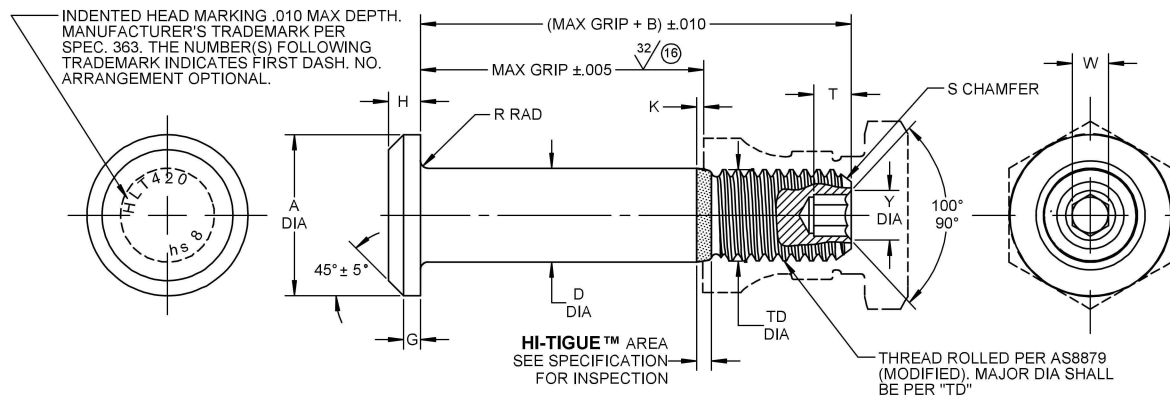
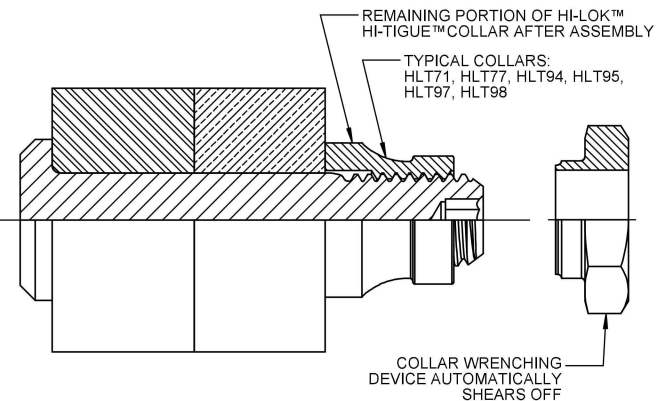


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HI-LOK™ HI-TIGUE™ PIN



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

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

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	G REF	H	K REF	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING, PLATING, OR SOLID FILM	AFTER COATING, PLATING, OR SOLID FILM								W HEX	T DEPTH	Y DIA		
5	5/32	.262 .242	.312	.1635 .1630	.1635 .1625	.1595 .1570	.020	.047 .037	.013	.025 .015	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.100 .080	5	5,280	2,200
6	3/16	.315 .295	.325	.1895 .1890	.1895 .1885	.1840 .1810	.025	.055 .045	.016	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	7,060	3,000
8	1/4	.412 .387	.395	.2495 .2490	.2495 .2485	.2440 .2410	.030	.069 .059	.021	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	12,260	5,100
10	5/16	.505 .475	.500	.3120 .3115	.3120 .3110	.3060 .3020	.035	.078 .068	.026	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	19,160	8,000
12	3/8	.600 .565	.545	.3745 .3740	.3745 .3735	.3680 .3640	.040	.088 .078	.030	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	27,600	11,300
14	7/16	.676 .641	.635	.4370 .4365	.4370 .4360	.4310 .4260	.045	.105 .093	.035	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	37,500	15,500
16	1/2	.770 .735	.685	.4995 .4990	.4995 .4985	.4930 .4880	.050	.115 .103	.039	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	49,100	20,000
18	9/16	.864 .829	.770	.5615 .5610	.5615 .5605	.5550 .5500	.055	.127 .112	.039	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	62,100	25,000
20	5/8	.953 .918	.825	.6240 .6235	.6240 .6230	.6180 .6120	.060	.137 .122	.044	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	76,700	30,200
24	3/4	1.108 1.066	1.050	.7490 .7485	.7490 .7480	.7430 .7370	.070	.151 .136	.044	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	110,400	40,200

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

DRAWN BY
J.F.OBISPO
D.P.S.

DATE
2014-08-11
1983-04-22

APPROVED
R.TING

DATE
1983-04-22

REVISION
16

DATE
K. PHAM
2022-3-3

TITLE
HI-LOK™ HI-TIGUE™ PIN
PROTRUDING SHEAR HEAD
NICKEL BASE ALLOY (INCONEL 718)
1/16 GRIP VARIATION

DRAWING NUMBER
HLT420

1 OF 2

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 2. Dimensions are in inches and to be met after finish.
 3. Surface texture per ASME B46.1.
 4. Hole preparation per NAS618.
 5. Evidence of broken edge across points.
 6. Use HLT620 for oversize replacement.
- ⑩ 7 After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in UK and European Union.

MATERIAL: Nickel base alloy per AMS5662.

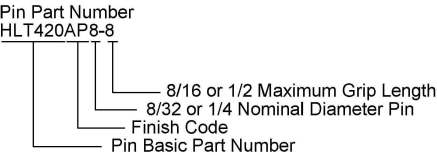
HEAT TREAT: 125,000 psi shear minimum (210,000 psi tensile minimum).

- FINISH:**
- HLT420(-)(-) = Passivate per AMS2700, Method 1, Type 8, Class 1, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ⑩ 7 HLT420AP(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT420DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT420FB(-)(-) = Grit blast top of head, passivate per AMS2700, Method 1, Type 8, Class 1, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT420FF(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, with color red on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT420FJ(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, with color red on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT420MA(-)(-) = Solid film lube per KAL-GARD™ RA.
 - HLT420PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT420SJ(-)(-) = Grit blast top of head, passivate per AMS2700, Method 1, Type 8, Class 1, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT420SN(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, with color orange on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT420TB(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT420NKJ(-)(-) = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 with color silver on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT420NKL(-)(-) = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only, with color silver on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT420HK(-)(-) = 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.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

**HOW TO ORDER
 EXAMPLE:**



HLT420

DRAWING NUMBER

HLT420

2 OF 2