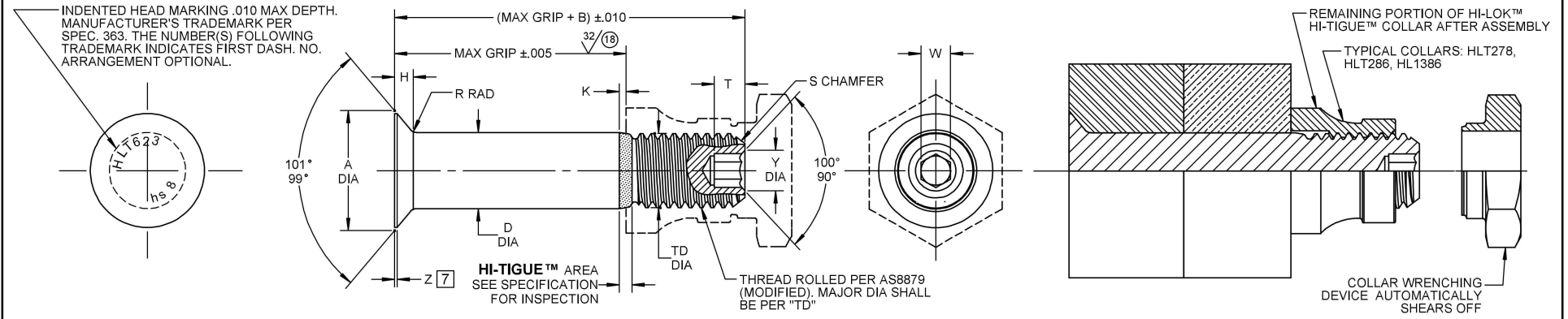




HI-LOK™ HI-TIGUE™ PIN

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

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 HLT423()6-()											
6	13/64	.3813 .3765	.360	.2026 .2021	.2026 .2016	.1840 .1810	.005	.0750 .0730	.016	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	8,100	4,350
8	17/64	.5066 .5018	.435	.2651 .2646	.2651 .2641	.2440 .2410	.006	.1013 .0993	.021	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	13,800	7,750
10	21/64	.6335 .6287	.545	.3276 .3271	.3276 .3266	.3060 .3020	.007	.1283 .1263	.026	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	21,100	12,300
12	25/64	.7604 .7556	.590	.3901 .3896	.3901 .3891	.3680 .3640	.008	.1553 .1533	.030	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	30,000	19,100
14	29/64	.8884 .8812	.690	.4526 .4521	.4526 .4516	.4310 .4260	.009	.1828 .1798	.035	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	40,300	25,800
16	33/64	1.0139 1.0068	.740	.5151 .5146	.5151 .5141	.4930 .4880	.010	.2093 .2063	.039	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	52,500	34,300
18	37/64	1.1408 1.1337	.825	.5771 .5766	.5771 .5761	.5550 .5500	.010	.2365 .2335	.039	.050 .040	.025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	65,600	43,500
20	41/64	1.2723 1.2651	.890	.6396 .6391	.6396 .6386	.6180 .6120	.010	.2654 .2624	.044	.050 .040	.025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	80,600	54,600
24	45/64	1.5308 1.5236	1.115	.7646 .7641	.7646 .7641	.7430 .7370	.012	.3214 .3184	.044	.050 .040	.025	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	115,000	79,200

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

HLT623

"HI-LOK", "HI-TIGUE", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY S.GRAPHICS	DATE 1983-04-22	TITLE HI-LOK™ HI-TIGUE™ PIN 100° FLUSH MS24694 TENSION HEAD NICKEL BASED ALLOY (INCONEL 718) 1/16 GRIP VARIATION, 1/64 OVERSIZE	
APPROVED R.TING	DATE 1983-06-06		
REVISION (18)	DATE K. PHAM 2022-03-08	DRAWING NUMBER HLT623	

- 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 HLT717 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).

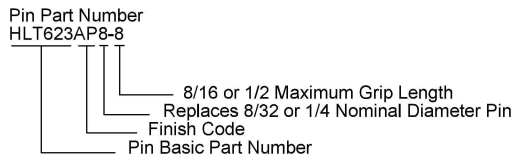
- FINISH:**
- HLT623(-)(-) = Passivate per AMS2700, Method 1, Type 8, Class 1, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 9 HLT623AP(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT623DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT623FB(-)(-) = Grit blast top of head, passivate per AMS2700, Method 1, Type 8, Class 1, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 9 HLT623GM(-)(-) = Passivate per AMS2700, Method 1, Type 8, Class 1. HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads (no overspray on the shank is allowed) and top of head only (.005 max overspray on the head bearing surface permissible) with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT623MA(-)(-) = Solid film lube per KAL-GARD™ RA.
 - HLT623PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT623SD(-)(-) = Grit blast top of head, passivate per AMS2700, Method 1, Type 8, Class 1, with color yellow on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT623SG(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, with color yellow on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT623TB(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT623NKJ(-)(-) = 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.
 - HLT623NKL(-)(-) = 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.
 - HLT623HK(-)(-) = 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 HLT623 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:



HLT623

DRAWING NUMBER

HLT623

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