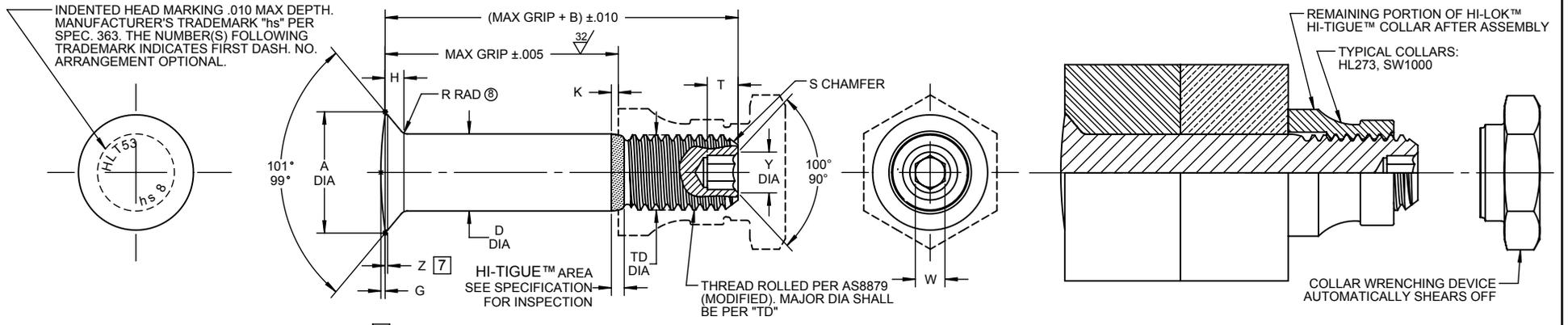


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1 HI-LOK™ HI-TIGUE™ PIN

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

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	F	G	H	K REF	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
														W HEX	T DEPTH	Y DIA		
5	5/32	.3304 .3256	.312	.1635 .1630	.1595 .1570	.004	.015 .010	.0698 .0678	.013	.025 .015	.010	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.135 .115	8	5,280	2,940
6	3/16	.3813 .3765	.325	.1895 .1890	.1840 .1810	.005	.015 .010	.0805 .0785	.016	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	7,060	4,350
8	1/4	.5066 .5018	.395	.2495 .2490	.2440 .2410	.006	.015 .010	.1080 .1060	.021	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	12,260	7,750
10	5/16	.6335 .6287	.500	.3120 .3115	.3060 .3020	.007	.015 .010	.1350 .1330	.026	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	19,160	12,300
12	3/8	.7604 .7556	.545	.3745 .3740	.3680 .3640	.008	.015 .010	.1620 .1600	.030	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	27,600	19,100
14	7/16	.8884 .8812	.635	.4370 .4365	.4310 .4260	.009	.015 .010	.1895 .1865	.035	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	37,500	25,800
16	1/2	1.0139 1.0068	.685	.4995 .4990	.4930 .4880	.010	.015 .010	.2160 .2130	.039	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	49,100	34,300

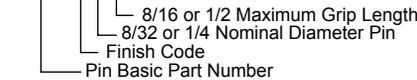
SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH

- GENERAL NOTES:**
- 1 Head edge out of roundness shall not exceed "F".
  - 2 Concentricity: Conical surface of head to "D" diameter within .005 FIM.
  - 3 Dimensions are in inches and to be met before 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 HLT153 for oversize replacement.

**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  
 HLT53TB8-8



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

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

- FINISH:**
- HLT53(-)(-) = Passivate per Hi-Shear Spec. 262, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HLT53DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HLT53TB(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HLT53YB(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, white paint on head, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HLT53YC(-)(-) = Solid film lube per AS5272, Type I, white paint on head, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HLT53HK(-)(-) = 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", ARE TRADEMARKS OF HI-SHEAR CORPORATION		
DRAWN BY D.P.S.	DATE 1977-01-20	TITLE HI-LOK™ HI-TIGUE™ PIN 100° FLUSH CROWN MS24694 TENSION HEAD PH13-8Mo STAINLESS STEEL 1/16 GRIP VARIATION
APPROVED JGWILCOX	DATE 1977-01-20	
REVISION 8	DATE M.BEARD 2017-07-05	DRAWING NUMBER <b>HLT53</b>