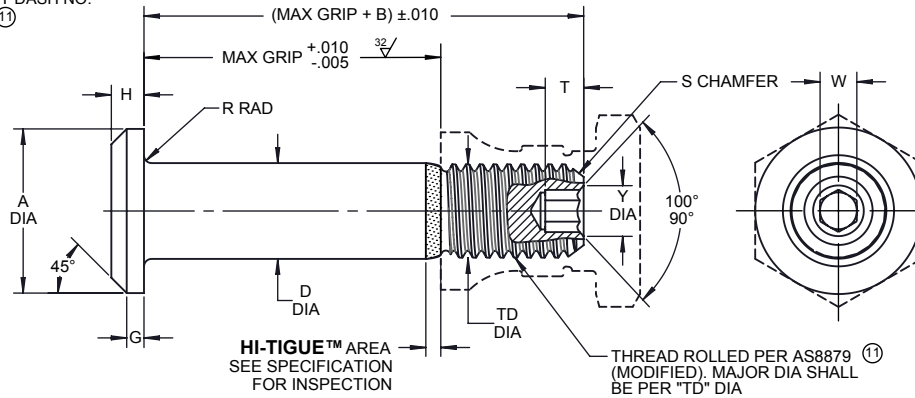
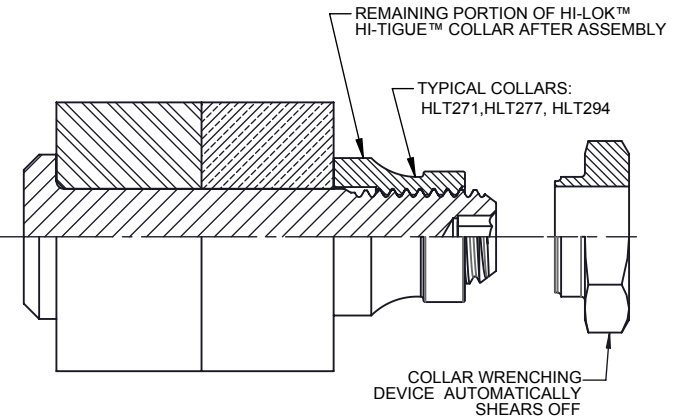


INDENTED HEAD MARKING .010 MAX DEPTH. MANUFACTURER'S TRADEMARK "hs" PER SPEC 363. THE NUMBER(S) FOLLOWING TRADEMARK INDICATES FIRST DASH NO. ARRANGEMENT OPTIONAL. (11)



HI-LOK™ HI-TIGUE™ PIN



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

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS	TENSION POUNDS MINIMUM
											W HEX	T DEPTH	Y DIA		
5	3/16														
NOTE: USE HLT114-6()															
6	13/64	.315 .295	.360	.2026 .2016	.1840 .1810	.025	.055 .045	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	8,060 6,970	2,900
8	17/64	.412 .387	.435	.2651 .2641	.2440 .2410	.030	.069 .059	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	13,800 11,920	5,100
10	21/64	.505 .475	.545	.3276 .3266	.3060 .3020	.035	.078 .068	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	21,070 18,200	7,100
12	25/64	.600 .565	.590	.3901 .3891	.3680 .3640	.040	.088 .078	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	29,880 25,800	9,800

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

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 2. Dimensions are in inches and to be met after plating.
 3. Surface texture per ASME B46.1.
 4. Hole preparation per NAS618.
 5. Use HLT126 for oversize replacement.

MATERIAL: (11) Alloy steel per AMS6415, AMS6349 or AMS6322, AMS6327 or AMS6325.

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

FINISH: HLT122-()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and 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 of the pin which HLT122 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER

(11) EXAMPLE:

Pin Part Number
HLT122-8-8
└─ 8/16 or 1/2 Threaded Stud Grip
└─ Replaces 8/32 or 1/4 Nominal Diameter Pin
└─ Finish Code
└─ Pin Basic Part Number

Pin and Collar Assembly Part Number Combination
HLT122277-8-8
└─ Size and grip length, see above example
└─ Collar Part Number
└─ Pin Part Number

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

DRAWN BY D.P.S.	DATE 1977-02-22	TITLE HI-LOK™ HI-TIGUE™ PIN PROTRUDING SHEAR HEAD ALLOY STEEL 1/16 GRIP VARIATION, 1/64 OVERSIZE	
APPROVED R. TING	DATE 1977-03-02	DRAWING NUMBER HLT122	
REVISION (11)	DATE K. TRAN 2017-10-19	1 OF 1	