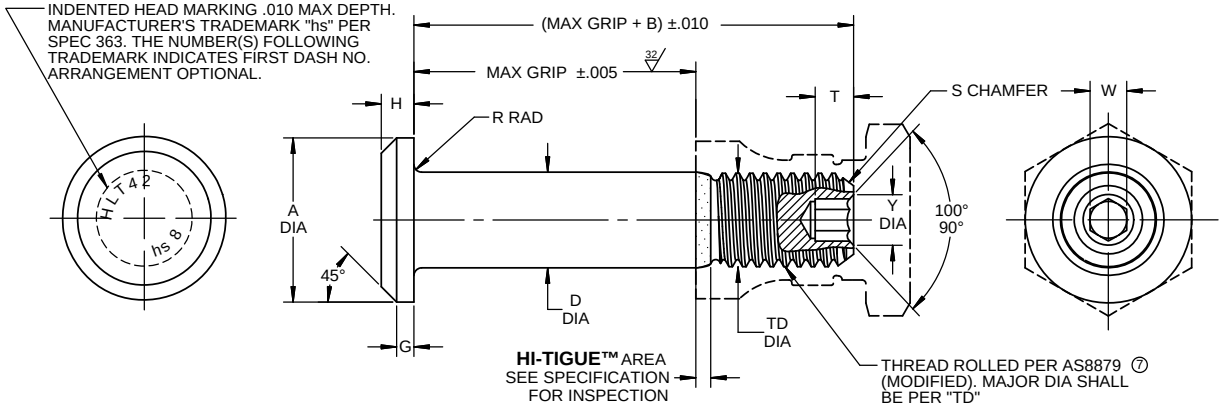
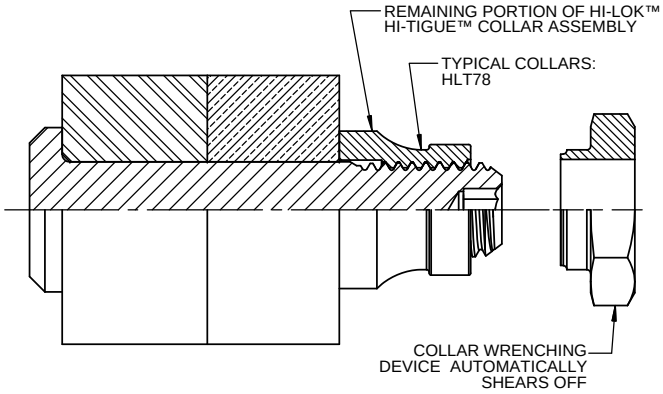
lisi AEROSPACE
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

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™ PIN AND COLLAR AFTER ASSEMBLY

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FIRST DASH NO.	PIN NOM DIA	**A** DIA	**B** REF	**D** DIA WITHOUT HI-KOTE™ LUBE	**D** DIA WITH HI-KOTE™ LUBE	**TD** DIA	**G** REF	**H**	**R** RAD	**S** CHAMFER REF	**THREAD** MODIFIED	SOCKET **W** HEX	SOCKET **T** DEPTH	SOCKET **Y** DIA	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
5	5/32	.322 .306	.312	.1640 .1635	.1640 .1630	.1595 .1570	.030	.060 .055	.025 .015	1/32 x 45°	.1640-32 UNJC-3A	.0645 .0635	.100 .080	.090 .075	4,010	2,180
6	3/16	.377 .357	.325	.1895 .1890	.1895 .1885	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	5,380	2,750
8	1/4	.440 .415	.395	.2495 .2490	.2495 .2485	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	9,300	5,000
10	5/16	.505 .475	.500	.3120 .3115	.3120 .3110	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	14,600	8,300
12	3/8	.600 .565	.545	.3745 .3740	.3745 .3735	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	21,000	12,700
14	7/16	.676 .641	.635	.4370 .4365	.4370 .4360	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	28,600	18,900
16	1/2	.770 .735	.685	.4995 .4990	.4995 .4985	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	37,300	25,500
18	9/16	.877 .842	.770	.5615 .5610	.5615 .5605	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	47,200	32,400

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

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

DRAWN BY	DATE	TITLE
VAN	1971-01-12	HI-LOK™ HI-TIGUE™ PIN PROTRUDING TENSION HEAD A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION
APPROVED JGWILCOX	DATE 1971-01-13	
REVISION ⑦	DATE M.BEARD 2017-07-10	DRAWING NUMBER **HLT42** 1 OF 2

HLT42

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GENERAL NOTES:
1. Concentricity: "A" to "D" diameter within .010 FIR.
⑦ 2. Surface texture per ASME B46.1.
3. Hole preparation per NAS618.
4. Use HLT142 for oversize replacement.
⑦ 5. Dimensions are in inches.

MATERIAL: A-286 high temperature alloy per AMS5731 or AMS5737.

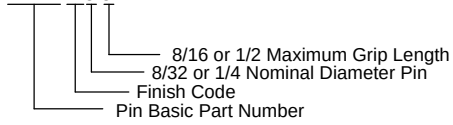
HEAT TREAT: 160,000 psi tension minimum (95,000 psi tensile minimum) at 70°F.

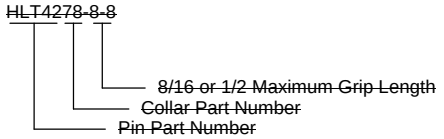
FINISH:
HLT42( )-( ) = Passivate per Hi-Shear Spec. 258, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT42TB( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
⑦ HLT42HK( )-( ) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

SPECIFICATION: HI-LOK™ HI-TIGUE™ Product Specification 342 and 342-2.

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
⑦ **EXAMPLE:** Pin Part Number





HLT42

DRAWING NUMBER
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