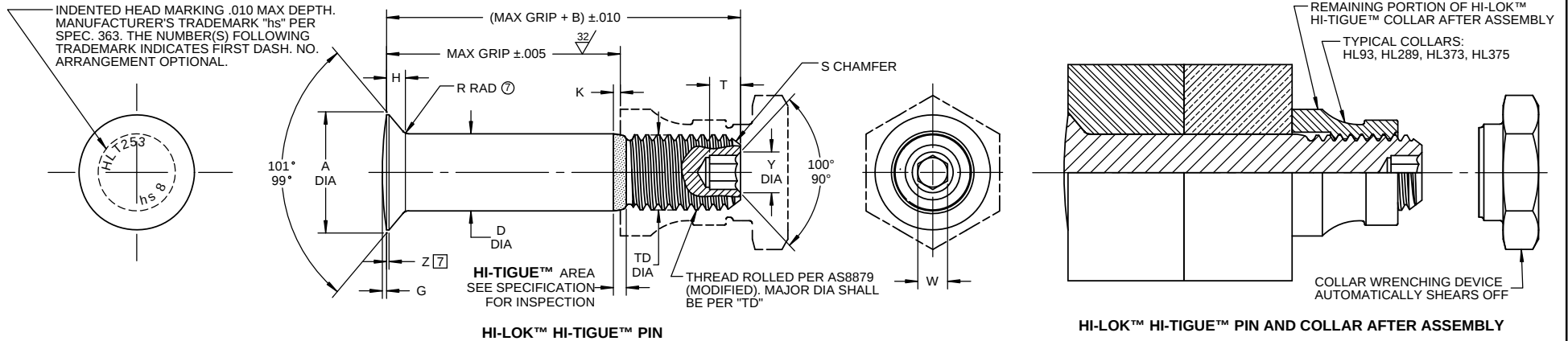


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①

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			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
														W HEX	T DEPTH	Y DIA		
5						NOTE: USE HLT153()6-()												
6	7/32	.3813 .3765	.360	.2182 .2177	.1840 .1810	.005	.015 .010	.0684 .0664	.016	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	9,400	4,350
8	9/32	.5066 .5018	.435	.2807 .2802	.2440 .2410	.006	.015 .010	.0948 .0928	.021	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	15,500	7,750
10	11/32	.6335 .6287	.545	.3432 .3427	.3060 .3020	.007	.015 .010	.1218 .1198	.026	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	23,200	12,300
12	13/32	.7604 .7556	.590	.4057 .4052	.3680 .3640	.008	.015 .010	.1488 .1468	.030	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	32,400	19,100
14	15/32	.8884 .8812	.690	.4682 .4677	.4310 .4260	.009	.015 .010	.1763 .1733	.035	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	43,100	25,800
16	17/32	1.0139 1.0068	.740	.5307 .5302	.4930 .4880	.010	.015 .010	.2027 .1997	.039	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	55,400	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.
③ 3. Dimensions are in inches and to be met before finish.
④ 4. Surface texture per ASME B46.1.
5. Hole preparation per NAS618.
6. "H" is dimensioned from maximum "D" diameter.
⑦ ⑦ Curved or flat edge manufacturer's option.

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

HEAT TREAT: 125,000 psi shear minimum.

FINISH: HLT253-()-() = Passivate per Hi-Shear Spec. 262, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT253DL()-() = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT253TB()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT253YB()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, white paint on head, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT253YC()-() = Solid film lube per AS5272, Type I, white paint on head, and cetyl alcohol lube per Hi-Shear Spec. 305.
⑦ HLT253HK()-() = 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 HLT253 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
HLT253TB8-8

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 D.P.S.	DATE 1977-06-08	TITLE HI-LOK™ HI-TIGUE™ PIN 100° FLUSH CROWN MS24694 TENSION HEAD PH13-8Mo STAINLESS STEEL 1/16 GRIP VARIATION, 1/32 OVERSIZE
APPROVED R.TING	DATE 1977-06-08	
REVISION ⑦	DATE M.BEARD 2017-05-03	DRAWING NUMBER HLT253

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