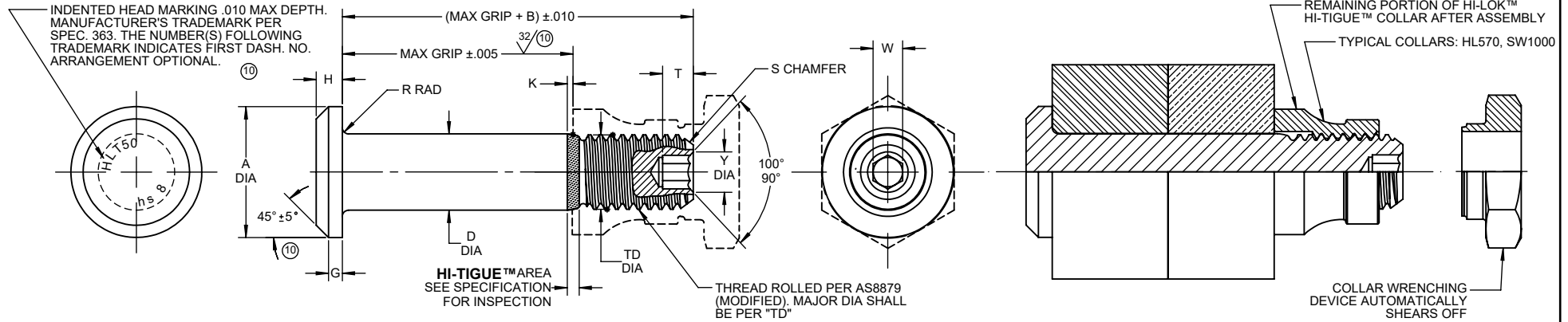




HI-LOK™ HI-TIGUE™ PIN

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

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

| FIRST<br>DASH<br>NO. | PIN<br>NOM<br>DIA | A<br>DIA     | B<br>REF | D<br>DIA       | TD<br>DIA      | G<br>REF | H            | K<br>REF | R<br>RAD     | S<br>CHAMFER<br>REF | THREAD<br>MODIFIED  | SOCKET         |              |              | DOUBLE<br>SHEAR<br>POUNDS<br>MINIMUM | TENSION<br>POUNDS<br>MINIMUM |
|----------------------|-------------------|--------------|----------|----------------|----------------|----------|--------------|----------|--------------|---------------------|---------------------|----------------|--------------|--------------|--------------------------------------|------------------------------|
|                      |                   |              |          |                |                |          |              |          |              |                     |                     | W<br>HEX       | T<br>DEPTH   | Y<br>DIA     |                                      |                              |
| 5                    | 5/32              | .262<br>.242 | .312     | .1635<br>.1630 | .1595<br>.1570 | .020     | .047<br>.037 | .013     | .025<br>.015 | 1/32 x 45°          | .1640-32<br>UNJC-3A | .0801<br>.0791 | .135<br>.115 | [5]          | 5,280                                | 2,200                        |
| 6                    | 3/16              | .315<br>.295 | .325     | .1895<br>.1890 | .1840<br>.1810 | .025     | .055<br>.045 | .016     | .025<br>.015 | 1/32 x 45°          | .1900-32<br>UNJF-3A | .0806<br>.0791 | .135<br>.115 | .119<br>.104 | 7,060                                | 3,000                        |
| 8                    | 1/4               | .412<br>.387 | .395     | .2495<br>.2490 | .2440<br>.2410 | .030     | .069<br>.059 | .021     | .025<br>.015 | 1/32 x 45°          | .2500-28<br>UNJF-3A | .0967<br>.0947 | .150<br>.130 | .142<br>.122 | 12,260                               | 5,100                        |
| 10                   | 5/16              | .505<br>.475 | .500     | .3120<br>.3115 | .3060<br>.3020 | .035     | .078<br>.068 | .026     | .030<br>.020 | 3/64 x 45°          | .3125-24<br>UNJF-3A | .1295<br>.1270 | .170<br>.150 | .180<br>.160 | 19,160                               | 8,000                        |
| 12                   | 3/8               | .600<br>.565 | .545     | .3745<br>.3740 | .3680<br>.3640 | .040     | .088<br>.078 | .030     | .030<br>.020 | 3/64 x 45°          | .3750-24<br>UNJF-3A | .1617<br>.1582 | .200<br>.180 | .217<br>.197 | 27,600                               | 11,300                       |
| 14                   | 7/16              | .676<br>.641 | .635     | .4370<br>.4365 | .4310<br>.4260 | .045     | .105<br>.093 | .035     | .030<br>.020 | 3/64 x 45°          | .4375-20<br>UNJF-3A | .1930<br>.1895 | .230<br>.210 | .253<br>.233 | 37,500                               | 15,500                       |
| 16                   | 1/2               | .770<br>.735 | .685     | .4995<br>.4990 | .4930<br>.4880 | .055     | .115<br>.103 | .039     | .030<br>.020 | 3/64 x 45°          | .5000-20<br>UNJF-3A | .2242<br>.2207 | .260<br>.240 | .289<br>.269 | 49,100                               | 20,000                       |

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
  2. Dimensions are in inches and to be met before finish.
  3. Surface texture per ASME B46.1.
  4. Hole preparation per NAS618.
  5. Evidence of broken edge across points.
  6. Use HLT150 for oversize replacement.
  7. Existing inventory of white painted parts may be used until stock is depleted

**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  
HLT50TB8-8  
8/16 or 1/2 Maximum Grip Length  
8/32 or 1/4 Nominal Diameter Pin  
Finish Code  
Pin Basic Part Number

**MATERIAL:** PH13-8Mo stainless steel per AMS5629.

**HEAT TREAT:** 125,000 psi shear minimum.

**FINISH:** HLT50-( )-( ) = Passivate per Hi-Shear Spec. 262, and cetyl alcohol lube per Hi-Shear Spec. 305.  
HLT50DL( )-( ) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.  
HLT50TB( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.  
⑩ ⑦ HLT50YB( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.  
⑩ ⑦ HLT50YC( )-( ) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.  
HLT50HK( )-( ) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

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

| "HI-LOK", "HI-TIGUE", AND "HI-KOTE",<br>ARE TRADEMARKS OF HI-SHEAR CORPORATION |                               |                                                                                                            |
|--------------------------------------------------------------------------------|-------------------------------|------------------------------------------------------------------------------------------------------------|
| DRAWN BY<br>D.P.S.                                                             | DATE<br>1977-01-20            | TITLE<br>HI-LOK™ HI-TIGUE™ PIN<br>PROTRUDING SHEAR HEAD<br>PH13-8Mo STAINLESS STEEL<br>1/16 GRIP VARIATION |
| APPROVED<br>JGWILCOX                                                           | DATE<br>1977-01-22            |                                                                                                            |
| REVISION<br>⑩                                                                  | DATE<br>C. ARTOS<br>2023-11-8 | DRAWING NUMBER<br><b>HLT50</b>                                                                             |