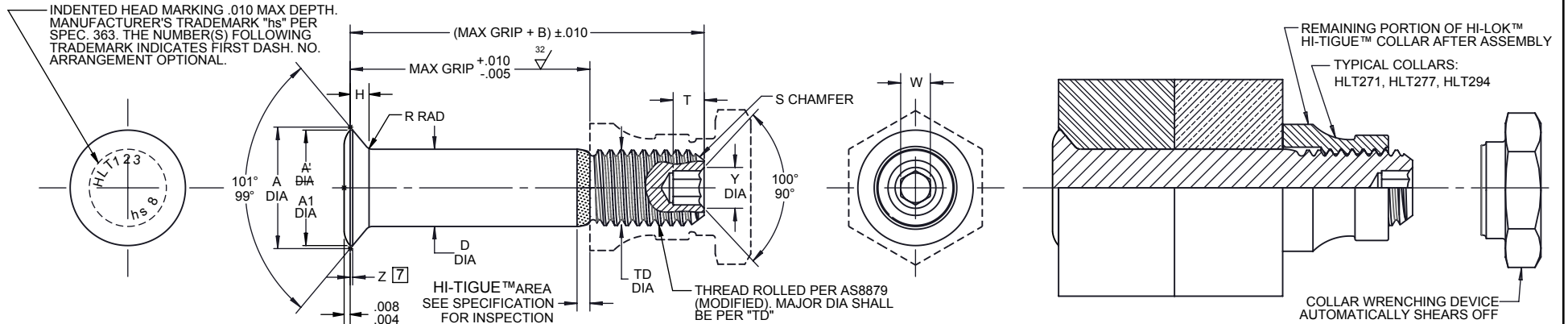




HI-LOK™ HI-TIGUE™ PIN

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

1																	7																	11																
FIRST DASH NO.	PIN NOM DIA	A DIA	A1 DIA A' DIA	B REF	D DIA	TD DIA	F	H	R RAD	Z	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS	TENSION POUNDS MINIMUM																																	
													W HEX	T DEPTH	Y DIA																																			
5						NOTE: Use HLT115-6																																												
6	13/64	.3148 .3096	.279	.360	.2026 2016	.1840 .1810	.005	.0470 .0449	.030 .020	.015 .005	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	8,060 6,970	2,600																																	
8	17/64	.4105 .4055	.375	.435	.2651 2641	.2440 2410	.006	.0610 .0589	.030 .020	.015 .005	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	13,800 11,920	4,600																																	
10	21/64	.4894 .4844	.454	.545	.3276 .3266	.3060 .3020	.007	.0679 .0658	.040 .030	.015 .005	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	21,070 18,200	7,000																																	
12	25/64	.5760 .5710	.541	.590	.3901 .3891	.3680 .3640	.008	.0780 .0759	.040 .030	.015 .005	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	29,880 25,800	10,000																																	
14	29/64	.6836 .6776	.631	.690	.4526 .4516	.4310 .4260	.009	.0969 .0944	.050 .040	.022 .005	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	40,220 34,800	14,000																																	
16	33/64	.7697 .7637	.717	.740	.5151 .5141	.4930 .4880	.010	.1068 .1043	.050 .040	.022 .005	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	52,100 45,000	17,800																																	

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 finish.
 - Surface texture per ASME B46.1.
 - Hole preparation per NAS618.
 - Curved or flat edge manufacturer's option.
 - Use HLT217 for oversize replacement.

CODE: First dash number indicates nominal diameter in 1/32nds which HLT123 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
 HLT123TB 8-8
 L 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
 HLT12377 8-8
 Size and Grip Length, See Above Example
 Collar Part Number
 Pin Part Number

MATERIAL: Alloy steel per Spec. AMS6415, AMS6349 or AMS6322.

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

FINISH: HLT123-()-() = Cadmium plate per Spec. AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT123BJ()-() = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT123TB()-() = 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.

"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, 1/64 OVERSIZE
APPROVED R.TING	DATE 1977-02-15	
REVISION 11	DATE F.CARINGELLA 2018-10-29	DRAWING NUMBER HLT123