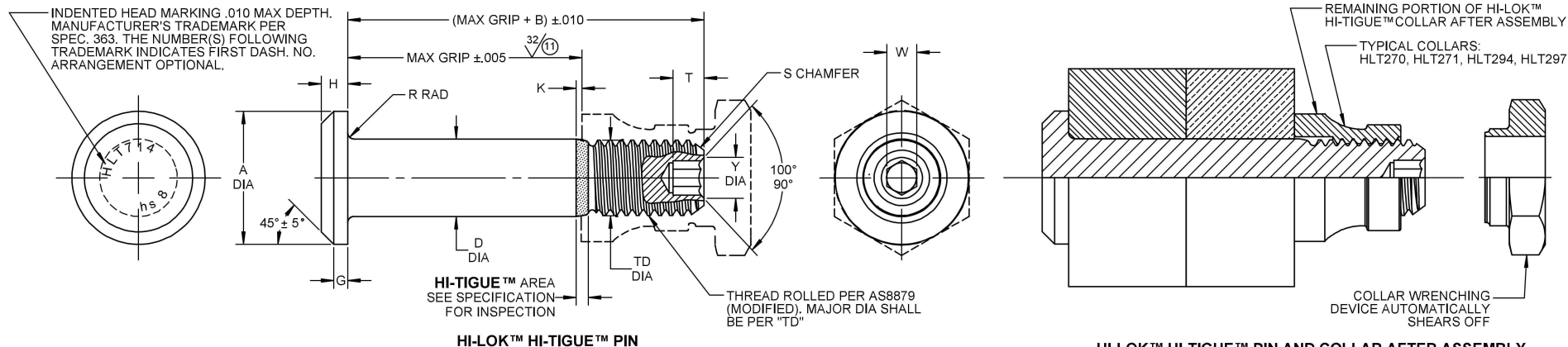


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SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH

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, OR SOLID FILM	AFTER COATING, PLATING, OR SOLID FILM								W HEX	T DEPTH	Y DIA		
5							NOTE: USE HLT620()6(-)										
6	7/32	.315 .295	.360	.2182 .2177	.2182 .2172	.1840 .1810	.025	.055 .045	.016	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	9,400	3,000
8	9/32	.412 .387	.435	.2807 .2802	.2807 .2797	.2440 .2410	.030	.069 .059	.021	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	15,500	5,100
10	11/32	.505 .475	.545	.3432 .3427	.3432 .3422	.3060 .3020	.035	.078 .068	.026	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	23,200	8,000
12	13/32	.600 .565	.590	.4057 .4052	.4057 .4047	.3680 .3640	.040	.088 .078	.030	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	32,400	11,300
14	15/32	.676 .641	.690	.4682 .4677	.4682 .4672	.4310 .4260	.045	.105 .093	.035	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	43,100	15,500
16	17/32	.770 .735	.740	.5307 .5302	.5307 .5297	.4930 .4880	.050	.115 .103	.039	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	55,400	20,000
18	19/32	.864 .829	.825	.5927 .5922	.5927 .5917	.5550 .5500	.055	.127 .112	.039	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	69,200	25,000
20	21/32	.953 .918	.890	.6552 .6547	.6552 .6542	.6180 .6120	.060	.137 .122	.044	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	84,500	30,200
24	25/32	1.108 1.066	1.115	.7802 .7797	.7802 .7792	.7430 .7370	.070	.151 .136	.044	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	120,000	40,200

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

DRAWN BY
 J.F.OBISPO
 D.P.S.

DATE
 2014-08-11
 1985-02-08

APPROVED
 JGWILCOX

DATE
 1985-02-11

REVISION
 (11)

DATE
 K. PHAM
 2022-03-08

TITLE
HI-LOK™ HI-TIGUE™ PIN
PROTRUDING SHEAR HEAD
NICKEL BASE ALLOY (INCONEL 718)
1/16 GRIP VARIATION, 1/32 OVERSIZE

DRAWING NUMBER
HLT714

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. Oversize replacement for HLT420 and HLT620.
- (11) [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:**
- (11) [6] HLT714(-)(-) = Passivate per AMS2700, Method 1, Type 8, Class 1, and cetyl alcohol lube per Hi-Shear Spec. 305.
- [6] HLT714AP(-)(-) = 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.
- HLT714DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT714FF(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, with color red on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT714FB(-)(-) = Grit blast top of head, passivate per AMS2700, Method 1, Type 8, Class 1, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT714FJ(-)(-) = 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.
- HLT714MA(-)(-) = Solid film lube per KAL-GARD™ RA.
- HLT714PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT714SK(-)(-) = 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.
- HLT714SP(-)(-) = 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.
- HLT714TB(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT714NKJ(-)(-) = 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.
- HLT714NKL(-)(-) = 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.
- HLT714HK(-)(-) = 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 HLT714 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
 HLT714AP8-8
 8/16 or 1/2 Maximum Grip Length
 Replaces 8/32 or 1/4 Nominal Diameter Pin
 Finish Code
 Pin Basic Part Number

HLT714

DRAWING NUMBER

HLT714

2 OF 2