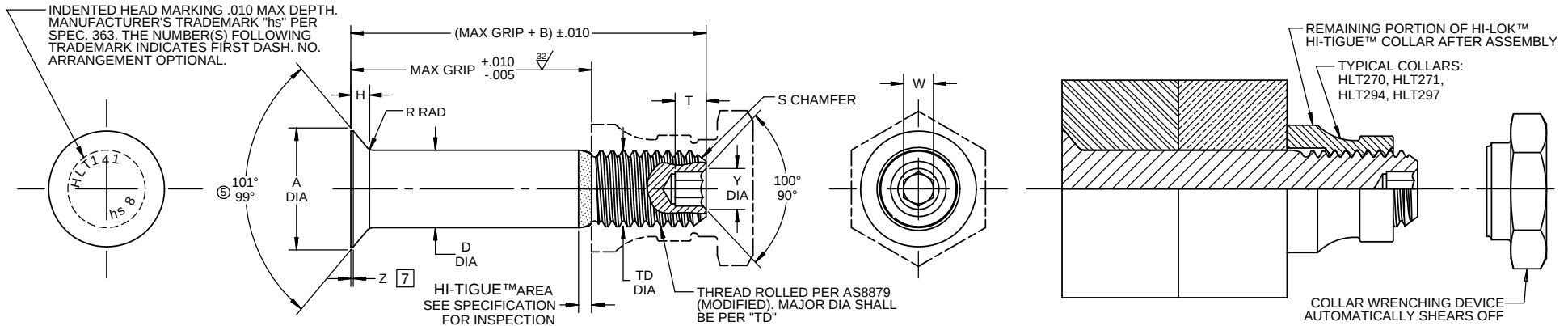




HI-LOK™ HI-TIGUE™ PIN

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

				1				7		⑤									
FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM		
				WITHOUT COATING PLATING OR S.F.L.	AFTER COATING PLATING OR S.F.L.								W HEX	T DEPTH	Y DIA				
5						NOTE: USE HLT41-6(-)(-)													
6	13/64	.3016 .2966	.360	.2026 .2021	.2026 .2016	.1840 .1810	.005	.0415 .0394	.030 .020	.010	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	6,130	2,000		
8	17/64	.3948 .3898	.435	.2651 .2646	.2651 .2641	.2440 .2410	.006	.0544 .0523	.030 .020	.010	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	10,490	3,700		
10	21/64	.4739 .4689	.545	.3276 .3271	.3276 .3266	.3060 .3020	.007	.0614 .0593	.040 .030	.010	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	16,000	5,000		
12	25/64	.5604 .5554	.590	.3901 .3896	.3901 .3891	.3680 .3640	.008	.0714 .0693	.040 .030	.010	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	22,700	7,200		
14	29/64	.6680 .6620	.690	.4526 .4521	.4526 .4516	.4310 .4260	.009	.0904 .0879	.050 .040	.015	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	30,600	10,000		
16	33/64	.7540 .7480	.740	.5151 .5146	.5151 .5141	.4930 .4880	.010	.1002 .0977	.050 .040	.015	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	39,600	13,500		
18	37/64	.8380 .8310	.825	.5771 .5766	.5771 .5761	.5550 .5500	.010	.1094 .1065	.050 .040	.015	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	49,700	17,000		

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 FIM.
 - 3 "H" is dimensioned from maximum "D" diameter.
 - 4 Surface texture per ASME B46.1.
 - 5 Hole preparation per NAS618.
 - 6 Dimensions in inches and to be met after finish.
 - 7 Curved or flat edge manufacturer's option.
 - 8 Use HLT241 for oversize replacement.

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

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HLT141 oversize pin replaces.. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER

EXAMPLE: Pin Part Number
HLT141TB8-8
8/16 or 1/2 Maximum Grip Length
8/32 or 1/4 Nominal Diameter Pin
Finish Code
Pin Basic Part Number

MATERIAL: A-286 high temperature alloy per AMS5731 or AMS5737.

HEAT TREAT: 95,000 psi shear minimum at 70°F.

- FINISH:** HLT141(-)(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT141PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT141TB(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT141TC(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec.292, except top surface of head shall be uncoated, and cetyl alcohol lube per Hi-Shear Spec. 305.
5 HLT141HK(-)(-) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

"HI-LOK", "HI-TIGUE", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY VAN	DATE 1972-06-10	TITLE HI-LOK™ HI-TIGUE™ PIN 100° FLUSH SHEAR HEAD A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION, 1/64 OVERSIZE	
APPROVED J.WILCOX	DATE 1972-06-15	DRAWING NUMBER HLT141	
REVISION 5	DATE M.BEARD 2017-05-18	1 OF 1	