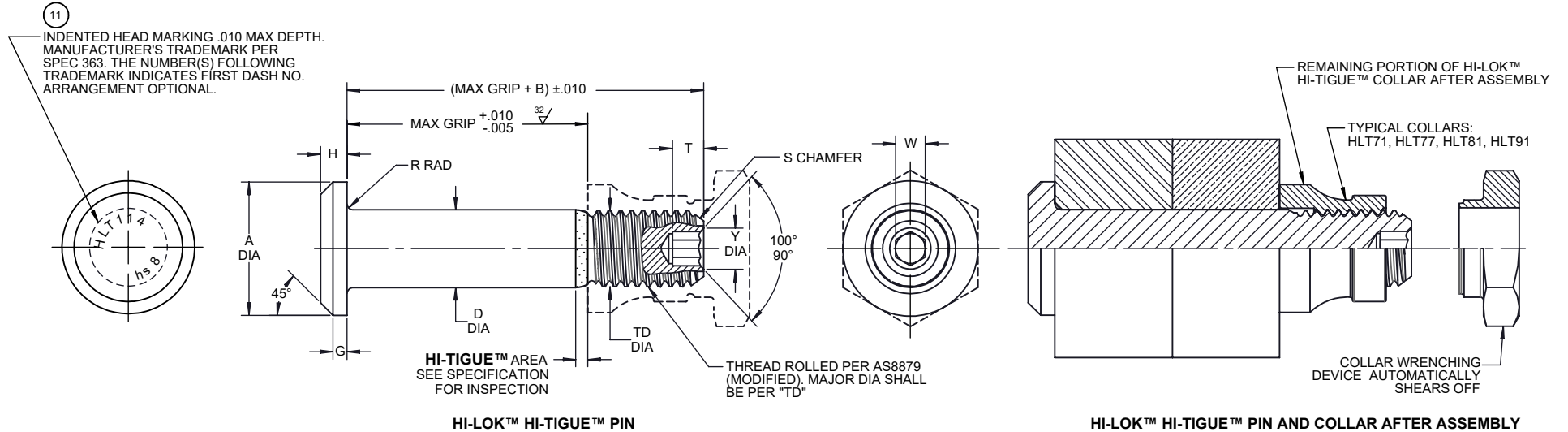




11

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS	TENSION POUNDS MINIMUM
											W HEX	T DEPTH	Y DIA		
5	5/32	.262 .242	.312	.1635 .1625	.1595 .1570	.020	.047 .037	.025 .015	1/32 x 45°	.1640-32 UNJF-3A	.0801 .0791	.100 .080	5	5,250 4,560	2,200
6	3/16	.315 .295	.325	.1895 .1885	.1840 .1810	.025	.055 .045	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	7,050 6,125	2,900
8	1/4	.412 .387	.395	.2495 .2485	.2440 .2410	.030	.069 .059	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	12,220 10,600	5,100
10	5/16	.505 .475	.500	.3120 .3110	.3060 .3020	.035	.078 .068	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	19,110 16,600	7,100
12	3/8	.600 .565	.545	.3745 .3735	.3680 .3640	.040	.088 .078	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	27,540 23,900	9,800

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

"HI-LOK", "HI-TIGUE", AND "HI-KOTE",
 ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY D.P.S.	DATE 1977-02-15	TITLE HI-LOK™ HI-TIGUE™ PIN PROTRUDING SHEAR HEAD ALLOY STEEL 1/16 GRIP VARIATION
APPROVED R.TING	DATE 1977-02-15	
REVISION 11	DATE K.MURKER 2019-11-12	DRAWING NUMBER HLT114

GENERAL NOTES: 1. Concentricity: "A" to "D" diameter within .010 FIR.
 2. Dimensions are in inches and to be met after plating.
 3. Surface texture per ASME B46.1.
 4. Hole preparation per NAS618.
 5 Evidence of broken edge across points.
 6. Use HLT122 for oversize replacement.

MATERIAL: Alloy steel per Spec. AMS6415, AMS6382, AMS6349 or AMS6322.

⑪ **HEAT TREAT:** 108,000 - 125,000 psi shear (180,000 psi tensile minimum) per AMS-H-6875.

FINISH: HLT114-()-() = Cadmium plate per Spec. AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT114BJ()-() = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT114TB()-() = Cadmium plate per AMS-QQ-P-416, Type III, Class 2, 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 352.

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:**

Pin Part Number
 HLT114TB8-8
 └── 8/16 or 1/2 Maximum Grip Length
 └── 8/32 or 1/4 Nominal Diameter Pin
 └── Finish Code
 └── Pin Basic Part Number

⑪

HLT114

DRAWING NUMBER

HLT114

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