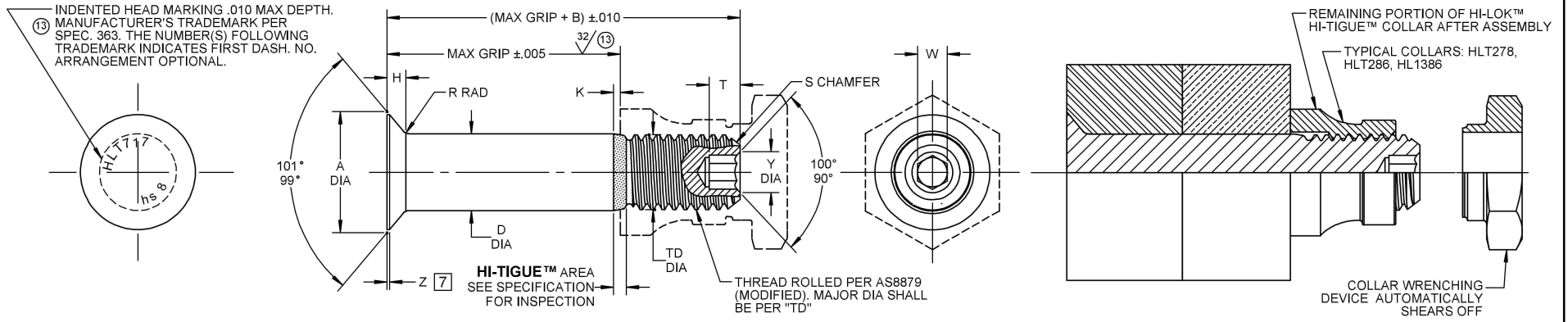




HI-LOK™ HI-TIGUE™ PIN

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

1																		7																	
FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	F REF	H	K REF	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM																	
				WITHOUT PLATING, S.F.L. OR COATING	WITH PLATING, S.F.L. OR COATING									W HEX	T DEPTH	Y DIA																			
5	5/32						NOTE: USE HLT623()6-()																												
6	7/32	.3813 .3765	.360	.2182 .2177	.2182 .2171	.1840 .1810	.005	.0684 .0644	.016	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	9,400	4,350																	
8	9/32	.5066 .5018	.435	.2807 .2802	.2807 .2797	.2440 .2410	.006	.0948 .0928	.021	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	15,500	7,750																	
10	11/32	.6335 .6287	.545	.3432 .3427	.3432 .3422	.3060 .3020	.007	.1218 .1198	.026	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	23,200	12,300																	
12	13/32	.7604 .7556	.590	.4057 .4052	.4057 .4047	.3680 .3640	.008	.1488 .1468	.030	.040 .030	.015	3/64 x 5°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	32,400	19,100																	
14	15/32	.8884 .8812	.690	.4682 .4677	.4682 .4672	.4310 .4260	.009	.1763 .1733	.035	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	43,100	25,800																	
16	17/32	1.0139 1.0068	.740	.5307 .5302	.5307 .5297	.4930 .4880	.010	.2027 .1997	.039	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	55,400	34,300																	
18	19/32	1.1408 1.1337	.825	.5927 .5922	.5927 .5917	.5550 .5500	.010	.2300 .2270	.039	.050 .040	.025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	69,200	43,500																	
20	21/32	1.2723 1.2651	.890	.6552 .6547	.6552 .6542	.6180 .6120	.010	.2589 .2559	.044	.050 .040	.025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	84,500	54,600																	
24	25/32	1.5308 1.5236	1.115	.7802 .7797	.7802 .7792	.7430 .7370	.012	.3149 .3119	.044	.050 .040	.025	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	120,000	79,200																	

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

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

DRAWN BY D.P.S.	DATE 1985-02-08	TITLE HI-LOK™ HI-TIGUE™ PIN 100° FLUSH MS24694 TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16 GRIP VARIATION, 1/32 OVERSIZE
APPROVED JGWILCOX	DATE 1985-02-11	
REVISION (13)	DATE K. PHAM 2022-03-08	DRAWING NUMBER HLT717

- GENERAL NOTES:**
- 1 Head edge out of roundness shall not exceed "F".
 2. Concentricity: Conical surface of head to "D" diameter within .003 FIM.
 3. "H" is dimensioned from maximum "D" diameter.
 4. Dimensions are in inches and to be met after finish.
 5. Surface texture per ASME B46.1.
 6. Hole preparation per NAS618.
 - 7 Curved or flat edge manufacturer's option.
 8. Oversize replacement for HLT423 and HLT623.
 - 13 9 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:**
- 13 HLT717(-)(-) = Passivate per AMS2700, Method 1, Type 8, Class 1, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 13 9 HLT717AP(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT717DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 13 HLT717FB(-)(-) = Grit blast top of head, passivate per AMS2700, Method 1, Type 8, Class 1 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT717PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 13 HLT717SD(-)(-) = Grit blast top of head, passivate per AMS2700, Method 1, Type 8, Class 1, with color yellow on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT717SG(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, with color yellow on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT717TB(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 13 9 HLT717GM(-)(-) = Passivate per AMS2700, Method 1, Type 8, Class 1. HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294 on threads (no overspray on the shank is allowed) and top of head only (.005 max overspray on the head bearing surface permissible) with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT717NKJ(-)(-) = 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.
 - HLT717NKL(-)(-) = 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.
 - HLT717HK(-)(-) = 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 HLT717 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
 HLT717AP8-8

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