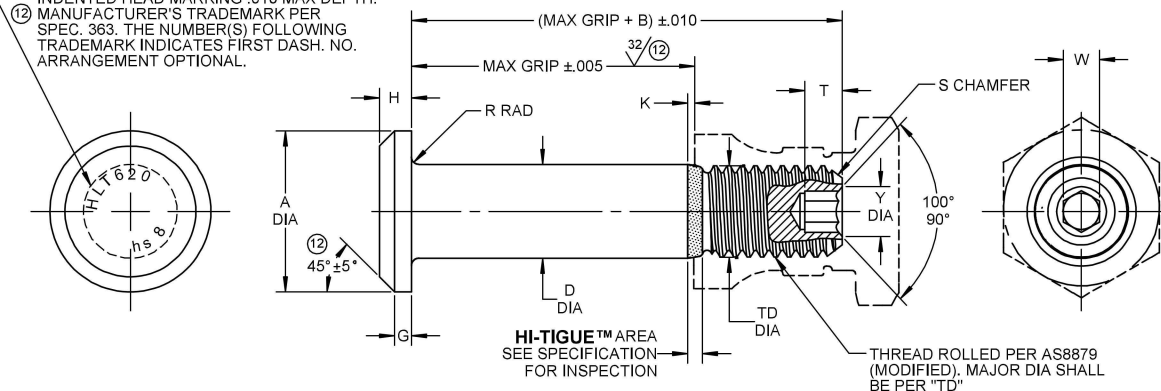


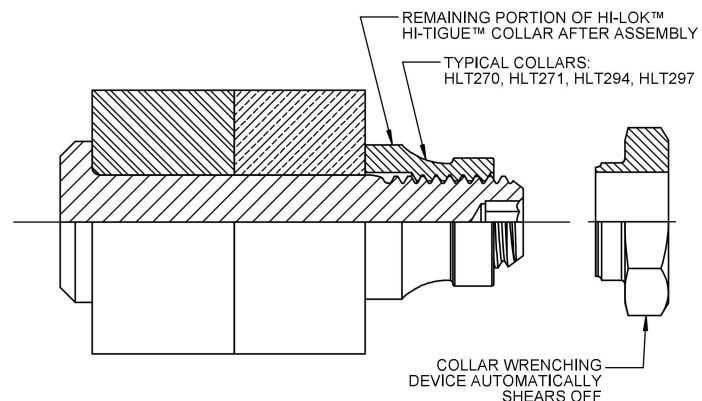
For the current list of licensed manufacturers, please visit the
LISI AEROSPACE website at:

[HTTP://WWW.LISI-AEROSPACE.COM/LICENSES](http://www.lisi-aerospace.com/licenses)

⑫ INDENTED HEAD MARKING .010 MAX DEPTH.
MANUFACTURER'S TRADEMARK PER
SPEC. 363. THE NUMBER(S) FOLLOWING
TRADEMARK INDICATES FIRST DASH. NO.
ARRANGEMENT OPTIONAL.



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 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, SOLID F.L.	WITH COATING, PLATING, SOLID F.L.								W HEX	T DEPTH	Y DIA		
5								NOTE: USE HLT420() 6-()									
6	13/64	.315 .295	.360	.2026 .2021	.2026 .2016	.1840 .1810	.025	.055 .045	.016	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	8,100	3,000
8	17/64	.412 .387	.435	.2651 .2646	.2651 .2641	.2440 .2410	.030	.069 .059	.021	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	13,800	5,100
10	21/64	.505 .475	.545	.3276 .3271	.3276 .3266	.3060 .3020	.035	.078 .068	.026	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	21,100	8,000
12	25/64	.600 .565	.590	.3901 .3896	.3901 .3891	.3680 .3640	.040	.088 .078	.030	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	30,000	11,300
14	29/64	.676 .641	.690	.4526 .4521	.4526 .4516	.4310 .4260	.045	.105 .093	.035	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	40,300	15,500
16	33/64	.770 .735	.740	.5151 .5146	.5151 .5141	.4930 .4880	.050	.115 .103	.039	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	52,500	20,000
18	37/64	.864 .829	.825	.5771 .5766	.5771 .5761	.5550 .5500	.055	.127 .112	.039	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	65,600	25,000
20	41/64	.953 .918	.890	.6396 .6391	.6396 .6386	.6180 .6120	.060	.137 .122	.044	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	80,600	30,200
24	49/64	1.108 1.066	1.115	.7646 .7641	.7646 .7636	.7430 .7370	.070	.151 .136	.044	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	115,000	40,200

"HI-LOK", "HI-TIGUE", AND "HI-KOTE",
ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY DATE
S.GRAPHICS 1983-06-02

APPROVED DATE
R.TING 1983-06-06

REVISION DATE
⑫ K. PHAM 2022-03-08

TITLE
HI-LOK™ HI-TIGUE™ PIN
PROTRUDING SHEAR HEAD
NICKEL BASE ALLOY (INCONEL 718)
1/16 GRIP VARIATION, 1/64 OVERSIZE

DRAWING NUMBER
HLT620

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. Use HLT714 for oversize replacement.
- (12) [6] 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:** (12) HLT620-()-() = Passivate per AMS2700, Method 1, Type 8, Class 1, and cetyl alcohol lube per Hi-Shear Spec. 305.
- (12) [6] HLT620AP()-() = 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.
- HLT620DL()-() = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
- (12) HLT620FB()-() = Grit blast top of head, passivate per AMS2700, Method 1, Type 8, Class 1, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT620FF()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, cetyl alcohol lube per Hi-Shear Spec. 305 and red identification on thread end.
- HLT620FJ()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, with color red on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT620PB()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
- (12) HLT620SK()-() = Grit blast top of head, passivate per AMS2700, Method 1, Type 8, Class 1, with color brown on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT620SP()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, with color brown on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT620TB()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT620NKJ()-() = 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.
- HLT620NKL()-() = 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.
- HLT620HK()-() = 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 of the pin which HLT620 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

**HOW TO ORDER
 EXAMPLE:**

Pin Part Number
 HLT620AP8-8

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

HLT620

DRAWING NUMBER

HLT620

2 OF 2