

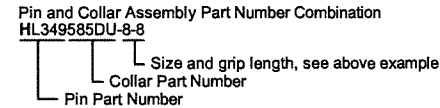
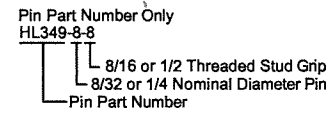
SEE COLLAR STANDARDS
 FOR COLLAR STRENGTHS.
 LOWER STRENGTH (PIN OR
 COLLAR) DETERMINES
 SYSTEM STRENGTH.

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	E REF	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING	WITH COATING									W HEX	T DEPTH	Y DIA		
5	5/32	.3393 .3308	.395	.1635 .1630	.1635 .1625	.1595 .1570	.125	.004	.0410 .0390	.025 .015	.012	1/32" x 37°	8-32UNJC-3A Modified	.0645 .0635	.100 .080	.090 .075	4,010	1,650
6	3/16	.3911 .3825	.410	.1895 .1890	.1895 .1885	.1840 .1810	.130	.005	.0470 .0450	.030 .020	.015	1/32" x 37°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	5,380	2,000
8	1/4	.5111 .5026	.495	.2495 .2490	.2495 .2485	.2440 .2410	.140	.006	.0610 .0590	.030 .020	.015	1/32" x 37°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	9,300	3,700
10	5/16	.6037 .5951	.560	.3120 .3115	.3120 .3110	.3060 .3020	.160	.007	.0680 .0660	.040 .030	.015	3/64" x 37°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	14,600	5,000
12	3/8	.7090 .7005	.625	.3745 .3740	.3745 .3735	.3680 .3640	.170	.008	.0780 .0760	.040 .030	.015	3/64" x 37°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	21,000	7,200

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .005 FIM.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions to be met after finish.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - Curved or flat edge manufacturer's option.
 - Use HL549 for oversize replacement.

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:



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

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

- FINISH:**
- HL349-(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL349VF(-)(-) = Surface coating per Hi-Shear Spec. 306, Type I, color blue, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL349AP(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

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

"Hi-Lok" and "HL" are internationally registered trademark of Hi-Shear Corporation.			
DRAWN DATE		TITLE	
D.P.S.	7-15-87	HI-LOK® PIN	
APPROVED DATE		130° FLUSH CROWN SHEAR HEAD TITANIUM 1/16" GRIP VARIATION (MECHANICAL LOCK APPLICATION)	
Wilcox	7-28-87		
REVISION DATE		DRAWING NUMBER	
3	3-29-10	HL349	
		SHEET 1 OF 1	

HL349