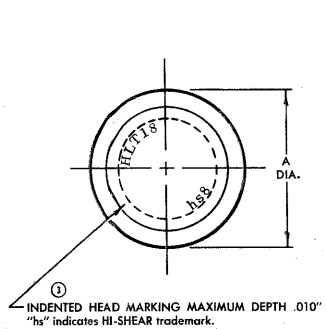
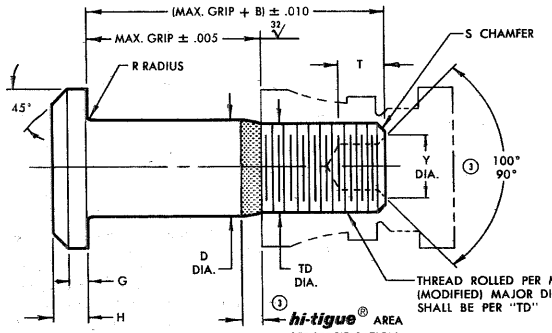
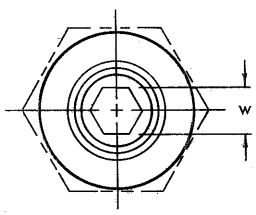
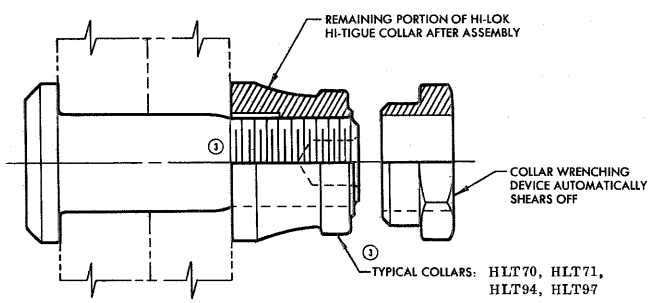



① INDENTED HEAD MARKING MAXIMUM DEPTH .010"
"hs" indicates HI-SHEAR trademark.
"VS" indicates VOI-SHAN trademark.
"SPS" indicates STANDARD PRESSED STEEL trademark.
The number(s) following the trademark indicate first dash number. Arrangement optional.




hi-lok® hi-tigue® PIN




hi-lok® hi-tigue® PIN AND COLLAR AFTER ASSEMBLY

| FIRST DASH NO. | NOM. DIA. | A DIA. | B REF. | D DIA. | TD DIA. | G | H | R RAD. | S CHAMFER REF. | THREAD | ① SOCKET W HEX. | ① SOCKET T DEPTH | ① SOCKET Y DIA. | ① DOUBLE SHEAR POUNDS MINIMUM | ① TENSION POUNDS MINIMUM | ①7 MIN. GRIP LENGTH |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| –5 | 5/32 | .262<br>.242 | .312 | .1695<br>.1685 | .1595<br>.1570 | .020 | .047<br>.037 | .025<br>.015 | 1/32" x 45° | 8-32UNJC-3A Modified | .0801<br>.0791 | .100<br>.080 | .104<br>.094 | 4,210 | 1,940 | -2 |
| –6 | 3/16 | .315<br>.295 | .325 | .1955<br>.1945 | .1840<br>.1810 | .025 | .055<br>.045 | .025<br>.015 | 1/32" x 45° | 10-32UNJF-3A Modified | .0806<br>.0791 | .100<br>.080 | .119<br>.104 | 5,550 | 2,500 | -2 |
| –8 | 1/4 | .412<br>.387 | .395 | .2555<br>.2545 | .2440<br>.2410 | .030 | .069<br>.059 | .025<br>.015 | 1/32" x 45° | 1/4-28UNJF-3A Modified | .0967<br>.0947 | .110<br>.090 | .142<br>.122 | 9,620 | 4,300 | -2 |
| –10 | 5/16 | .505<br>.475 | .500 | .3180<br>.3170 | .3060<br>.3020 | .035 | .078<br>.068 | .030<br>.020 | 3/64" x 45° | 5/16-24UNJF-3A Modified | .1295<br>.1270 | .130<br>.110 | .180<br>.160 | 14,890 | 6,300 | -2 |
| –12 | 3/8 | .600<br>.565 | .545 | .3805<br>.3795 | .3680<br>.3640 | .040 | .088<br>.078 | .030<br>.020 | 3/64" x 45° | 3/8-24UNJF-3A Modified | .1617<br>.1582 | .160<br>.140 | .217<br>.197 | 21,430 | 8,700 | -3 |
| –14 | 7/16 | .676<br>.641 | .635 | .4430<br>.4420 | .4310<br>.4260 | .045 | .105<br>.093 | .030<br>.020 | 3/64" x 45° | 7/16-20UNJF-3A Modified | .1930<br>.1895 | .190<br>.170 | .253<br>.233 | 29,000 | 12,100 | -4 |
| –16 | 1/2 | .770<br>.735 | .685 | .5055<br>.5045 | .4930<br>.4880 | .050 | .116<br>.103 | .030<br>.020 | 3/64" x 45° | 1/2-20UNJF-3A Modified | .2242<br>.2207 | .220<br>.200 | .289<br>.269 | 37,900 | 15,300 | -4 |
| | | | | | | | | | | | | | | | | |
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① SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH.

GENERAL NOTES:
1. Concentricity: Head to "D" diameter within .010 FIR.
2. Dimensions to be met after plating.
① 3. Surface texture per ANSI B46.1.
4. Hole preparation per NAS618 (Column "B") for interference application.
5. Use HLT118 for oversize replacement.
6. Install per Hi-Shear Spec. 299.
① 7. Minimum required for head and Hi-Tigue feature.

MATERIAL: Alloy steel per Spec. MIL-S-5000, MIL-S-5626 or MIL-S-6049.

HEAT TREAT: 95,000 psi shear minimum (160,000–180,000 psi tensile per Spec. MIL-H-6875).

① FINISH: HLT18-( )-( ) = Cadmium plate per Spec. QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

① SPECIFICATION: Hi-Lok Hi-Tigue Product Specification 342.

CODE: First dash number indicates nominal diameter in 32nds.
Second dash number indicates maximum grip in 16ths.

HOW TO ORDER
EXAMPLES: Pin Part Number Only
HLT18-8-8
- 8/16 or 1/2 Maximum Grip Length
- 8/32 or 1/4 Nominal Diameter Pin
- Pin Part Number

Pin and Collar Assembly Part Number Combination
HLT1870-8-8
- Size and Grip Length, See Above Example
- Collar Part Number
- Pin Part Number

① U.S. patents 3,138,987; 3,390,906; 3,578,367; and foreign patents. "Hi-Lok," "HL," "Hi-Tigue," and "HLT" are Registered Trademarks of Hi-Shear Corporation.

| DRAWN | DATE | hi-lok® hi-tigue® PIN |
|---|---|---|
| VAN | 10-4-68 | PROTRUDING SHEAR HEAD ALLOY STEEL 1/16" GRIP VARIATION |
| APPROVED | DATE | |
| POLIVKA | 10-8-68 | |
| REVISION ③ | DATE D.P.S. 3-3-81 | DRAWING NUMBER HLT18 |

HLT18

2-1597