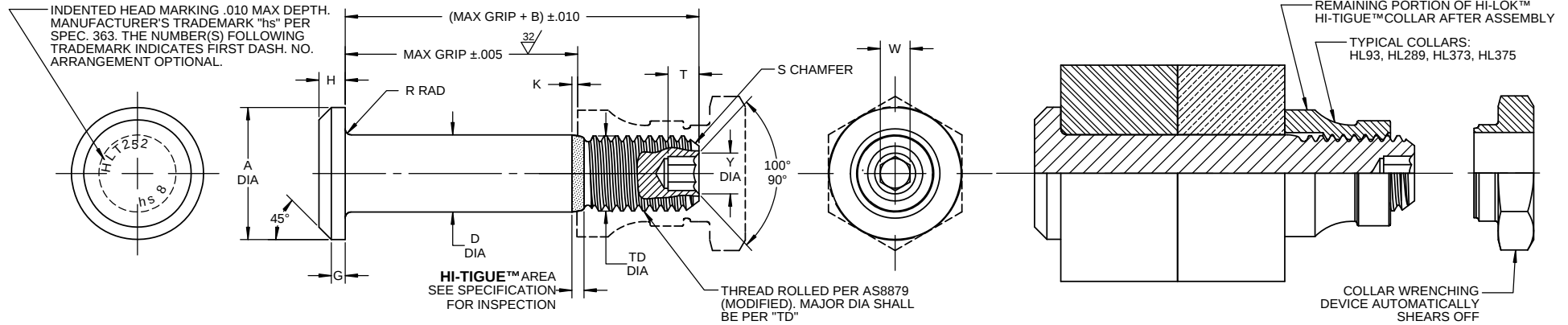


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HI-LOK™ HI-TIGUE™ PIN

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 HLT152()6(-)											
6	7/32	.390 .370	.360	.2182 .2177	.1840 .1810	.035	.074 .064	.016	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	9,400	4,350
8	9/32	.460 .435	.435	.2807 .2802	.2440 .2410	.045	.090 .080	.021	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	15,500	7,750
10	11/32	.520 .490	.545	.3432 .3427	.3060 .3020	.055	.112 .102	.026	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	23,200	12,300
12	13/32	.620 .550	.590	.4057 .4052	.3680 .3640	.075	.140 .130	.030	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	32,400	19,100
14	15/32	.695 .615	.690	.4682 .4677	.4310 .4260	.095	.160 .150	.035	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	43,100	25,800
16	17/32	.790 .740	.740	.5307 .5302	.4930 .4880	.095	.188 .178	.039	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	55,400	34,300

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 2. Dimensions are in inches and to be met before finish.
 3. Surface texture per ASME B46.1.
 4. Hole preparation per NAS618.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HLT252 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

MATERIAL: PH13-8Mo stainless steel per AMS5629.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: HLT252(-)(-) = Passivate per Hi-Shear Spec. 262, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT252DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT252TB(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT252YB(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, white paint on head, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT252YC(-)(-) = Solid film lube per AS5272, Type I, white paint on head, and cetyl alcohol lube per Hi-Shear Spec. 305.
© HLT252HK(-)(-) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

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

HOW TO ORDER

© **EXAMPLE:** Pin Part Number HLT252TB8-8
8/16 or 1/2 Maximum Grip Length
Replaces 8/32 or 1/4 Nominal Diameter Pin
Finish Code
Pin Basic Part Number

"HI-LOK", "HI-TIGUE", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY D.P.S.	DATE 1977-06-08	TITLE HI-LOK™ HI-TIGUE™ PIN PROTRUDING TENSION HEAD PH13-8Mo STAINLESS STEEL 1/16 GRIP VARIATION, 1/32 OVERSIZE	
APPROVED R.TING	DATE 1977-06-08	DRAWING NUMBER HLT252	
REVISION 6	DATE M.BEARD 2017-05-03	1 OF 1	