



HI-LOK™ HI-TIGUE™ PIN

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

③							①		⑦		⑨						
FIRST DASH NO.	PIN NOM DIA	A DIA	A+ DIA A' DIA	B REF	D DIA	TD DIA	F	H	R RAD	Z	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS	TENSION POUNDS MINIMUM
													W HEX	T DEPTH	Y DIA		
5							NOTE: USE HLT115-6										
6	7/32	.3303 .3253	.295	.360	.2182 .2172	.1840 .1810	.005	.0470 .0449	.030 .020	.015 .005	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	9,350 8,070	2,600
8	9/32	.4260 .4210	.391	.435	.2807 .2797	.2440 .2410	.006	.0610 .0589	.030 .020	.015 .005	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	15,470 13,400	4,600
10	11/32	.5051 .5001	.470	.545	.3432 .3422	.3060 .3020	.007	.0679 .0658	.040 .030	.015 .005	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	23,130 20,000	7,000
12	13/32	.5916 .5866	.556	.590	.4057 .4047	.3680 .3640	.008	.0780 .0759	.040 .030	.015 .005	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	33,320 28,000	10,000
14	15/32	.6992 .6932	.647	.690	.4682 .4672	.4310 .4260	.009	.0969 .0944	.050 .040	.022 .005	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	43,040 37,200	14,000
16	17/32	.7852 .7792	.733	.740	.5307 .5297	.4930 .4880	.010	.1068 .1043	.050 .040	.022 .005	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	55,300 47,700	17,800

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

- GENERAL NOTES:**
- 1 Head edge out of roundness shall not exceed "F".
  - 2 Concentricity: Conical surface of head to "D" diameter within .005 FIR.
  - 3 Head is dimensioned from maximum "D" diameter.
  - 4 Dimensions are in inches and to be met after plating.
  - 5 Surface texture per ASME B46.1.
  - 6 Hole preparation per NAS618.
  - 7 Curved or flat edge manufacturer's option.

**MATERIAL:** ⑨ Alloy steel per AMS6415, AMS6349, AMS6382, AMS6322, AMS6325, AMS6327.

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

**FINISH:** ⑨ HLT127-( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.  
⑨ HLT127TB( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, 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. of the pin which HLT127 oversize pin replaces.  
Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

**HOW TO ORDER**

⑨ **EXAMPLE:** Pin Part Number  
HLT127TB 8-8

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

Pin and Collar Assembly Part Number Combination  
HLT127277 8-8

Size and Grip Length,  
See Above Example  
Collar Part Number  
Pin Part Number

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

DRAWN BY D.P.S.	DATE 1977-03-09	TITLE HI-LOK™ HI-TIGUE™ PIN 100° FLUSH CROWN SHEAR HEAD ALLOY STEEL 1/16 GRIP VARIATION, 1/32 OVERSIZE
APPROVED R. TING	DATE 1977-03-09	
REVISION 9	DATE KEVIN TRAN 2017-07-05	DRAWING NUMBER <b>HLT127</b>