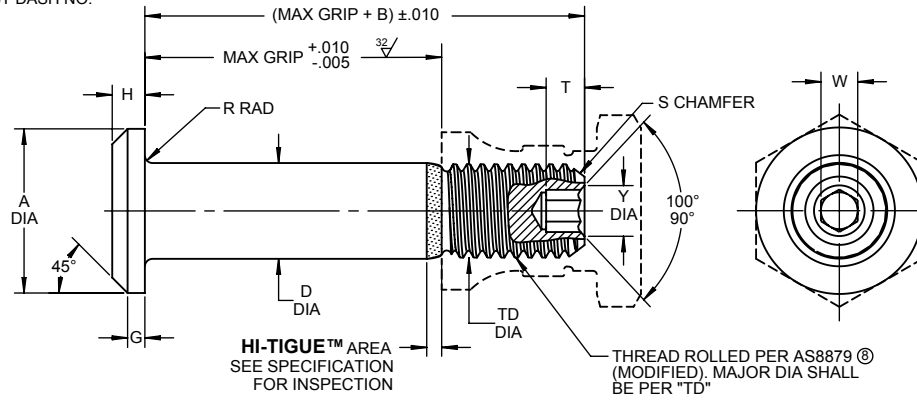
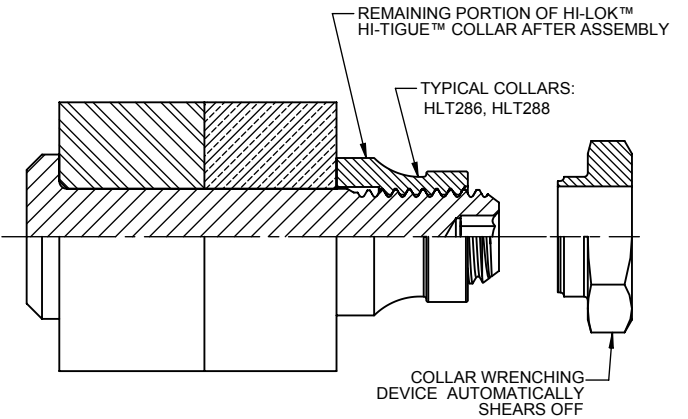


INDENTED HEAD MARKING .010 MAX DEPTH. MANUFACTURER'S TRADEMARK "hs" PER SPEC 363. THE NUMBER(S) FOLLOWING TRADEMARK INDICATES FIRST DASH NO. ARRANGEMENT OPTIONAL.



HI-LOK™ HI-TIGUE™ PIN



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

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

⑧

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 MINIMUM	TENSION POUNDS
											W HEX	T DEPTH	Y DIA		
6	7/32	.390 .370	.360	.2182 .2172	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	8,070	4,980 3,850
8	9/32	.460 .435	.435	.2807 .2797	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	13,400	8,890 6,550
10	11/32	.520 .490	.545	.3432 .3422	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	20,000	14,080 10,350
12	13/32	.620 .585	.590	.4057 .4047	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	28,000	20,930 15,750
14	15/32	.695 .660	.690	.4682 .4672	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	37,200	28,340 21,200
16	17/32	.790 .755	.740	.5307 .5297	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	47,700	37,780 28,800
18	19/32	.905 .870	.825	.5927 .5917	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	59,600	47,880 36,400
20	21/32	.975 .940	.890	.6552 .6542	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	72,900	59,930 46,100

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

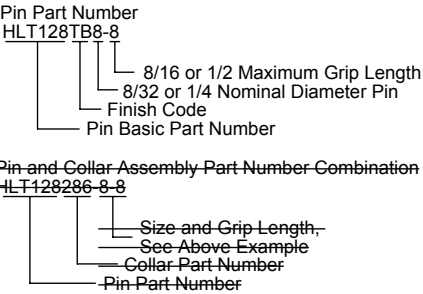
DRAWN BY D.P.S.	DATE 1977-03-09	TITLE HI-LOK™ HI-TIGUE™ PIN PROTRUDING TENSION HEAD ALLOY STEEL 1/16 GRIP VARIATION, 1/32 OVERSIZE
APPROVED R.TING	DATE 1977-03-09	
REVISION ⑧	DATE M.BEARD 2017-06-13	DRAWING NUMBER HLT128

- GENERAL NOTES:**
- 1. Concentricity: "A" to "D" diameter within .010 FIM.
 - ⑧ 2. Dimensions are in inches and to be met after finish.
 - ⑧ 3. Surface texture per ASME B46.1.
 - 4. Hole preparation per NAS618.
 - 5. Oversize pin for HLT116 and HLT124.
- MATERIAL:** Alloy steel per AMS6415, MIL-S-5626 or AMS-S-6049.
- HEAT TREAT:** 180,000 - 215,000 psi tensile per AMS-H-6875.
- FINISH:**
- HLT128-()-() = Cadmium plate per AMS-QQ-P-416 Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT128BJ()-() = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT128TB()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ⑧ HLT128HK()-() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

SPECIFICATION: HI-LOK™ HI-TIGUE™ Product Specification 352.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HLT128 oversize pin replaces..
 Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER
 ⑧ **EXAMPLE:**



HLT128