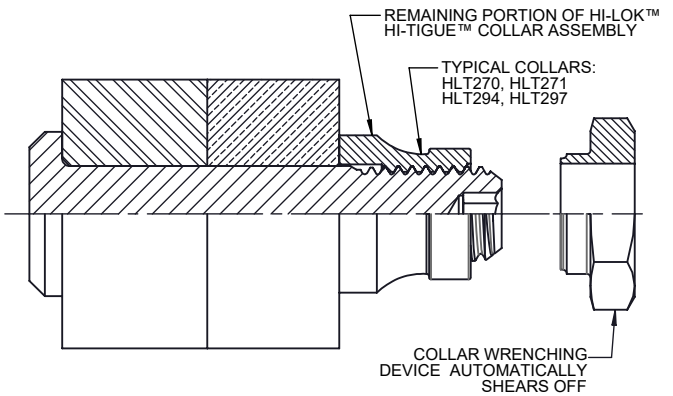
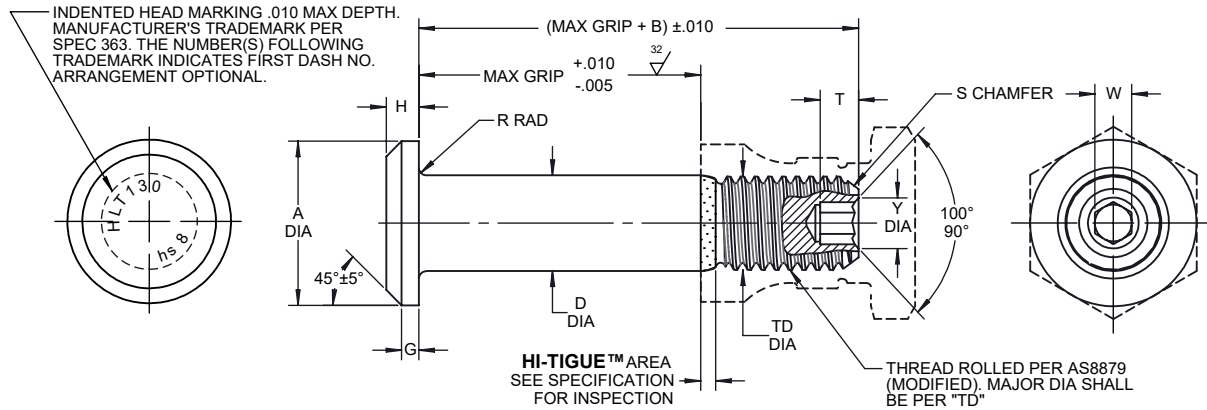




HI-LOK™ HI-TIGUE™ PIN AND COLLAR AFTER ASSEMBLY

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

**HOW TO ORDER
EXAMPLE:**

Pin Part Number
HLT130TB8-8
└─ 8/16 or 1/2 Maximum Grip Length
└─ Replaces 8/32 or 1/4 Nominal Diameter Pin
└─ Finish Code
└─ Pin Basic Part Number
Pin and Collar Assembly Part Number Combination
HLT130270-8-8
└─ Size and Grip Length, See Above Example
└─ Collar Part Number
└─ Pin Part Number

[5] HI-LOK™ HI-TIGUE™ PIN														SOCKET		DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	W HEX	T DEPTH	Y DIA				
5			NOTE: Use HLT30-6														
6	13/64	.315 .295	.360	.2026 .2021	.1840 .1810	.025	.055 .045	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	8,100	3,000		
8	17/64	.412 .387	.435	.2651 .2646	.2440 .2410	.030	.069 .059	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	13,800	5,100		
10	21/64	.505 .475	.545	.3276 .3271	.3060 .3020	.035	.078 .068	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	21,100	8,000		
12	25/64	.600 .565	.590	.3901 .3896	.3680 .3640	.040	.088 .078	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	30,000	11,300		
14	29/64	.676 .641	.690	.4526 .4521	.4310 .4260	.045	.105 .093	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	40,300	15,500		
16	33/64	.770 .735	.740	.5151 .5146	.4930 .4880	.050	.115 .103	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	52,200	20,000		
18	37/64	.864 .829	.825	.5771 .5766	.5550 .5500	.055	.127 .112	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	65,400	25,000		
20	41/64	.953 .918	.890	.6396 .6391	.6180 .6120	.060	.137 .122	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	80,300	30,200		

GENERAL NOTES:

- Concentricity: "A" to "D" diameter within .010 FIR.
- Dimensions apply after plating coating or surface finishing, but before lubricant.
- Surface texture per ASME B46.1.
- Use HLT230 for oversize replacement.
- Maximum "D" diameter may be increased by .0004 to allow for solid film application.

CODE: First dash number indicates nominal diameter in 1/32nds which HLT130 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See "Finish" note for explanation of code letters.

MATERIAL: TYPE 431 Stainless Steel per AMS5628 or MIL-S-18732.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: HLT130-()-() = Passivate per AMS2700, Method 1, Type 8, Class 1, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT130LP()-() = Solid film lube per AS5272, Type II (Kalgard RA, 400 Deg Bake) and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT130TB()-() = Ti-Shield III, Hi-Kote 2 Solid Film Lube per HS292 and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LOK™ HI-TIGUE™ Product Specification 342.

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

DRAWN BY VAN	DATE 1972-03-14	TITLE HI-LOK™ HI-TIGUE™ PIN PROTRUDING SHEAR HEAD TYPE 431 STAINLESS STEEL 1/16 GRIP VARIATION, 1/64 OVERSIZE	
APPROVED JGWILCOX	DATE 1972-03-21		
REVISION 2	DATE D. PEÑA 2021-02-04	DRAWING NUMBER HLT130	