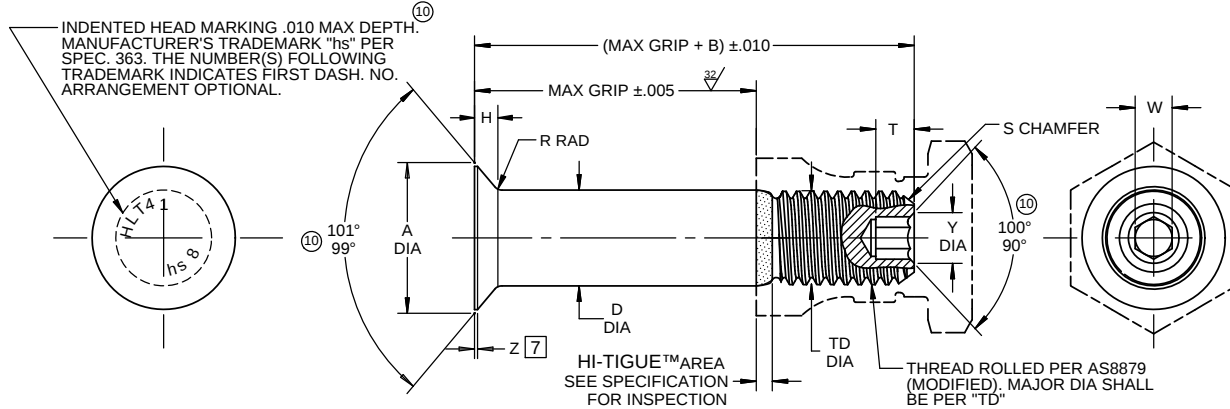
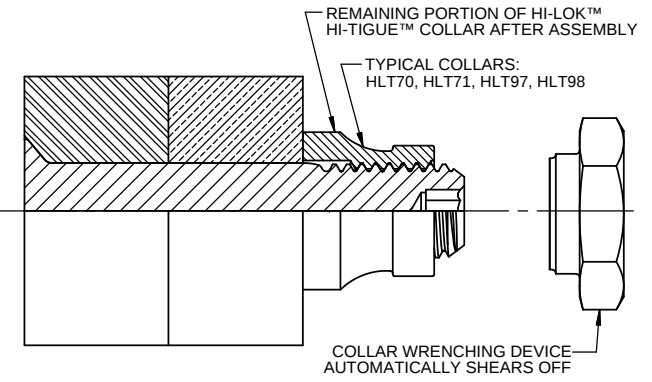




HI-LOK™ HI-TIGUE™ PIN



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	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING PLATING OR S.F.L.	AFTER COATING PLATING OR S.F.L.								W HEX	T DEPTH	Y DIA		
5	5/32	.2612 .2564	.312	.1640 .1635	.1640 .1630	.1595 .1570	.004	.0408 .0388	.025 .015	.010	1/32 x 45°	.1640-32 UNJC-3A	.0645 .0635	.100 .080	.090 .075	4,010	1,290
6	3/16	.3016 .2966	.325	.1895 .1890	.1895 .1885	.1840 .1810	.005	.0470 .0449	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	5,380	2,000
8	1/4	.3948 .3898	.395	.2495 .2490	.2495 .2485	.2440 .2410	.006	.0610 .0589	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	9,300	3,700
10	5/16	.4739 .4689	.500	.3120 .3115	.3120 .3110	.3060 .3020	.007	.0679 .0658	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	14,600	5,000
12	3/8	.5604 .5554	.545	.3745 .3740	.3745 .3735	.3680 .3640	.008	.0780 .0759	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	21,000	7,200
14	7/16	.6680 .6620	.635	.4370 .4365	.4370 .4360	.4310 .4260	.009	.0969 .0944	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	28,600	10,000
16	1/2	.7540 .7480	.685	.4995 .4990	.4995 .4985	.4930 .4880	.010	.1068 .1043	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	37,300	13,500
18	9/16	.8380 .8310	.770	.5615 .5610	.5615 .5605	.5550 .5500	.010	.1160 .1130	.050 .040	.022	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	47,200	17,000

- 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.
 - Surface texture per ASME B46.1.
 - Hole preparation per NAS618.
 - Dimensions are in inches and to be met after finish.
 - Curved or flat edge manufacturer's option.
 - Use HLT141 for oversize replacement.

MATERIAL: A-286 high temperature alloy per AMS5731 or AMS5737.

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

- FINISH:**
- HLT41(-)(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT41PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT41TB(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT41TC(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, except top surface of head shall be uncoated, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT41HK(-)(-) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

SPECIFICATION: HI-LOK™ HI-TIGUE™ Product Specification 342 and 342-2.

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

HOW TO ORDER

EXAMPLE:

Pin Part Number
HLT41TB8-8
8/16 or 1/2 Maximum Grip Length
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 VAN	DATE 1971-01-11	TITLE HI-LOK™ HI-TIGUE™ PIN 100° FLUSH SHEAR HEAD A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION
APPROVED JGWILCOX	DATE 1971-01-12	
REVISION 10	DATE M.BEARD 2017-06-01	DRAWING NUMBER HLT41