



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

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			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT SOLID FILM LUBE	WITH SOLID FILM LUBE									W HEX.	T DEPTH	Y DIA.		
-5	5/32	.3304	.312	.1640	.1640	.1595	.004	.0698	.013	.025	.010	1/32" x 45°	8-32UNJC-3A Modified	.0645	.100	.090	4,010	2,180
		.3256		.1635	.1630	.1570								.0635	.080	.075		
-6	3/16	.3813	.325	.1895	.1895	.1840	.005	.0805	.016	.030	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806	.100	.119	5,380	2,750
		.3765		.1890	.1885	.1810								.0791	.080	.104		
-8	1/4	.5066	.395	.2485	.2485	.2440	.006	.1080	.021	.030	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967	.110	.142	9,300	5,000
		.5018		.2490	.2485	.2410								.0947	.090	.122		
-10	5/16	.6335	.500	.3120	.3120	.3060	.007	.1350	.026	.040	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295	.130	.180	14,600	8,300
		.6287		.3115	.3110	.3020								.1270	.110	.160		
-12	3/8	.7604	.545	.3745	.3745	.3680	.008	.1620	.030	.040	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617	.160	.217	21,000	12,700
		.7556		.3740	.3735	.3640								.1582	.140	.197		
-14	7/16	.8884	.635	.4370	.4370	.4310	.009	.1895	.035	.050	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930	.190	.253	28,600	18,900
		.8812		.4365	.4360	.4260								.1895	.170	.233		
-16	1/2	1.0139	.685	.4995	.4995	.4930	.010	.2160	.039	.050	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2342	.220	.289	37,300	25,500
		1.0068		.4990	.4985	.4880								.2207	.200	.269		
-18	9/16	1.1408	.770	.5615	.5615	.5550	.010	.2430	.039	.060	.025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555	.260	.326	47,200	32,400
		1.1337		.5610	.5605	.5500								.2520	.240	.306		

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

- ① GENERAL NOTES:
- Head edge out of roundness shall not exceed "F."
  - Concentricity: Conical surface of head to "D" diameter within .005 FIR.
  - "H" is dimensioned from maximum "D" diameter.
  - Surface texture per ANSI B46.1.
  - Hole preparation per NAS618.
  - Use HLT143 for oversize replacement.
  - Curved or flat edge manufacturer's option.

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.

HOW TO ORDER  
EXAMPLES:

Pin Part Number Only  
HLT43-8-8  
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  
HLT4378-8-8  
Size and Grip Length, See Above Example  
Collar Part Number  
Pin Part Number

MATERIAL: A-286 high temperature alloy per AMS5731 or AMS5737.  
HEAT TREAT: 160,000 psi tension minimum (95,000 psi shear minimum) at 70°F.  
FINISH: HLT43-( )-( ) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.  
HLT43DL-( )-( ) = Solid film lube per MIL-L-8937 and cetyl alcohol lube per Hi-Shear Spec. 305.  
HLT43DU-( )-( ) = Solid film lube per MIL-L-8937.  
HLT43TC-( )-( ) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, except top surface of head shall be uncoated, and cetyl alcohol lube per Hi-Shear Spec. 305.  
SPECIFICATION: Hi-Lok Hi-Tigue Product Specification 342.

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