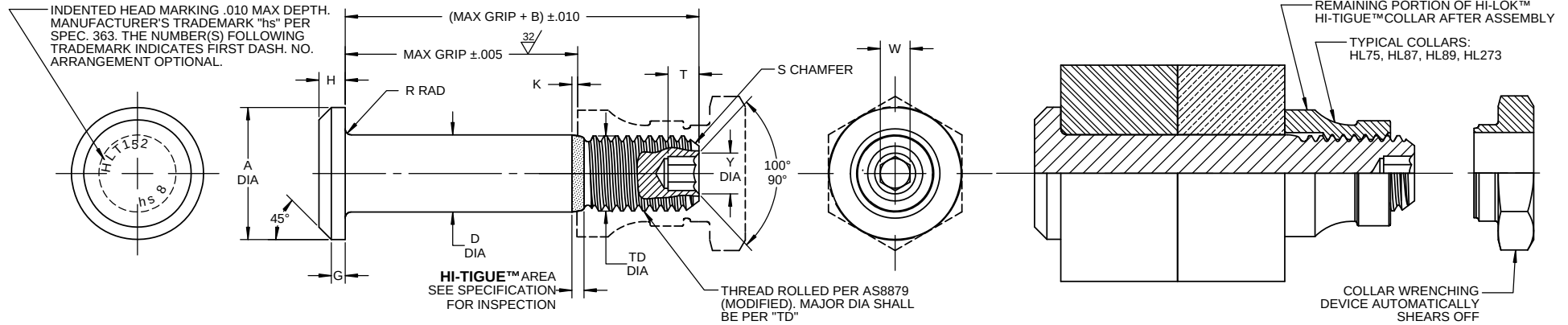


⑥

For the current list of licensed manufacturers, please visit the
 LISI AEROSPACE website at:
[HTTP://WWW.LISI-AEROSPACE.COM/LICENSES](http://www.lisi-aerospace.com/licenses)



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

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	H	K REF	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
												W HEX	T DEPTH	Y DIA		
5						NOTE: USE HLT52()6(-)										
6	13/64	.377 .357	.360	.2026 .2021	.1840 .1810	.035	.074 .064	.016	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	8,100	4,350
8	17/64	.440 .415	.435	.2651 .2646	.2440 .2410	.045	.090 .080	.021	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	13,800	7,750
10	21/64	.505 .475	.545	.3276 .3271	.3060 .3020	.055	.112 .102	.026	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	21,100	12,300
12	25/64	.600 .565	.590	.3901 .3896	.3680 .3640	.075	.140 .130	.030	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	30,000	19,100
14	29/64	.676 .641	.690	.4526 .4521	.4310 .4260	.095	.160 .150	.035	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	40,300	25,800
16	33/64	.770 .735	.740	.5151 .5146	.4930 .4880	.095	.188 .178	.039	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	52,200	34,300

GENERAL NOTES: 1. Concentricity: "A" to "D" diameter within .010 FIM.
 ② 2. Dimensions are in inches and to be met before finish.
 ③ 3. Surface texture per ASME B46.1.
 4. Hole preparation per NAS618.
 5. Use HLT252 for oversize replacement.

CODE: First dash number indicates nominal diameter in 1/32nds
 of the pin which HLT152 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

MATERIAL: PH13-8Mo stainless steel per AMS5629.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: HLT152(-)(-) = Passivate per Hi-Shear Spec. 262, and cetyl alcohol lube per
 Hi-Shear Spec. 305.
 HLT152DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per
 Hi-Shear Spec. 305.
 HLT152TB(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl
 alcohol lube per Hi-Shear Spec. 305.
 HLT152YB(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, white paint on
 head, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT152YC(-)(-) = Solid film lube per AS5272, Type I, white paint on head, and cetyl
 alcohol lube per Hi-Shear Spec. 305.
 ⑥ HLT152HK(-)(-) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

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

HOW TO ORDER

⑥ **EXAMPLE:**

Pin Part Number
 HLT152TB8-8

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

"HI-LOK", "HI-TIGUE", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY D.P.S.	DATE 1977-06-08	TITLE HI-LOK™ HI-TIGUE™ PIN PROTRUDING TENSION HEAD PH13-8Mo STAINLESS STEEL 1/16 GRIP VARIATION, 1/64 OVERSIZE	
APPROVED R.TING	DATE 1977-06-08	DRAWING NUMBER HLT152	
REVISION ⑥	DATE M.BEARD 2017-05-02	1 OF 1	