STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

Division of Hi-Shear Industries, Inc.
VOI-SHAN, Division of VSI Corp., U.S.A. (Licensee) U.S. Federal Code I.D. No. 92215
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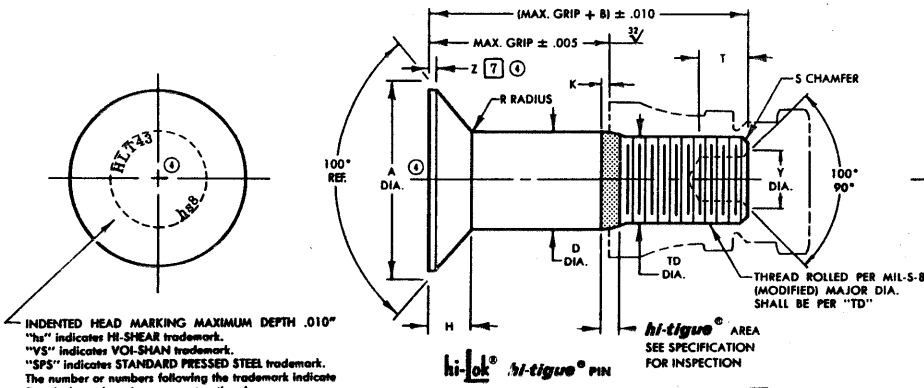
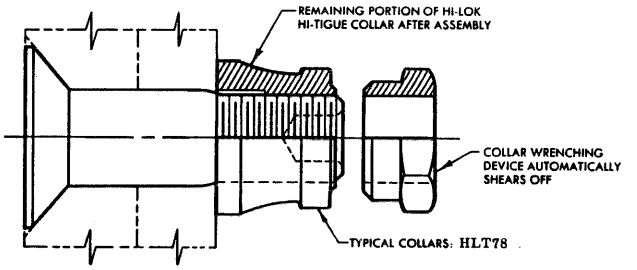


hi-lok® hi-tigue® PIN



hi-lok® hi-tigue® PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA. ④ WITHOUT SOLID FILM LUBE	D DIA. ④ WITH SOLID FILM LUBE	TD DIA.	F	H	K REF.	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET W HEX.	SOCKET T DEPTH	SOCKET Y DIA.	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
–5	5/32	.3304 .3256	.312	.1640 .1635	.1640 .1630	.1595 .1570	.004	.0698 .0678	.013	.025 .015	.010	1/32" x 45°	8-32UNJC-3A Modified	.0645 .0635	.100 .080	.090 .075	4,010	2,180
–6	3/16	.3813 .3765	.325	.1895 .1890	.1895 .1885	.1840 .1810	.005	.0805 .0785	.016	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	5,380	2,750
–8	1/4	.5066 .5018	.395	.2495 .2490	.2495 .2485	.2440 .2410	.006	.1080 .1060	.021	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	9,300	5,000
–10	5/16	.6335 .6287	.500	.3120 .3115	.3120 .3110	.3060 .3020	.007	.1350 .1330	.026	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	14,600	8,300
–12	3/8	.7604 .7556	.545	.3745 .3740	.3745 .3735	.3680 .3640	.008	.1620 .1600	.030	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	21,000	12,700
–14	7/16	.8884 .8812	.635	.4370 .4365	.4370 .4360	.4310 .4260	.009	.1895 .1865	.035	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	28,600	18,900
–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°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	37,300	25,500
–18	9/16	1.1408 1.1337	.770	.5615 .5610	.5615 .5605	.5550 .5500	.010	.2430 .2400	.039	.050 .040	.025	1 1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	47,200	32,400

④ SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH.

④ GENERAL NOTES:
1. Head edge out of roundness shall not exceed "F."
2. Concentricity: Conical surface of head to "D" diameter within .005 FIR.
3. "H" is dimensioned from maximum "D" diameter.
4. Surface texture per ANSI B46.1.
5. Hole preparation per NAS618.
6. Use HLT143 for oversize replacement.
7. Curved or flat edge manufacturer's option.

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
EXAMPLES: Pin Part Number Only
HLT43-8-8
8/16 or 1/2 Maximum Grip Length
8/32 or 1/4 Nominal Diameter Pin
Pin Part Number

Pin and Collar Assembly Part Number Combination
HLT4378-8-8
Size and Grip Length, See Above Example
Collar Part Number
Pin Part Number

MATERIAL: A-286 high temperature alloy per AMS5731 or AMS5737.
HEAT TREAT: 160,000 psi tension minimum (95,000 psi shear minimum) at 70°F.
FINISH: HLT43-( )-( ) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT43DL-( )-( ) = Solid film lube per MIL-L-8937 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT43DU-( )-( ) = Solid film lube per MIL-L-8937.
HLT43TC-( )-( ) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, except top surface of head shall be uncoated, and cetyl alcohol lube per Hi-Shear Spec. 305.
SPECIFICATION: Hi-Lok Hi-Tigue Product Specification 342.

DRAWN	DATE	hi-lok® hi-tigue® PIN
JAP	1-12-71	100° FLUSH MS24694 TENSION HEAD
APPROVED	DATE	A-286 HIGH TEMPERATURE ALLOY
JG Wilcox	1-13-71	1/16" GRIP VARIATION
REVISION ④	DATE D. P. S. 10-14-81	DRAWING NUMBER HLT43

HLT43

2-1597