



HI-LOK™ HI-TIGUE™ PIN

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

| FIRST<br>DASH<br>NO. | PIN<br>NOM<br>DIA | A<br>DIA       | B<br>REF | D<br>DIA       | TD<br>DIA      | F                        | G            | H              | K<br>REF | R<br>RAD     | Z<br>MAX | S<br>CHAMFER<br>REF | THREAD<br>MODIFIED  | SOCKET         |              |              | DOUBLE<br>SHEAR<br>POUNDS<br>MINIMUM | TENSION<br>POUNDS<br>MINIMUM |
|----------------------|-------------------|----------------|----------|----------------|----------------|--------------------------|--------------|----------------|----------|--------------|----------|---------------------|---------------------|----------------|--------------|--------------|--------------------------------------|------------------------------|
|                      |                   |                |          |                |                |                          |              |                |          |              |          |                     |                     | W<br>HEX       | T<br>DEPTH   | Y<br>DIA     |                                      |                              |
| 5                    |                   |                |          |                |                | NOTE: USE HLT51( )J6-( ) |              |                |          |              |          |                     |                     |                |              |              |                                      |                              |
| 6                    | 13/64             | .3016<br>.2966 | .360     | .2026<br>.2021 | .1840<br>.1810 | .005                     | .015<br>.010 | .0415<br>.0394 | .016     | .030<br>.020 | .015     | 1/32 x 45°          | .1900-32<br>UNJF-3A | .0806<br>.0791 | .135<br>.115 | .119<br>.104 | 8,100                                | 2,600                        |
| 8                    | 17/64             | .3948<br>.3898 | .435     | .2651<br>.2646 | .2440<br>.2410 | .006                     | .015<br>.010 | .0544<br>.0523 | .021     | .030<br>.020 | .015     | 1/32 x 45°          | .2500-28<br>UNJF-3A | .0967<br>.0947 | .150<br>.130 | .142<br>.122 | 13,800                               | 4,400                        |
| 10                   | 21/64             | .4739<br>.4689 | .545     | .3276<br>.3271 | .3060<br>.3020 | .007                     | .015<br>.010 | .0614<br>.0593 | .026     | .040<br>.030 | .015     | 3/64 x 45°          | .3125-24<br>UNJF-3A | .1295<br>.1270 | .170<br>.150 | .180<br>.160 | 21,100                               | 7,000                        |
| 12                   | 25/64             | .5604<br>.5554 | .590     | .3901<br>.3896 | .3680<br>.3640 | .008                     | .015<br>.010 | .0714<br>.0693 | .030     | .040<br>.030 | .015     | 3/64 x 45°          | .3750-24<br>UNJF-3A | .1617<br>.1582 | .200<br>.180 | .217<br>.197 | 30,000                               | 10,000                       |
| 14                   | 29/64             | .6680<br>.6620 | .690     | .4526<br>.4521 | .4310<br>.4260 | .009                     | .015<br>.010 | .0904<br>.0879 | .035     | .050<br>.040 | .022     | 3/64 x 45°          | .4375-20<br>UNJF-3A | .1930<br>.1895 | .230<br>.210 | .253<br>.233 | 40,300                               | 12,500                       |
| 16                   | 33/64             | .7540<br>.7480 | .740     | .5151<br>.5146 | .4930<br>.4880 | .010                     | .015<br>.010 | .1002<br>.0977 | .039     | .050<br>.040 | .022     | 3/64 x 45°          | .5000-20<br>UNJF-3A | .2242<br>.2207 | .260<br>.240 | .289<br>.269 | 52,200                               | 18,000                       |

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. Dimensions are in inches and to be met before finish.
  4. Surface texture per ASME B46.1.
  5. Hole preparation per NAS618.
  6. "H" is dimensioned from maximum "D" diameter.
  7. Curved or flat edge manufacturer's option.
  8. Use HLT251 for oversize replacement.

**CODE:** First dash number indicates nominal diameter in 1/32nds of the pin which HLT151 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  
HLT151TB8-8

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

**MATERIAL:** PH13-8Mo stainless steel per AMS5629.

**HEAT TREAT:** 125,000 psi shear minimum.

**FINISH:**

- HLT151( )-( ) = Passivate per Hi-Shear Spec. 262, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT151DL( )-( ) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT151TB( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT151YB( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, white paint on head, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT151YC( )-( ) = Solid film lube per AS5272, Type I, white paint on head, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT151HK( )-( ) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

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

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

|                    |                                    |                                                                                                                                 |
|--------------------|------------------------------------|---------------------------------------------------------------------------------------------------------------------------------|
| DRAWN BY<br>D.P.S. | DATE<br>1977-06-08                 | TITLE<br>HI-LOK™ HI-TIGUE™ PIN<br>100° FLUSH CROWN SHEAR HEAD<br>PH13-8Mo STAINLESS STEEL<br>1/16 GRIP VARIATION, 1/64 OVERSIZE |
| APPROVED<br>R.TING | DATE<br>1977-06-08                 |                                                                                                                                 |
| REVISION<br>9      | DATE<br>F.CARINGELLA<br>2017-04-04 | DRAWING NUMBER<br><b>HLT151</b>                                                                                                 |