lisi AEROSPACE
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR Corporation, USA
a LISI AEROSPACE Company

Design Holder

CAGE No. 73197

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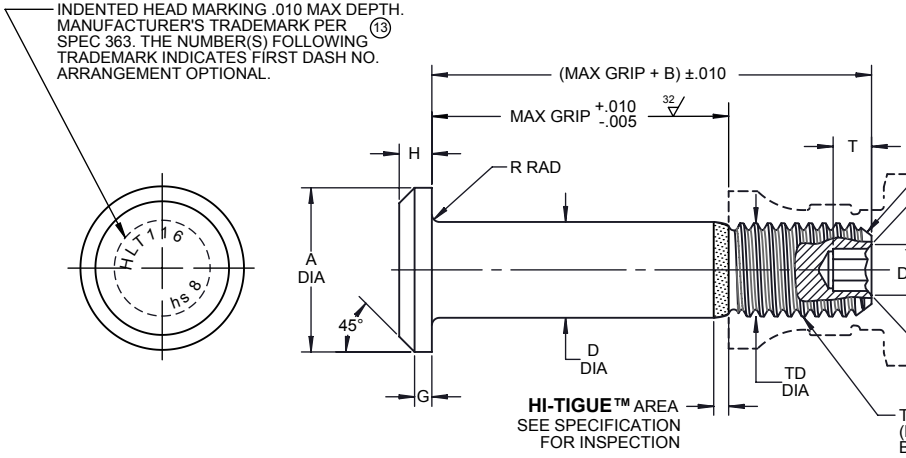
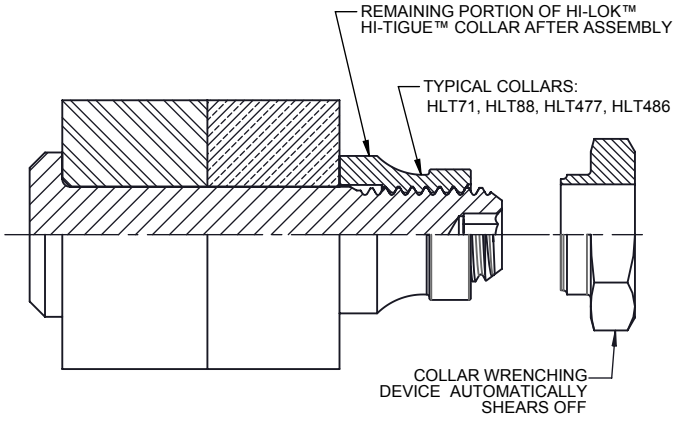


HI-LOK™ HI-TIGUE™ PIN



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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 **W** HEX	SOCKET **T** DEPTH	SOCKET **Y** DIA	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS
5	5/32	.262 .242	.312	.1635 .1625	.1595 .1570	.040	.065 .055	.025 .015	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.100 .080	5	4,560	3,570 2,450
6	3/16	.315 .295	.325	.1895 .1885	.1840 .1810	.045	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	6,125	4,980 3,850
8	1/4	.412 .387	.395	.2495 .2485	.2440 .2410	.055	.090 .080	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	10,600	8,890 6,550
10	5/16	.505 .475	.500	.3120 .3110	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	16,600	14,080 10,350
12	3/8	.600 .565	.545	.3745 .3735	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	23,900	20,930 15,750
14	7/16	.676 .641	.635	.4370 .4360	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	32,500	28,340 21,200
16	1/2	.770 .735	.685	.4995 .4985	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	42,400	37,780 28,800
18	9/16	.864 .829	.770	.5615 .5605	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	53,700	47,880 36,400
20	5/8	.953 .918	.825	.6240 .6230	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	66,300	59,930 46,100

(13)

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

DRAWN BY D.P.S. — DATE 1977-02-15	TITLE: HI-LOK™ HI-TIGUE™ PIN PROTRUDING SPECIAL HEAD ALLOY STEEL 1/16 GRIP VARIATION
APPROVED R.TING — DATE 1977-02-15	
REVISION (13) — DATE F.CARINGELLA 2019-11-05	DRAWING NUMBER: HLT116 — 1 OF 2

HLT116

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GENERAL NOTES:
1. Concentricity: "A" to "D" diameter within .010 FIM.
2. Dimensions are in inches and to be met after finish.
3. Surface texture per ASME B46.1.
4. Hole preparation per NAS618.
5. Evidence of broken edge across points.
6. Use HLT124 for oversize replacement.

MATERIAL: Alloy steel per AMS6415, AMS6349 or AMS6322, AMS6327.

HEAT TREAT: 180,000-215,000 psi tensile per AMS-H-6875.

FINISH:
HLT116-( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT116BJ( )-( ) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT116TB( )-( ) = 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
HLT116TB8-8
- 8/16 or 1/2 Maximum Grip Length
- 8/32 or 1/4 Nominal Diameter Pin
- Finish Code
- Pin Basic Part Number

HLT116

DRAWING NUMBER
HLT116