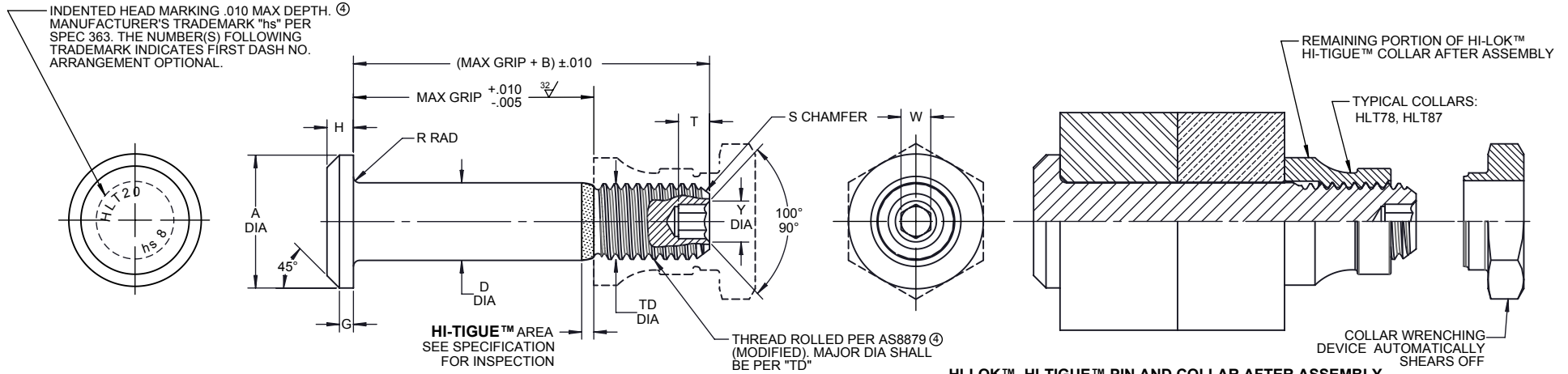




HI-LOK™ HI-TIGUE™ PIN

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

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	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	.322 .306	.312	.1695 .1685	.1595 .1570	.030	.065 .055	.025 .015	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.100 .080	.104 .094	4,210	2,180	2
6	3/16	.377 .357	.325	.1955 .1945	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	5,550	3,180	2
8	1/4	.440 .415	.395	.2555 .2545	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	9,620	5,820	2
10	5/16	.505 .475	.500	.3180 .3170	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	14,890	9,200	2
12	3/8	.600 .565	.545	.3805 .3795	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	21,430	14,000	3
14	7/16	.676 .641	.635	.4430 .4420	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	29,000	18,900	4
16	1/2	.770 .735	.685	.5055 .5045	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	37,900	25,600	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 FIR.
 2. Dimensions are in inches and to be met after finish.
 3. Surface texture per ASME B46.1.
 4. Use HLT120 for oversize replacement.
 5. Install per Hi-Shear Spec. 299.
 - 6 Minimum required for head and HI-TIGUE™ feature.

CODE: First dash number indicates nominal diameter in 1/32nds.
 Second dash number indicates maximum grip in 1/16ths.

HOW TO ORDER

EXAMPLE:

Pin Part Number
 HLT20-8-8

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

Pin and Collar Assembly Part Number Combination
 HLT2078-8-8

Size and Grip length,
 See Above Example
 Collar Part Number
 Pin Part Number

MATERIAL: ④ Alloy steel per Spec. AMS6415, AMS6484, AMS6349, AMS6382 or AMS6322, AMS6325, AMS6327.

HEAT TREAT: ④ 160,000-180,000 psi tensile per Spec. AMS-H-6875.

FINISH: ④ HLT20-() () = 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.

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

DRAWN BY VAN	DATE 1971-02-09	TITLE HI-LOK™ HI-TIGUE™ PIN PROTRUDING TENSION HEAD ALLOY STEEL 1/16 GRIP VARIATION	
APPROVED JG. WILCOX	DATE 1971-02-10	DRAWING NUMBER HLT20	
REVISION ④	DATE K. TRAN 2017-12-22	1 OF 1	