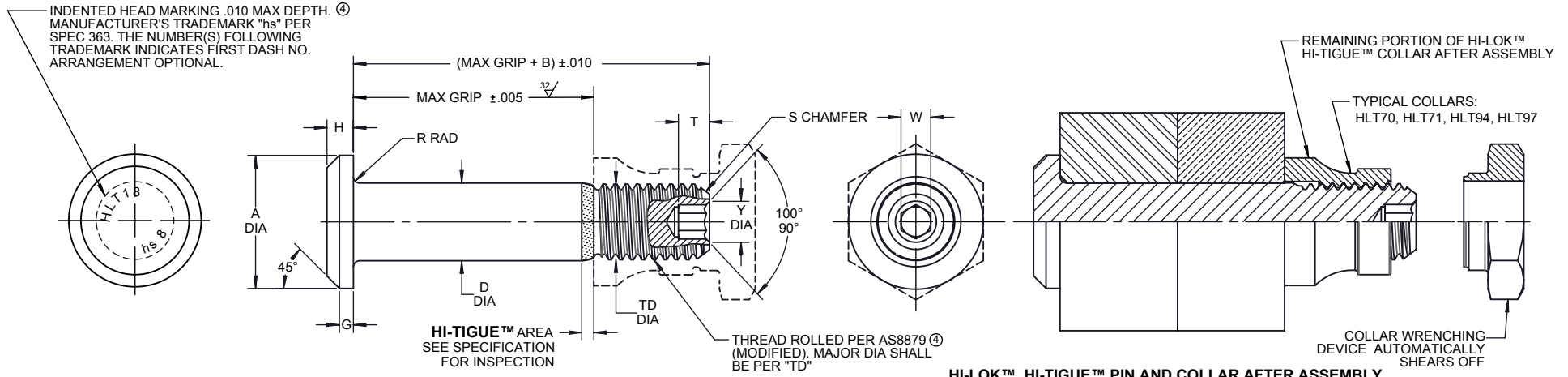




HI-LOK™ HI-TIGUE™ PIN

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

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G	H	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS	TENSION POUNDS MINIMUM	MIN. GRIP LENGTH
											W HEX	T DEPTH	Y DIA			
5	5/32	.262 .242	.312	.1695 .1685	.1595 .1570	.020	.047 .037	.025 .015	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.100 .080	.104 .094	4,210	1,940	2
6	3/16	.315 .295	.325	.1955 .1945	.1840 .1810	.025	.055 .045	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	5,550	2,500	2
8	1/4	.412 .387	.395	.2555 .2545	.2440 .2410	.030	.069 .059	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	9,620	4,300	2
10	5/16	.505 .475	.500	.3180 .3170	.3060 .3020	.035	.078 .068	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	14,890	6,300	2
12	3/8	.600 .565	.545	.3805 .3795	.3680 .3640	.040	.088 .078	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	21,430	8,700	3
14	7/16	.676 .641	.635	.4430 .4420	.4310 .4260	.045	.105 .093	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	29,000	12,100	4
16	1/2	.770 .735	.685	.5055 .5045	.4930 .4880	.050	.116 .103	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	37,900	15,300	4

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

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 2. Dimensions are in inches and to be met after plating.
 3. Surface texture per ASME B46.1.
 4. Hole preparation per NAS618 (Column B) for interference application.
 5. Use HLT118 for oversize replacement.
 6. Install per Hi-Shear Spec. 299.
 7. Minimum required for head HI-TIGUE™ feature.

MATERIAL: ④ Alloy steel per Spec. AMS6415, AMS6484, AMS6349, AMS6382 or AMS6322, AMS6325.

HEAT TREAT: ④ 95,000 psi shear minimum (160,000-180,000 psi tensile per Spec. AMS-H-687).

FINISH: ④ HLT18-()-() = Cadmium plate per Spec. AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

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

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

HOW TO ORDER

④ **EXAMPLE:** Pin Part Number HLT18-8-8

Pin and Collar Assembly Part Number Combination
 HLT1870-8-8
 Size and Grip length, See Above Example
 Collar Part Number
 Pin Part Number

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

DRAWN BY VAN	DATE 1968-10-04	TITLE HI-LOK™ HI-TIGUE™ PIN PROTRUDING SHEAR HEAD ALLOY STEEL 1/16 GRIP VARIATION	
APPROVED POLIVKA	DATE 1968-10-08	DRAWING NUMBER HLT18	
REVISION ④	DATE K. TRAN 2017-12-22	1 OF 1	