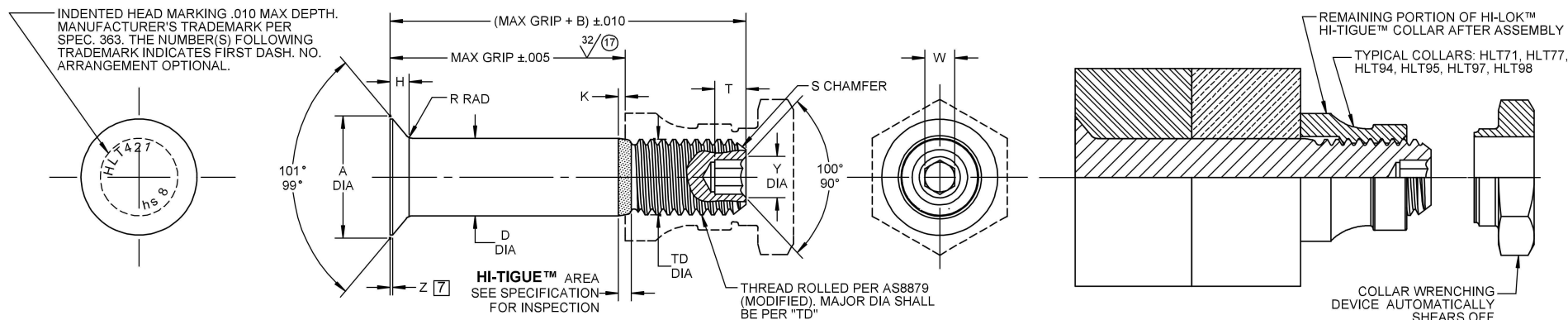




HI-LOK™ HI-TIGUE™ PIN

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 REF	H	K REF	R RAD	Z MAX	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	.2612 .2564	.312	.1635 .1630	.1635 .1625	.1595 .1570	.004	.0408 .0388	.013	.025 .015	.012	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.100 .080	8	5,280	1,700
6	3/16	.3016 .2966	.325	.1895 .1890	.1895 .1885	.1840 .1810	.005	.0470 .0449	.016	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	7,060	2,600
8	1/4	.3948 .3898	.395	.2495 .2490	.2495 .2485	.2440 .2410	.006	.0610 .0589	.021	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	12,260	4,400
10	5/16	.4739 .4689	.500	.3120 .3115	.3120 .3110	.3060 .3020	.007	.0679 .0658	.026	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	19,160	7,000
12	3/8	.5604 .5554	.545	.3745 .3740	.3745 .3735	.3680 .3640	.008	.0780 .0759	.030	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	27,600	10,000
14	7/16	.6680 .6620	.635	.4370 .4365	.4370 .4360	.4310 .4260	.009	.0969 .0944	.035	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	37,500	13,500
16	1/2	.7540 .7480	.685	.4995 .4990	.4995 .4985	.4930 .4880	.010	.1068 .1043	.039	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	49,100	18,000
18	9/16	.8380 .8310	.770	.5615 .5610	.5615 .5605	.5550 .5500	.010	.1160 .1131	.039	.050 .040	.022	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	62,100	22,500
20	5/8	.9250 .9180	.825	.6240 .6235	.6240 .6230	.6180 .6120	.010	.1260 .1230	.044	.050 .040	.022	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	76,700	27,000
24	3/4	1.0970 1.0850	1.050	.7490 .7485	.7490 .7480	.7430 .7370	.012	.1460 .1410	.044	.050 .040	.022	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	110,400	37,300

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
 J.F.OBISPO
 D.P.S.

DATE
 2014-08-05
 1983-04-22

APPROVED
 R. TING

DATE
 1983-04-22

REVISION
 17

DATE
 K. PHAM
 2022-3-3

TITLE
HI-LOK™ HI-TIGUE™ PIN
100° FLUSH SHEAR HEAD
NICKEL BASE ALLOY (INCONEL 718)
1/16 GRIP VARIATION

DRAWING NUMBER
HLT421

1 OF 2

- GENERAL NOTES:**
- 1 Head edge out of roundness shall not exceed "F".
 2. Concentricity: Conical surface of head to "D" diameter within .003 FIM.
 3. Dimensions are in inches and to be met after finish.
 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.
 - 8 Evidence of broken edge across points.
 9. Use HLT621 for oversize replacement.
 - 17 10 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.

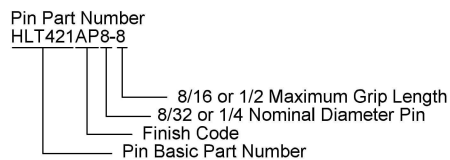
HEAT TREAT: 125,000 psi shear minimum (210,000 psi tensile minimum).

- FINISH:**
- | | |
|-------------------|--|
| HLT421(-)(-) | = Passivate per AMS2700, Method 1, Type 8, Class 1, and cetyl alcohol lube per Hi-Shear Spec. 305. |
| 10 HLT421AP(-)(-) | = 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. |
| HLT421DL(-)(-) | = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305. |
| HLT421FB(-)(-) | = Grit blast top of head, passivate per AMS2700, Method 1, Type 8, Class 1, and cetyl alcohol lube per Hi-Shear Spec. 305. |
| HLT421MA(-)(-) | = Solid film lube per KAL-GARD™ RA. |
| HLT421PB(-)(-) | = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305. |
| HLT421SJ(-)(-) | = 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. |
| HLT421SN(-)(-) | = 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. |
| HLT421TB(-)(-) | = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305. |
| HLT421NKJ(-)(-) | = 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. |
| HLT421NKL(-)(-) | = 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. |
| HLT421HK(-)(-) | = 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:**



HLT421

DRAWING NUMBER

HLT421

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