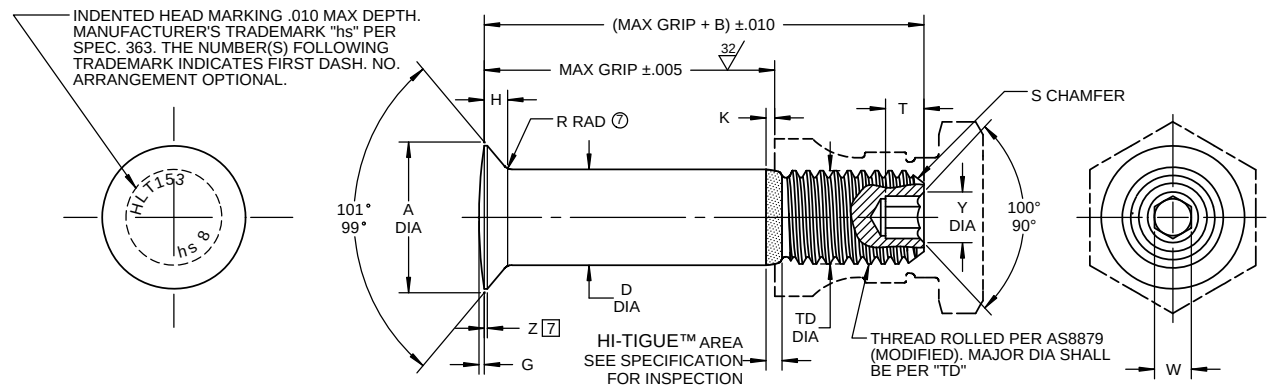
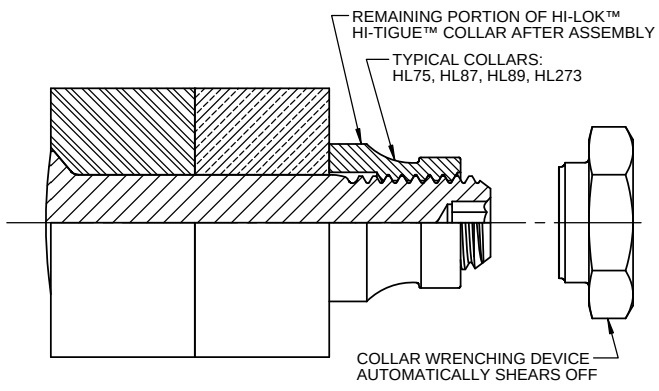
lisi AEROSPACE
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR Corporation, USA
a LISI AEROSPACE Company
Design Holder
CAGE No. 73197

⑦ For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at:
HTTP://WWW.LISI-AEROSPACE.COM/LICENSES



HI-LOK™ HI-TIGUE™ PIN



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

1

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	F	G	H	K REF	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET W HEX	SOCKET T DEPTH	SOCKET Y DIA	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
5						NOTE: USE HLT53( )6-( )												
6	13/64	.3813 .3765	.360	.2026 .2021	.1840 .1810	.005	.015 .010	.0750 .0730	.016	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	8,100	4,350
8	17/64	.5066 .5018	.435	.2651 .2646	.2440 .2410	.006	.015 .010	.1013 .0993	.021	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	13,800	7,750
10	21/64	.6335 .6287	.545	.3276 .3271	.3060 .3020	.007	.015 .010	.1283 .1263	.026	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	21,100	12,300
12	25/64	.7604 .7556	.590	.3901 .3896	.3680 .3640	.008	.015 .010	.1553 .1533	.030	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	30,000	19,100
14	29/64	.8884 .8812	.690	.4526 .4521	.4310 .4260	.009	.015 .010	.1828 .1798	.035	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	40,300	25,800
16	33/64	1.0139 1.0068	.740	.5151 .5146	.4930 .4880	.010	.015 .010	.2093 .2063	.039	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	52,200	34,300

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.
⑦ 3. Dimensions are in inches and to be met before finish.
⑦ 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 HLT253 for oversize replacement.

MATERIAL: ⑦ PH13-8Mo stainless steel per AMS5629.

HEAT TREAT: 125,000 psi shear minimum.

FINISH:
HLT153-( )-( ) = Passivate per Hi-Shear Spec. 262, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT153DL( )-( ) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT153TB( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT153YB( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, white paint on head, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT153YC( )-( ) = Solid film lube per AS5272, Type I, white paint on head, and cetyl alcohol lube per Hi-Shear Spec. 305.
⑦ HLT153HK( )-( ) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

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

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HLT153 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER
⑦ **EXAMPLE:** Pin Part Number
HLT153TB8-8
- 8/16 or 1/2 Maximum Grip Length
- 8/32 or 1/4 Nominal Diameter Pin
- Finish Code
- Pin Basic Part Number

DRAWN BY	DATE	TITLE
D.P.S.	1977-06-08	HI-LOK™ HI-TIGUE™ PIN 100° FLUSH CROWN MS24694 TENSION HEAD PH13-8Mo STAINLESS STEEL 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED	DATE	
R.TING	1977-06-08	
REVISION	DATE	DRAWING NUMBER
⑦	M.BEARD 2017-05-02	HLT153 1 OF 1

HLT153