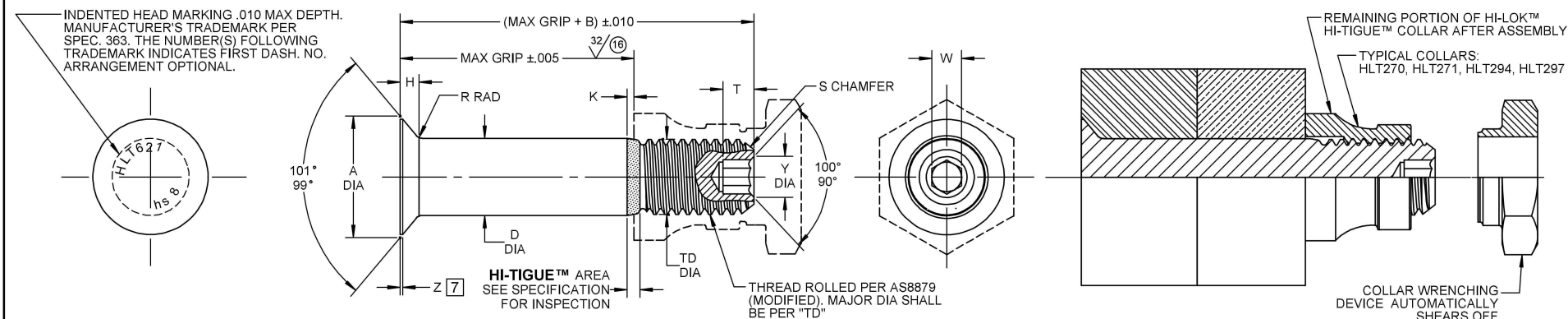




HI-LOK™ HI-TIGUE™ PIN

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

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

1

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	F REF	H	K REF	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING, PLATING, OR SOLID FILM	AFTER COATING, PLATING, OR SOLID FILM									W HEX	T DEPTH	Y DIA		
5							NOTE: USE HLT421()6(-)											
6	13/64	.3016 .2966	.360	.2026 .2021	.2026 .2016	.1840 .1810	.005	.0415 .0394	.016	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	8,100	2,600
8	17/64	.3948 .3898	.435	.2651 .2646	.2651 .2641	.2440 .2410	.006	.0544 .0523	.021	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	13,800	4,400
10	21/64	.4894 .4844	.545	.3276 .3271	.3276 .3266	.3060 .3020	.007	.0679 .0658	.026	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	21,100	7,000
12	25/64	.5760 .5710	.590	.3901 .3896	.3901 .3891	.3680 .3640	.008	.0780 .0759	.030	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	30,000	10,000
14	29/64	.6680 .6620	.690	.4526 .4521	.4526 .4516	.4310 .4260	.009	.0904 .0879	.035	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	40,300	13,500
16	33/64	.7540 .7480	.740	.5151 .5146	.5151 .5141	.4930 .4880	.010	.1002 .0977	.039	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	52,500	18,000
18	37/64	.8380 .8310	.825	.5771 .5766	.5771 .5761	.5550 .5500	.010	.1094 .1065	.039	.050 .040	.022	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	65,600	22,500
20	41/64	.9250 .9180	.890	.6396 .6391	.6396 .6386	.6180 .6120	.010	.1197 .1168	.044	.050 .040	.022	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	80,600	27,000
24	45/64	1.0970 1.0850	1.115	.7646 .7641	.7646 .7636	.7430 .7370	.012	.1394 .1344	.044	.050 .040	.022	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	115,000	37,300

"HI-LOK", "HI-TIGUE", AND "HI-KOTE",
ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY
J.F.OBISPO

DATE
2014-08-06

S.GRAPHICS

1983-06-02

APPROVED
R.TING

DATE
1983-06-06

REVISION
16

DATE
K. PHAM
2022-03-08

TITLE
HI-LOK™ HI-TIGUE™ PIN
100° FLUSH SHEAR HEAD
NICKEL BASE ALLOY (INCONEL 718)
1/16 GRIP VARIATION, 1/64 OVERSIZE

DRAWING NUMBER
HLT621

1 OF 2

- GENERAL NOTES:**
- 1 Head edge out of roundness shall not exceed "F".
 - 2 Concentricity: Conical surface of head to "D" diameter within .003 FIM.
 - 3 Dimensions are in inches and to be met after finish.
 - 4 Surface texture per ASME B46.1.
 - 5 Hole preparation per NAS618.
 - 6 "H" is dimensioned from maximum "D" diameter
 - 7 Curved or flat edge manufacturer's option.
 - 8 Use HLT715 for oversize replacement.
 - 9 After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in UK and European Union.

MATERIAL: Nickel base alloy per AMS5662.

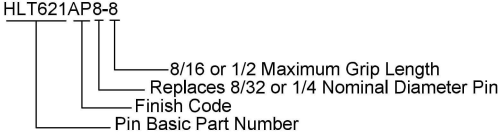
HEAT TREAT: 125,000 psi shear minimum (210,000 psi tensile minimum).

- FINISH:**
- HLT621(-)(-) = Passivate per AMS2700, Method 1, Type 8, Class 1, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 9 HLT621AP(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT621DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT621FB(-)(-) = Grit blast top of head, passivate per AMS2700, Method 1, Type 8, Class 1, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT621FF(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, with color red on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT621FJ(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, with color red on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT621MA(-)(-) = Solid film lube per KAL-GARD™ RA.
 - HLT621PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT621SK(-)(-) = Grit blast top of head, passivate per AMS2700, Method 1, Type 8, Class 1, with color brown on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT621TB(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT621NKJ(-)(-) = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 with color silver on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT621NKL(-)(-) = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only, with color silver on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT621HK(-)(-) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HLT621 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

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

HOW TO ORDER
EXAMPLE: Pin Part Number



HLT621

DRAWING NUMBER

HLT621

2 OF 2