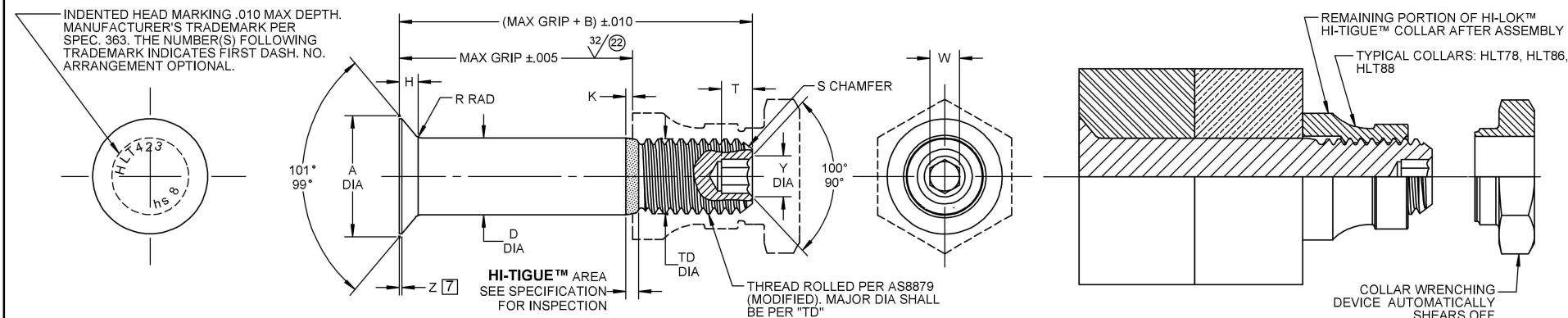


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HI-LOK™ HI-TIGUE™ PIN

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	.3304 .3256	.312	.1635 .1630	.1635 .1625	.1595 .1570	.004	.0700 .0680	.013	.025 .015	.012	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.100 .080	[8]	5,280	2,940
6	3/16	.3813 .3765	.325	.1895 .1890	.1895 .1885	.1840 .1810	.005	.0805 .0785	.016	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	7,060	4,350
8	1/4	.5066 .5018	.395	.2495 .2490	.2495 .2485	.2440 .2410	.006	.1080 .1060	.021	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	12,260	7,750
10	5/16	.6335 .6287	.500	.3120 .3115	.3120 .3110	.3060 .3020	.007	.1350 .1330	.026	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	19,160	12,300
12	3/8	.7604 .7556	.545	.3745 .3740	.3745 .3735	.3680 .3640	.008	.1620 .1600	.030	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	27,600	19,100
14	7/16	.8884 .8812	.635	.4370 .4365	.4370 .4360	.4310 .4260	.009	.1895 .1865	.035	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	37,500	25,800
16	1/2	1.0139 1.0068	.685	.4995 .4990	.4995 .4985	.4930 .4880	.010	.2160 .2130	.039	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	49,100	34,300
18	9/16	1.1408 1.1337	.770	.5615 .5610	.5615 .5605	.5550 .5500	.010	.2430 .2400	.039	.050 .040	.025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	62,100	43,500
20	5/8	1.2723 1.2651	.825	.6240 .6235	.6240 .6230	.6180 .6120	.010	.2720 .2690	.044	.050 .040	.025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	76,700	54,600
24	3/4	1.5308 1.5236	1.050	.7490 .7485	.7490 .7480	.7430 .7370	.012	.3280 .3250	.044	.050 .040	.025	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

"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
 22

DATE
 K. PHAM
 2022-03-08

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

DRAWING NUMBER
HLT423

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 HLT623 for oversize replacement.
 - 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:**
- HLT423(-)(-) = Passivate per AMS2700, Method 1, Type 8, Class 1 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 10 HLT423AP(-)(-) = 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.
 - HLT423DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT423FB(-)(-) = Grit blast top of head, passivate per AMS2700, Method 1, Type 8, Class 1 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 10 HLT423GM(-)(-) = 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 (no overspray on the shank is allowed) and top of head only (.005 max overspray on the head bearing surface permissible) with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT423MA(-)(-) = Solid film lube per KAL-GARD™ RA.
 - HLT423PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT423SC(-)(-) = 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.
 - HLT423SE(-)(-) = 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.
 - HLT423TB(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT423NKJ(-)(-) = 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.
 - HLT423NKL(-)(-) = 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.
 - HLT423HK(-)(-) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

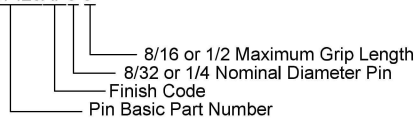
CODE: First dash number indicates nominal diameter in 1/32nds.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

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

HOW TO ORDER

EXAMPLE:

Pin Part Number
 HLT423AP8-8



HLT423

DRAWING NUMBER

HLT423

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