



HI-LOK™ HI-TIGUE™ PIN

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

FIRST DASH NO.	PIN NOM DIA	A DIA	A' DIA MIN	B REF	D DIA	TD DIA	F	H	R RAD	S CHAMFER REF	THREAD MODIFIED	Z	SOCKET			DOUBLE SHEAR POUNDS	TENSION POUNDS MINIMUM
													W HEX	T DEPTH	Y DIA		
5	5/32	.2612 .2561	.238	.312	.1635 .1625	.1595 .1570	.004	.0410 .0390	.025 .015	1/32 x 45°	.1640-32 UNJC-3A	.010 .005	.0801 .0791	.100 .080	[5]	5,250 4,560	2,000
6	3/16	.3016 .2966	.266	.325	.1895 .1885	.1840 .1810	.005	.0470 .0449	.030 .020	1/32 x 45°	.1900-32 UNJF-3A	.015 .005	.0806 .0791	.100 .080	.119 .104	7,050 6,125	2,600
8	1/4	.3948 .3898	.359	.395	.2495 .2485	.2440 .2410	.006	.0610 .0589	.030 .020	1/32 x 45°	.2500-28 UNJF-3A	.015 .005	.0967 .0947	.110 .090	.142 .122	12,220 10,600	4,600
10	5/16	.4739 .4689	.438	.500	.3120 .3110	.3060 .3020	.007	.0679 .0658	.040 .030	3/64 x 45°	.3125-24 UNJF-3A	.015 .005	.1295 .1270	.130 .110	.180 .160	19,110 16,600	7,000
12	3/8	.5604 .5554	.525	.545	.3745 .3735	.3680 .3640	.008	.0780 .0759	.040 .030	3/64 x 45°	.3750-24 UNJF-3A	.015 .005	.1617 .1582	.160 .140	.217 .197	27,540 23,900	10,000
14	7/16	.6680 .6620	.616	.635	.4370 .4360	.4310 .4260	.009	.0969 .0944	.050 .040	3/64 x 45°	.4375-20 UNJF-3A	.022 .005	.1930 .1895	.190 .170	.253 .233	37,500 32,500	14,000
16	1/2	.7540 .7480	.702	.685	.4995 .4985	.4930 .4880	.010	.1068 .1043	.050 .040	3/64 x 45°	.5000-20 UNJF-3A	.022 .005	.2242 .2207	.220 .200	.289 .269	49,000 42,400	17,800
18	9/16	.8380 .8310	.786	.770	.5615 .5605	.5550 .5500	.010	.1160 .1131	.050 .040	1/16 x 45°	.5625-18 UNJF-3A	.022 .005	.2555 .2520	.260 .240	.326 .306	61,910 53,700	19,200
20	5/8	.9250 .9180	.873	.825	.6240 .6230	.6180 .6120	.010	.1260 .1230	.050 .040	1/16 x 45°	.6250-18 UNJF-3A	.022 .005	.2555 .2520	.260 .240	.326 .306	76,450 66,300	24,700

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

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
  - Concentricity: Conical surface of head to "D" diameter within .005 FIM.
  - "H" is dimensioned from maximum "D" diameter.
  - Dimensions are in inches and to be met after plating.
  - Evidence of broken edge across points.
  - Surface texture per ASME B46.1.
  - Hole preparation per NAS618.
  - Curved or flat edge manufacturer's option.
  - Use HLT123 for oversize replacement.

**MATERIAL:** Alloy steel per AMS6415, AMS6349 or AMS-S-6049.

**HEAT TREAT:** 108,000-125,000 psi shear (180,000 psi tensile minimum) per AMS-H-6875.

**FINISH:** HLT115-( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

⑬ HLT115TB( )-( ) = Cadmium plate per AMS-QQ-P-416, Type III, Class 2, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.

**SPECIFICATION:** HI-LOK™ HI-TIGUE™ Product Specification 352.

**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**

⑬ **EXAMPLE:**

Pin Part Number  
HLT115TB8-8

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

Pin and Collar Assembly Part Number Combination  
HLT11577-8-8

Size and Grip Length, See Above Example  
Collar Part Number  
Pin Part Number

"HI-LOK", "HI-TIGUE", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY D.P.S.	DATE 1977-02-15	TITLE HI-LOK™ HI-TIGUE™ PIN 100° FLUSH CROWN SHEAR HEAD ALLOY STEEL 1/16 GRIP VARIATION	
APPROVED R.TING	DATE 1977-02-15	DRAWING NUMBER <b>HLT115</b>	
REVISION ⑬	DATE M.BEARD 2017-06-13	1 OF 1	