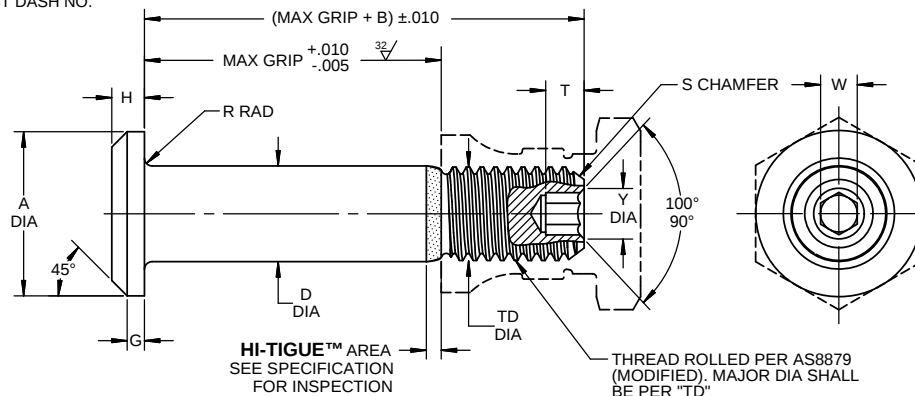
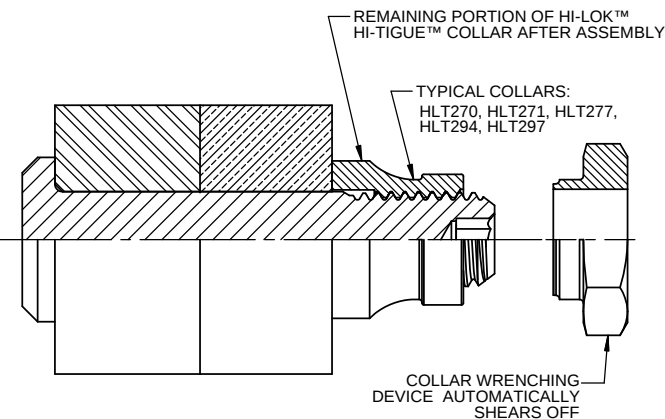


INDENTED HEAD MARKING .010 MAX DEPTH.  
MANUFACTURER'S TRADEMARK "hs" PER  
SPEC 363. THE NUMBER(S) FOLLOWING  
TRADEMARK INDICATES FIRST DASH NO.  
ARRANGEMENT OPTIONAL.



HI-LOK™ HI-TIGUE™ PIN



HI-LOK™ 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 DIA                            |                                         | TD<br>DIA      | G<br>REF | H            | R<br>RAD     | S<br>CHAMFER<br>REF | THREAD<br>MODIFIED  | SOCKET         |              |              | DOUBLE<br>SHEAR<br>POUNDS<br>MINIMUM | TENSION<br>POUNDS<br>MINIMUM |
|----------------------|-------------------|----------------|----------|----------------------------------|-----------------------------------------|----------------|----------|--------------|--------------|---------------------|---------------------|----------------|--------------|--------------|--------------------------------------|------------------------------|
|                      |                   |                |          | WITH<br>CETYL<br>ALCOHOL<br>ONLY | WITH<br>SOLID<br>FILM<br>OR<br>HI-KOTE™ |                |          |              |              |                     |                     | W<br>HEX       | T<br>DEPTH   | Y<br>DIA     |                                      |                              |
| 5                    |                   |                |          | NOTE: USE HLT410( )6-( )         |                                         |                |          |              |              |                     |                     |                |              |              |                                      |                              |
| 6                    | 13/64             | .315<br>.295   | .360     | .2026<br>.2021                   | .2026<br>.2016                          | .1840<br>.1810 | .025     | .055<br>.045 | .025<br>.015 | 1/32 x 37°          | .1900-32<br>UNJF-3A | .0806<br>.0791 | .100<br>.080 | .119<br>.104 | 6,130                                | 2,500                        |
| 8                    | 17/64             | .412<br>.387   | .435     | .2651<br>.2646                   | .2651<br>.2641                          | .2440<br>.2410 | .030     | .069<br>.059 | .025<br>.015 | 1/32 x 37°          | .2500-28<br>UNJF-3A | .0967<br>.0947 | .110<br>.090 | .142<br>.122 | 10,490                               | 4,300                        |
| 10                   | 21/64             | .505<br>.475   | .545     | .3276<br>.3271                   | .3276<br>.3266                          | .3060<br>.3020 | .035     | .078<br>.068 | .030<br>.020 | 3/64 x 37°          | .3125-24<br>UNJF-3A | .1295<br>.1270 | .130<br>.110 | .180<br>.160 | 16,000                               | 6,300                        |
| 12                   | 25/64             | .600<br>.565   | .590     | .3901<br>.3896                   | .3901<br>.3891                          | .3680<br>.3640 | .040     | .088<br>.078 | .030<br>.020 | 3/64 x 37°          | .3750-24<br>UNJF-3A | .1617<br>.1582 | .160<br>.140 | .217<br>.197 | 22,700                               | 8,700                        |
| 14                   | 29/64             | .676<br>.641   | .690     | .4526<br>.4521                   | .4526<br>.4516                          | .4310<br>.4260 | .045     | .105<br>.093 | .030<br>.020 | 3/64 x 37°          | .4375-20<br>UNJF-3A | .1930<br>.1895 | .190<br>.170 | .253<br>.233 | 30,600                               | 12,100                       |
| 16                   | 33/64             | .770<br>.735   | .740     | .5151<br>.5146                   | .5151<br>.5141                          | .4930<br>.4880 | .050     | .115<br>.103 | .030<br>.020 | 3/64 x 37°          | .5000-20<br>UNJF-3A | .2242<br>.2207 | .220<br>.200 | .289<br>.269 | 39,600                               | 15,300                       |
| 18                   | 37/64             | .864<br>.829   | .825     | .5771<br>.5766                   | .5771<br>.5761                          | .5550<br>.5500 | .055     | .127<br>.112 | .040<br>.025 | 1/16 x 37°          | .5625-18<br>UNJF-3A | .2555<br>.2520 | .260<br>.240 | .326<br>.306 | 49,700                               | 19,000                       |
| 20                   | 41/64             | .953<br>.918   | .890     | .6396<br>.6391                   | .6396<br>.6386                          | .6180<br>.6120 | .060     | .137<br>.122 | .040<br>.025 | 1/16 x 37°          | .6250-18<br>UNJF-3A | .2555<br>.2520 | .260<br>.240 | .326<br>.306 | 61,000                               | 23,000                       |
| 24                   | 49/64             | 1.108<br>1.066 | 1.115    | .7646<br>.7641                   | .7646<br>.7636                          | .7430<br>.7370 | .070     | .151<br>.136 | .045<br>.030 | 1/16 x 37°          | .7500-16<br>UNJF-3A | .3185<br>.3150 | .330<br>.300 | .398<br>.378 | 87,200                               | 30,700                       |
| 28                   | 57/64             | 1.285<br>1.241 | 1.285    | .8896<br>.8891                   | .8896<br>.8886                          | .8680<br>.8610 | .090     | .187<br>.172 | .050<br>.035 | 5/64 x 37°          | .8750-14<br>UNJF-3A | .3820<br>.3780 | .400<br>.370 | .471<br>.451 | 118,000                              | 45,000                       |
| 32                   | 1-1/64            | 1.468<br>1.424 | 1.480    | 1.0146<br>1.0141                 | 1.0146<br>1.0136                        | .9930<br>.9860 | .110     | .218<br>.203 | .060<br>.045 | 5/64 x 37°          | 1.000-12<br>UNJF-3A | .5100<br>.5040 | .520<br>.490 | .618<br>.598 | 154,000                              | 60,900                       |

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

|                    |                               |                                                                                                           |
|--------------------|-------------------------------|-----------------------------------------------------------------------------------------------------------|
| DRAWN BY<br>VAN    | DATE<br>1969-07-23            | TITLE<br>HI-LOK™ HI-TIGUE™ PIN<br>PROTRUDING SHEAR HEAD<br>TITANIUM<br>1/16 GRIP VARIATION, 1/64 OVERSIZE |
| APPROVED<br>R.TING | DATE<br>1969-07-25            |                                                                                                           |
| REVISION<br>10     | DATE<br>M.BEARD<br>2017-05-16 | DRAWING NUMBER<br><b>HLT110</b>                                                                           |

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

2 OF 2