lisi AEROSPACE
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR Corporation, USA
a LISI AEROSPACE Company

Design Holder

CAGE No. 73197

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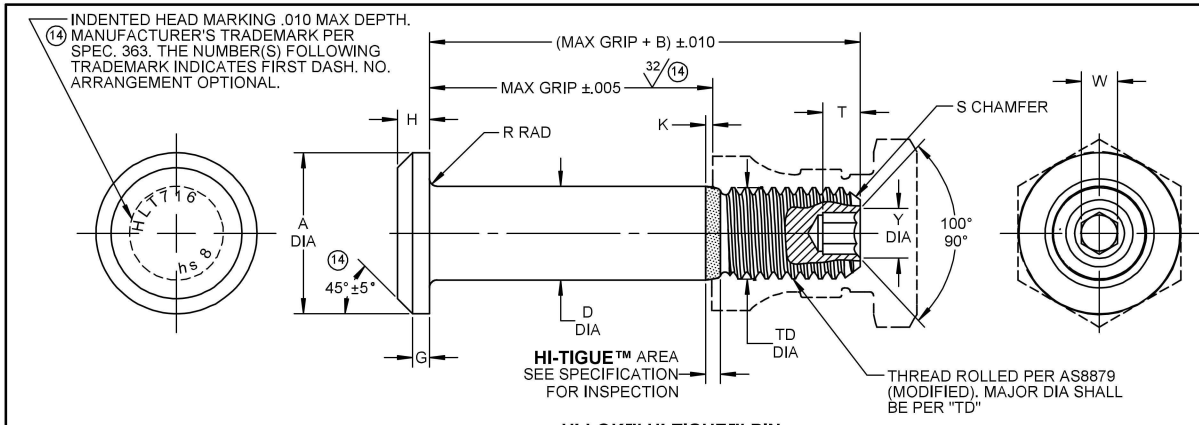
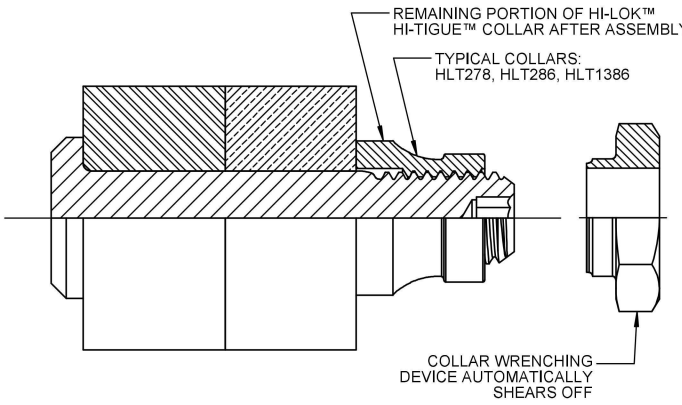


HI-LOK™ HI-TIGUE™ PIN



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

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA WITHOUT PLATING, S.F.L. OR COATING	D DIA WITH PLATING, S.F.L. OR COATING	TD DIA	G REF	H	K REF	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET W HEX	SOCKET T DEPTH	SOCKET Y DIA	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
5							NOTE: USE HLT622( )6-( )										
6	7/32	.390 .370	.360	.2182 .2177	.2182 .2172	.1840 .1810	.035	.074 .064	.016	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	9,400	4,350
8	9/32	.460 .435	.435	.2807 .2802	.2807 .2797	.2440 .2410	.045	.090 .080	.021	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	15,500	7,750
10	11/32	.520 .490	.545	.3432 .3427	.3432 .3422	.3060 .3020	.055	.112 .102	.026	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	23,200	12,300
12	13/32	.620 .585	.590	.4057 .4052	.4057 .4047	.3680 .3640	.075	.140 .130	.030	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	32,400	19,100
14	15/32	.695 .660	.690	.4682 .4677	.4682 .4672	.4310 .4260	.095	.160 .150	.035	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	43,100	25,800
16	17/32	.790 .755	.740	.5307 .5302	.5307 .5297	.4930 .4880	.095	.188 .178	.039	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	55,400	34,300
18	19/32	.900 .865	.825	.5927 .5922	.5927 .5917	.5550 .5500	.125	.210 .200	.039	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	69,200	43,500
20	21/32	.970 .935	.890	.6552 .6547	.6552 .6542	.6180 .6120	.175	.265 .255	.044	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	84,500	54,600
24	25/32	1.185 1.145	1.115	.7802 .7797	.7802 .7792	.7430 .7370	.200	.335 .320	.044	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	120,000	79,200

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

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

DRAWN BY	DATE
D.P.S.	1983-06-02
APPROVED	DATE
R.TING	1983-06-08
REVISION	DATE
(14)	K. PHAM 2022-03-08

TITLE
HI-LOK™ HI-TIGUE™ PIN
PROTRUDING TENSION HEAD
NICKEL BASE ALLOY (INCONEL 718)
1/16 GRIP VARIATION, 1/32 OVERSIZE

DRAWING NUMBER
HLT716

HLT716

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2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

GENERAL NOTES:
1. Concentricity: "A" to "D" diameter within .010 FIM.
2. Dimensions are in inches and to be met after finish.
3. Surface texture per ASME B46.1.
4. Hole preparation per NAS618.
5. Oversize replacement for HLT422 and HLT622.

(14) [6] 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:

(14) HLT716-( )-( ) = Passivate per AMS2700, Method 1, Type 8, Class 1, and cetyl alcohol lube per Hi-Shear Spec. 305.

(14) [6] HLT716AP( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

HLT716DL( )-( ) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.

HLT716PB( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

(14) HLT716SC( )-( ) = Grit blast top of head, passivate per AMS2700, Method 1, Type 8, Class 1, with color green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

(14) HLT716FB( )-( ) = Grit blast top of head, passivate per AMS2700, Method 1, Type 8, Class 1, and cetyl alcohol lube per Hi-Shear Spec. 305.

HLT716SE( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, with color green on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.

(14) HLT716SD( )-( ) = 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.

HLT716SG( )-( ) = 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.

HLT716TB( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.

HLT716MA( )-( ) = Solid film lube per KAL-GARD™ RA.

(14) HLT716GL( )-( ) = Passivate per AMS2700, Method 1, Type 8, Class 1. HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294 on threads only (no overspray is allowed on the shank) color code white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

HLT716NKJ( )-( ) = 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.

HLT716NKL( )-( ) = 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.

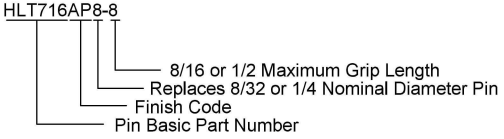
HLT716HK( )-( ) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

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

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HLT716 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER EXAMPLE:

Pin Part Number
HLT716AP8-8



HLT716

DRAWING NUMBER
HLT716