

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		TD DIA	F	H	K REF	R RAD.	Z MAX.	S CHAMFER REF	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT PLATING S.F.L. OR COATING	WITH PLATING S.F.L. OR COATING									W HEX	T DEPTH	Y DIA		
5	5/32	.3304 .3256	.312	.1635 .1630	.1635 .1625	.1595 .1570	.004	.0700 .0680	.013	.025 .015	.012	1/32" x 45°	8-32UNJC-3A Modified	.0801 .0791	.100 .080	8	5,280	2,490
6	3/16	.3813 .3765	.325	.1895 .1890	.1895 .1885	.1840 .1810	.005	.0805 .0785	.016	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	7,060	4,350
8	1/4	.5066 .5018	.395	.2495 .2490	.2495 .2485	.2440 .2410	.006	.1080 .1060	.021	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	12,260	7,750
10	5/16	.6335 .6287	.500	.3120 .3115	.3120 .3110	.3060 .3020	.007	.1350 .1330	.026	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	19,160	12,300
12	3/8	.7604 .7556	.545	.3745 .3740	.3745 .3735	.3680 .3640	.008	.1620 .1600	.030	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	27,600	19,100
14	7/16	.8884 .8812	.635	.4370 .4365	.4370 .4360	.4310 .4260	.009	.1895 .1865	.035	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	37,500	25,800
16	1/2	1.0139 1.0068	.685	.4995 .4990	.4995 .4985	.4930 .4880	.010	.2160 .2130	.039	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	49,100	34,300
18	9/16	1.1408 1.1337	.770	.5615 .5610	.5615 .5605	.5550 .5500	.010	.2430 .2400	.039	.050 .040	.025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	62,100	43,500
20	5/8	1.2723 1.2651	.825	.6240 .6235	.6240 .6230	.6180 .6120	.010	.2720 .2690	.044	.050 .040	.025	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	76,700	54,600
24	3/4	1.5308 1.5236	1.050	.7490 .7485	.7490 .7480	.7430 .7370	.012	.3280 .3250	.044	.050 .040	.025	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.330 .300	.398 .378	110,400	79,200

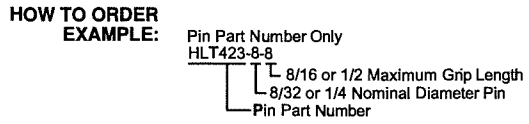
SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH.

- 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.
 - Dimensions to be met after finish.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - Curved or flat edge manufacturer's option.
 - Evidence of broken edge across points.
 - Use HLT623 for oversize replacement.

- MATERIAL:** Nickel base alloy per AMS5662.
HEAT TREAT: 125,000 psi shear minimum (210,000 psi tensile minimum).
FINISH:
- HLT423(-)(-) = Grit blast top of head, passivate per Hi-Shear Spec. 258, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT423AP(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT423DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT423PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT423PZ(-)(-) = Passivate per Hi-Shear Spec 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT423SC(-)(-) = Grit blast top of head, passivate per Hi-Shear Spec. 258, with color green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

- HLT423SE(-)(-) = Hi-Kote 2 solid film per Hi-Shear Spec. 292, with color green on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT423TB(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT423MA(-)(-) = Solid film lube per Kal-Gard RA.
- HLT423GM(-)(-) = Passivate per Hi-Shear Spec. 258. Hi-Kote 1 aluminum 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.

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



"Hi-Lok", "HL", Hi-Tigue, and "HLT" are internationally registered trademark of Hi-Shear Corporation.		
DRAWN	DATE	TITLE
D.P.S.	4-22-83	HI-LOK® HI-TIGUE® PIN
APPROVED	DATE	100° FLUSH TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16" GRIP VARIATION
R. Ting	4-22-83	DRAWING NUMBER
REVISION	DATE	HLT423
16	LV 5-18-09	

HLT423