .013  | .025<br>.015 | 1/32" x 37°   | 8-32UNJC-3A Modified    | .0801<br>.0791 | .135<br>.115 | 5            | 4,010                       | 1,940                  |
| 6              | 3/16        | .315<br>.295 | .325  | .1895<br>.1890 | .1840<br>.1810 | .025  | .055<br>.045 | .016  | .025<br>.015 | 1/32" x 37°   | 10-32UNJF-3A Modified   | .0806<br>.0791 | .135<br>.115 | .119<br>.104 | 5,380                       | 2,500                  |
| 8              | 1/4         | .412<br>.387 | .395  | .2495<br>.2490 | .2440<br>.2410 | .030  | .069<br>.059 | .021  | .025<br>.015 | 1/32" x 37°   | 1/4-28UNJF-3A Modified  | .0967<br>.0947 | .150<br>.130 | .142<br>.122 | 9,300                       | 4,300                  |
| 10             | 5/16        | .505<br>.475 | .500  | .3120<br>.3115 | .3060<br>.3020 | .035  | .078<br>.068 | .026  | .030<br>.020 | 3/64" x 37°   | 5/16-24UNJF-3A Modified | .1295<br>.1270 | .170<br>.150 | .180<br>.160 | 14,600                      | 6,300                  |
| 12             | 3/8         | .600<br>.565 | .545  | .3745<br>.3740 | .3680<br>.3640 | .040  | .088<br>.078 | .030  | .030<br>.020 | 3/64" x 37°   | 3/8-24UNJF-3A Modified  | .1617<br>.1582 | .200<br>.180 | .217<br>.197 | 21,000                      | 8,700                  |
| 14             | 7/16        | .676<br>.641 | .635  | .4370<br>.4365 | .4310<br>.4260 | .045  | .105<br>.093 | .035  | .030<br>.020 | 3/64" x 37°   | 7/16-20UNJF-3A Modified | .1930<br>.1895 | .230<br>.210 | .253<br>.233 | 28,600                      | 12,100                 |
| 16             | 1/2         | .770<br>.735 | .685  | .4995<br>.4990 | .4930<br>.4880 | .050  | .115<br>.103 | .039  | .030<br>.020 | 3/64" x 37°   | 1/2-20UNJF-3A Modified  | .2242<br>.2207 | .260<br>.240 | .289<br>.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.

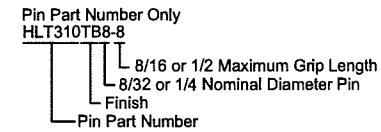
**HEAT TREAT:** 95,000 psi shear minimum.

- 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 | <b>HI-LOK® HI-TIGUE® PIN</b> |
| APPROVED |  | DATE     | PROTRUDING SHEAR HEAD        |
| JGW/lcox |  | 11-12-76 | TITANIUM                     |
| REVISION |  | DATE     | 1/16" GRIP VARIATION         |
| 7        |  | 12-11-12 | DRAWING NUMBER               |
|          |  |          | <b>HLT310</b>                |