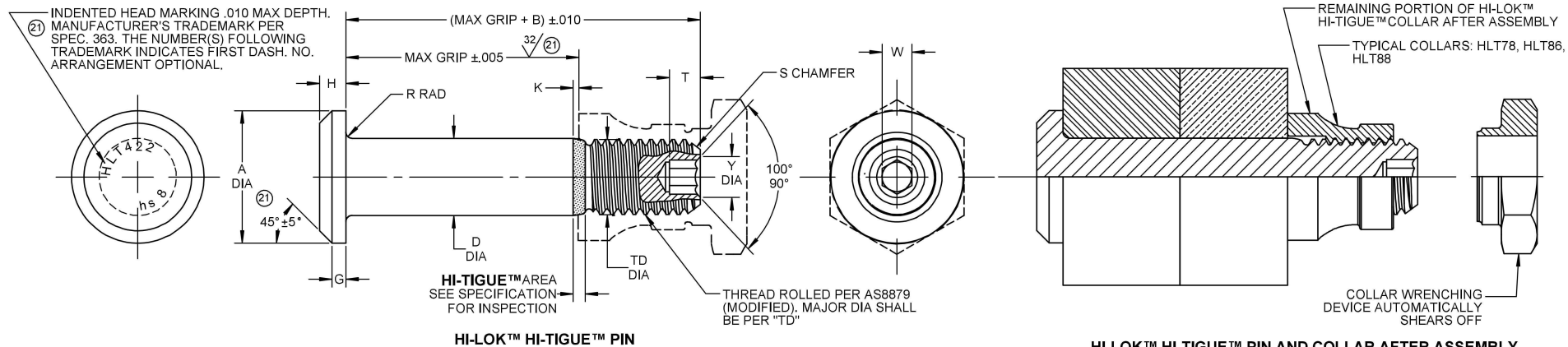


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HI-LOK™ HI-TIGUE™ PIN

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

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	.322 .306	.312	.1635 .1630	.1635 .1625	.1595 .1570	.030	.065 .055	.013	.025 .015	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.100 .080	[5]	5,280	2,940
6	3/16	.377 .357	.325	.1895 .1890	.1895 .1885	.1840 .1810	.035	.074 .064	.016	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	7,060	4,350
8	1/4	.440 .415	.395	.2495 .2490	.2495 .2485	.2440 .2410	.045	.090 .080	.021	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	12,260	7,750
10	5/16	.505 .475	.500	.3120 .3115	.3120 .3110	.3060 .3020	.055	.112 .102	.026	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	19,160	12,300
12	3/8	.600 .565	.545	.3745 .3740	.3745 .3735	.3680 .3640	.075	.140 .130	.030	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	27,600	19,100
14	7/16	.676 .641	.635	.4370 .4365	.4370 .4360	.4310 .4260	.095	.160 .150	.035	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	37,500	25,800
16	1/2	.770 .735	.685	.4995 .4990	.4995 .4985	.4930 .4880	.095	.188 .178	.039	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	49,100	34,300
18	9/16	.877 .842	.770	.5615 .5610	.5615 .5605	.5550 .5500	.125	.210 .200	.039	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	62,100	43,500
20	5/8	.953 .918	.825	.6240 .6235	.6240 .6230	.6180 .6120	.175	.265 .255	.044	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	76,700	54,600
24	3/4	1.150 1.110	1.050	.7490 .7485	.7490 .7480	.7430 .7370	.200	.335 .320	.044	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	110,400	79,200

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

HLT422

"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
 (21)

DATE
 K. PHAM
 2022-03-08

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

DRAWING NUMBER
HLT422

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 HLT622 for oversize replacement.
- ②① 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:**
- ②① HLT422(-)(-) = Passivate per AMS2700, Method 1, Type 8, Class 1, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ②① ⑦ HLT422AP(-)(-) = 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.
 - ②① HLT422DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ②① HLT422FB(-)(-) = Grit blast top of head, passivate per AMS2700, Method 1, Type 8, Class 1, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ②① HLT422MA(-)(-) = Solid film lube per KAL-GARD™ RA.
 - ②① ⑦ HLT422GL(-)(-) = Passivate per AMS2700, Method 1, Type 8, Class 1. HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only (no overspray is allowed on the shank) with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ②① HLT422PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ②① HLT422SC(-)(-) = Grit blast top of head, passivate per AMS2700, Method 1, Type 8, Class 1, with color green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ②① HLT422SD(-)(-) = Grit blast top of head, passivate per AMS2700, Method 1, Type 8, Class 1, with color yellow on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT422SE(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, with color green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT422SG(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, with color yellow on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT422TB(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT422NKJ(-)(-) = 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.
 - HLT422NKL(-)(-) = 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.
 - HLT422HK(-)(-) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

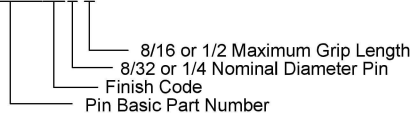
SPECIFICATION: HI-LOK™ HI-TIGUE™ Product Specification 342.

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:

Pin Part Number
 HLT422AP8-8



HLT422

DRAWING NUMBER

HLT422

2 OF 2