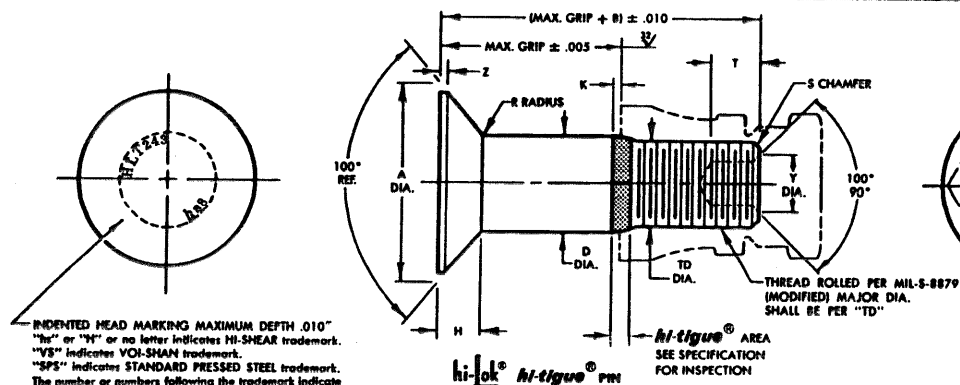


hi-lok® hi-tigue® PIN AND COLLAR AFTER ASSEMBLY

| FIRST<br>DASH<br>NO. | NOM.<br>DIA. | A<br>DIA.        | B<br>REF. | D<br>DIA.                   |                          | TD<br>DIA.     | F    | H              | K<br>REF. | R<br>RAD.    | Z            | S<br>CHAMFER<br>REF. | THREAD                     | SOCKET         |              |              | DOUBLE<br>SHEAR<br>POUNDS<br>MINIMUM | TENSION<br>POUND<br>MINIMUM |
|----------------------|--------------|------------------|-----------|-----------------------------|--------------------------|----------------|------|----------------|-----------|--------------|--------------|----------------------|----------------------------|----------------|--------------|--------------|--------------------------------------|-----------------------------|
|                      |              |                  |           | WITHOUT<br>HI-KOTE™<br>LUBE | WITH<br>HI-KOTE™<br>LUBE |                |      |                |           |              |              |                      |                            | W<br>HEX.      | T<br>DEPTH   | Y<br>DIA.    |                                      |                             |
|                      |              |                  |           |                             |                          |                |      |                |           |              |              |                      |                            |                |              |              |                                      |                             |
| - 5                  | 3/16         |                  |           | NOTE: Use HLT43-6           |                          |                |      |                |           |              |              |                      |                            |                |              |              |                                      |                             |
| - 6                  | 7/32         | .3813<br>.3765   | .360      | .2182<br>.2177              | .2182<br>.2172           | .1840<br>.1810 | .005 | .0684<br>.0664 | .022      | .030<br>.020 | .015<br>.005 | 1/32" x 45°          | 10-32UNJF-3A<br>Modified   | .0806<br>.0791 | .100<br>.080 | .119<br>.104 | 7,100                                | 2,750                       |
| - 8                  | 9/32         | .5066<br>.5018   | .435      | .2807<br>.2802              | .2807<br>.2797           | .2440<br>.2410 | .006 | .0948<br>.0928 | .027      | .030<br>.020 | .015<br>.005 | 1/32" x 45°          | 1/4-28UNJF-3A<br>Modified  | .0967<br>.0947 | .110<br>.090 | .142<br>.122 | 11,800                               | 5,820                       |
| - 10                 | 11/32        | .6335<br>.6287   | .545      | .3432<br>.3427              | .3432<br>.3422           | .3060<br>.3020 | .007 | .1218<br>.1198 | .032      | .040<br>.030 | .015<br>.005 | 3/64" x 45°          | 5/16-24UNJF-3A<br>Modified | .1295<br>.1270 | .130<br>.110 | .180<br>.160 | 17,600                               | 9,200                       |
| - 12                 | 13/32        | .7804<br>.7556   | .590      | .4057<br>.4052              | .4057<br>.4047           | .3680<br>.3640 | .008 | .1488<br>.1468 | .036      | .040<br>.030 | .015<br>.005 | 3/64" x 45°          | 3/8-24UNJF-3A<br>Modified  | .1617<br>.1582 | .160<br>.140 | .217<br>.197 | 24,600                               | 14,000                      |
| - 14                 | 15/32        | .8884<br>.8812   | .690      | .4682<br>.4677              | .4682<br>.4672           | .4310<br>.4260 | .009 | .1763<br>.1733 | .035      | .050<br>.040 | .022<br>.005 | 3/64" x 45°          | 7/16-20UNJF-3A<br>Modified | .1930<br>.1895 | .190<br>.170 | .253<br>.233 | 32,700                               | 18,900                      |
| - 16                 | 17/32        | 1.0139<br>1.0068 | .740      | .5307<br>.5302              | .5307<br>.5297           | .4930<br>.4880 | .010 | .2027<br>.1997 | .045      | .050<br>.040 | .022<br>.005 | 3/64" x 45°          | 1/2-20UNJF-3A<br>Modified  | .2242<br>.2207 | .220<br>.200 | .289<br>.269 | 42,000                               | 25,500                      |
| - 18                 | 19/32        | 1.1408<br>1.1337 | .825      | .5927<br>.5922              | .5927<br>.5917           | .5550<br>.5500 | .010 | .2300<br>.2270 | .041      | .050<br>.040 | .022<br>.005 | 1/16" x 45°          | 9/16-18UNJF-3A<br>Modified | .2555<br>.2520 | .260<br>.240 | .326<br>.306 | 52,400                               | 32,400                      |
|                      |              |                  |           |                             |                          |                |      |                |           |              |              |                      |                            |                |              |              |                                      |                             |
|                      |              |                  |           |                             |                          |                |      |                |           |              |              |                      |                            |                |              |              |                                      |                             |
|                      |              |                  |           |                             |                          |                |      |                |           |              |              |                      |                            |                |              |              |                                      |                             |
|                      |              |                  |           |                             |                          |                |      |                |           |              |              |                      |                            |                |              |              |                                      |                             |
|                      |              |                  |           |                             |                          |                |      |                |           |              |              |                      |                            |                |              |              |                                      |                             |

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 FIR.
  - "H" is dimensioned from maximum "D" diameter.
  - Surface texture per ANSI-46.1.
  - Hole preparation per NAS618.

**MATERIAL:** A-286 high temperature alloy per AMS5731.

**HEAT TREAT:** 95,000 psi shear minimum at 70°F.

**FINISH:** HLT243-( )-( ) = Passivate per HI-Shear Spec. 258 and cetyl alcohol lube per HI-Shear Spec. 305.  
HLT243TC-( )-( ) = HI-Kote II except top surface of head shall be uncoated, and cetyl alcohol lube per HI-Shear Spec. 305.

**SPECIFICATION:** HI-Lok HI-Tigue Product Specification 342.

**CODE:** First dash number indicates nominal diameter in 1/32nds which HLT243 oversize pin replaces.  
Second dash number indicates maximum grip in 1/16ths. See "Finish" note for explanation of code letters.

**HOW TO ORDER EXAMPLES:**

**Pin Part Number Only**  
HLT243-6-8  
8/16 or 1/2 Maximum Grip Length  
Replaces 8/32 or 1/4 Nominal Diameter Pin  
Pin Part Number

**Pin and Collar Assembly Part Number Combination**  
HLT243286-8-8  
Size and Grip Length, See Above Example  
Collar Part Number  
Pin Part Number

|                                                                                                                                                                                                                                                                                                  |                 |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------|
| U.S. Patents 2,882,773; 2,947,491; 2,940,493; 3,027,789; 3,138,987; 3,578,387; design patent 191,883; other U.S. and Foreign patents granted and pending; property of HI-Shear Corporation. "Hi-Lok" and "Hi-Tigue" are Registered Trademarks. "Hi-Kote" is a trademark of HI-Shear Corporation. |                 |
| DRAWN<br>VAN                                                                                                                                                                                                                                                                                     | DATE<br>6-19-72 |
| APPROVED<br>J. B. Wilson                                                                                                                                                                                                                                                                         | DATE<br>6-20-72 |
| REVISION                                                                                                                                                                                                                                                                                         | DATE            |
| DRAWING NUMBER<br><b>HLT243</b>                                                                                                                                                                                                                                                                  |                 |