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

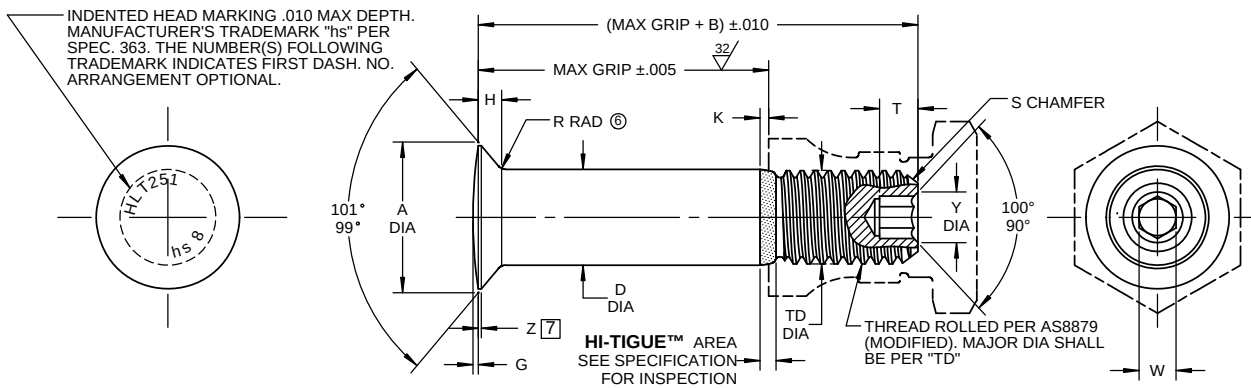
HI-SHEAR Corporation, USA
a LISI AEROSPACE Company

Design Holder

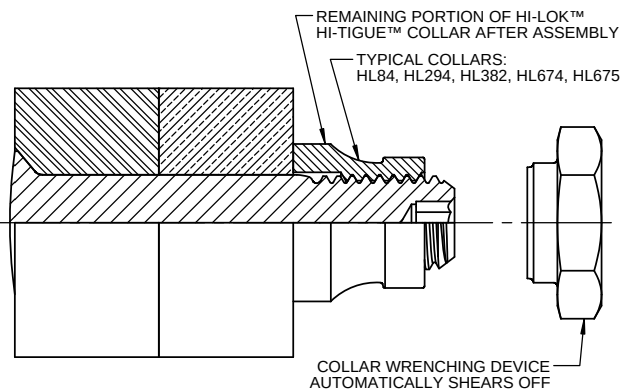
CAGE No. 73197

⑥

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 HLT151( )6-( )												
6	7/32	.3304 .3253	.360	.2182 .2177	.1840 .1810	.005	.015 .010	.0470 .0449	.016	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	9,400	2,600
8	9/32	.4260 .4210	.435	.2807 .2802	.2440 .2410	.006	.015 .010	.0610 .0589	.021	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	15,500	4,400
10	11/32	.5051 .5001	.545	.3432 .3427	.3060 .3020	.007	.015 .010	.0679 .0658	.026	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	23,200	7,000
12	13/32	.5916 .5866	.590	.4057 .4052	.3680 .3640	.008	.015 .010	.0780 .0759	.030	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	32,400	10,000
14	15/32	.6992 .6932	.690	.4682 .4677	.4310 .4260	.009	.015 .010	.0969 .0944	.035	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	43,100	12,500
16	17/32	.7852 .7792	.740	.5307 .5302	.4930 .4880	.010	.015 .010	.1068 .1043	.039	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	55,400	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.
⑥ 3. Dimensions are in inches and to be met before finish.
⑥ 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.

MATERIAL: ⑥ PH13-8Mo stainless steel per AMS5629.

HEAT TREAT: 125,000 psi shear minimum.

FINISH:
HLT251-( )-( ) = Passivate per Hi-Shear Spec. 262, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT251DL( )-( ) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT251TB( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT251YB( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, white paint on head, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT251YC( )-( ) = Solid film lube per AS5272, Type I, white paint on head, and cetyl alcohol lube per Hi-Shear Spec. 305.
⑥ HLT251HK( )-( ) = 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 HLT251 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER
⑥ **EXAMPLE:** Pin Part Number
HLT251TB8-8
- 8/16 or 1/2 Maximum Grip Length
- 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	DATE
D.P.S.	1977-06-08
APPROVED	DATE
R.TING	1977-06-08
REVISION	DATE
⑥	M.BEARD 2017-05-03

TITLE
HI-LOK™ HI-TIGUE™ PIN
100° FLUSH CROWN SHEAR HEAD
PH13-8Mo STAINLESS STEEL
1/16 GRIP VARIATION, 1/32 OVERSIZE

DRAWING NUMBER
HLT251

1 OF 1

HLT251

©2017 Hi-Shear Corporation