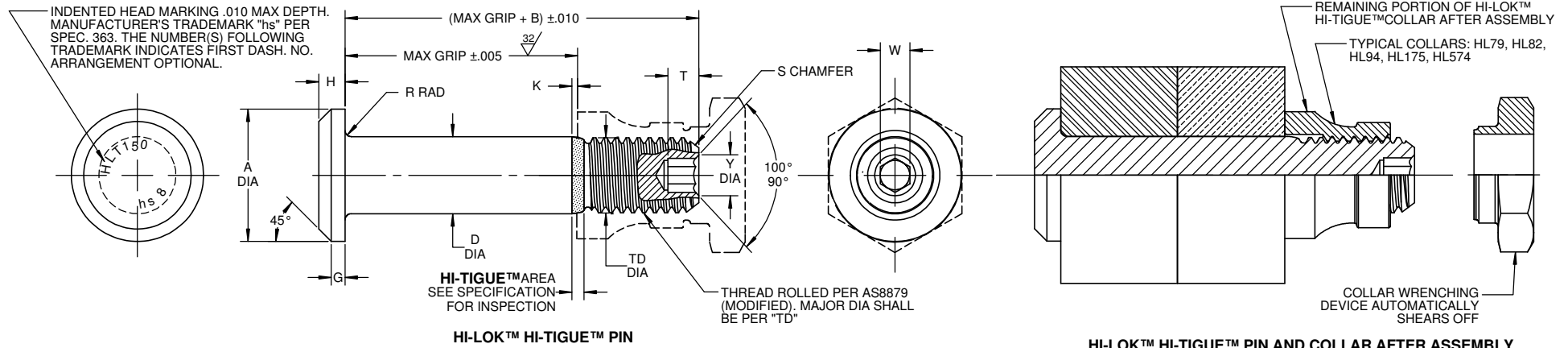


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HI-LOK™ HI-TIGUE™ PIN

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

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

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	H	K REF	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
												W HEX	T DEPTH	Y DIA		
5						NOTE: USE HLT50()6-()										
6	13/64	.315 .295	.360	.2026 .2021	.1840 .1810	.025	.055 .045	.016	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	8,100	3,000
8	17/64	.412 .387	.435	.2651 .2646	.2440 .2410	.030	.069 .059	.021	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	13,800	5,100
10	21/64	.505 .475	.545	.3276 .3271	.3060 .3020	.035	.078 .068	.026	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	21,100	8,000
12	25/64	.600 .565	.590	.3901 .3896	.3680 .3640	.040	.088 .078	.030	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	30,000	11,300
14	29/64	.676 .641	.690	.4526 .4521	.4310 .4260	.045	.105 .093	.035	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	40,300	15,500
16	33/64	.770 .735	.740	.5151 .5146	.4930 .4880	.050	.115 .103	.039	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	52,200	20,000

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 2. Dimensions to be met after finish and before application of solid film lubricant.
 3. Surface texture per ANSI B46.1.
 4. Hole preparation per NAS618.
 5. Use HLT250 for oversize replacement.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HLT150 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
HLT150TB8-8
└─ 8/16 or 1/2 Maximum Grip Length
└─ Replaces 8/32 or 1/4 Nominal Diameter Pin
└─ HI-KOTE™ 2 Solid Film Lube
└─ Pin Basic Part Number

MATERIAL: PH13-8Mo stainless steel per AMS5629.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: HLT150(-)(-) = Passivate per Hi-Shear Spec. 262, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT150DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT150TB(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT150YB(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, white paint on head, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT150YC(-)(-) = Solid film lube per AS5272, Type I, white paint on head, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LOK™ HI-TIGUE™ Product Specification 342.

"HI-LOK", "HI-TIGUE", and "HI-KOTE", are Trademarks of Hi-Shear Corporation

DRAWN BY D.P.S.	DATE 1977-01-20	TITLE HI-LOK™ HI-TIGUE™ PIN PROTRUDING SHEAR HEAD PH13-8Mo STAINLESS STEEL 1/16 GRIP VARIATION, 1/64 OVERSIZE	
APPROVED JGWilcox	DATE 1977-01-20	DRAWING NUMBER HLT150	
REVISION ⑦	DATE J.F. Obispo 2017-05-10		