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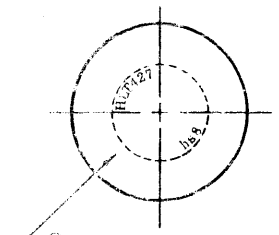
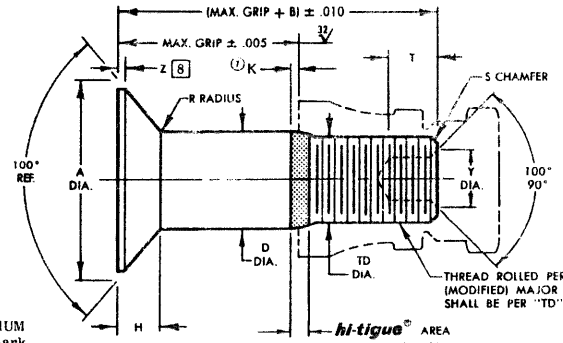
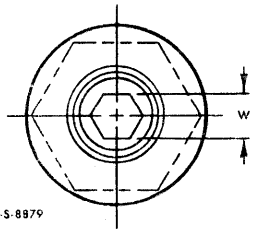
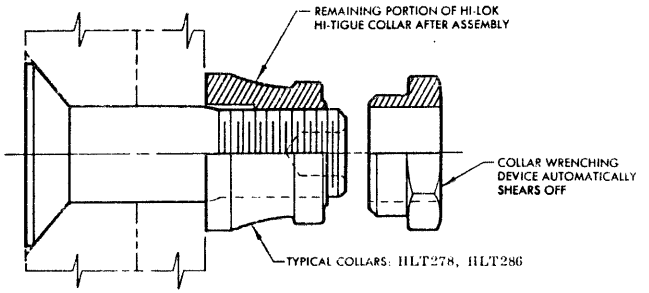


① INDENTED HEAD MARKING MAXIMUM DEPTH .010". Manufacturer's trademark per Hi-Shear Spec. 363. The number(s) following the trademark indicate first dash number. Arrangement optional.



hi-lok® hi-tigue® PIN





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

[1] [8]

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.		D DIA.	TD DIA.	F	H	K REF.	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET W HEX.	SOCKET T DEPTH	SOCKET Y DIA.	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
-5	3/16					NOTE: Use HL327-6												
-6	13/64	.3313 .3765	.360		.2026 .2016	.1840 .1810	.005	.0750 .0730	.020	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	6,130	2,750
-8	17/64	.5066 .5018	.435		.2651 .2641	.2440 .2410	.006	.1013 .0993	.025	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	10,490	5,820
-10	21/64	.6335 .6287	.545		.3276 .3266	.3060 .3020	.007	.1283 .1263	.031	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	16,000	9,200
-12	25/64	.7604 .7556	.590		.3901 .3891	.3680 .3640	.008	.1553 .1533	.037	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	22,700	14,000
-14	29/64	.8884 .8812	.690		.4526 .4516	.4310 .4260	.009	.1828 .1798	.039	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	30,600	18,900
-16	33/64	1.0139 1.0068	.740		.5151 .5141	.4930 .4880	.010	.2093 .2063	.045	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	39,600	25,500
-18	37/64	1.1408 1.1337	.825		.5771 .5761	.5550 .5500	.010	.2365 .2335	.043	.050 .040	.025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	49,700	32,400

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

GENERAL NOTES:
1. [1.] Head edge out of roundness shall not exceed "F."
2. Concentricity: Conical surface of head to "D" diameter within .005 FIR.
3. "H" is dimensioned from maximum "D" diameter.
4. Dimensions to be met after plating.
5. Surface texture per ANSI B46.1.
6. Hole preparation per NAS618.
7. Use HLT627 for oversize replacement.
8. [8.] Curved or flat edge manufacturer's option.

① CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HLT427 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See "Finish" note for explanation of code letters.

HOW TO ORDER EXAMPLES:

Pin Part Number Only
HLT427-8-8
- 8/16 or 1/2 Maximum Grip Length
- Replaces 8/32 or 1/4 Nominal Diameter Pin
- Pin Part Number

Pin and Collar Assembly Part Number Combination
HLT427286-8-8
- Size and Grip Length, See Above Example
- Collar Part Number
- Pin Part Number

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

HEAT TREAT: 160,000—180,000 psi tensile per Spec. MIL-H-6875.

FINISH: HLT427-( )-( ) = Cadmium plate per Spec. QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT427TB-( )-( ) = Cadmium plate per QQ-P-416, Type II, Class 2; Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.

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

U.S. Patent 3,578,367 and international patents. "HL", "Hi-Lok", "HLT", and "Hi-Tigue" are internationally registered trademarks of Hi-Shear Corporation.

DRAWN	DATE	hi-lok® hi-tigue® PIN
Van	6-21-69	100° FLUSH MS24694 TENSION HEAD
APPROVED	DATE	ALLOY STEEL
V. Miller	6-24-69	1/16" GRIP VARIATION — 1/64" OVERSIZE
REVISION ⑦	DATE D.P.S. 11-3-87	DRAWING NUMBER HLT427

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CODE IDENTIFICATION NO. 73197