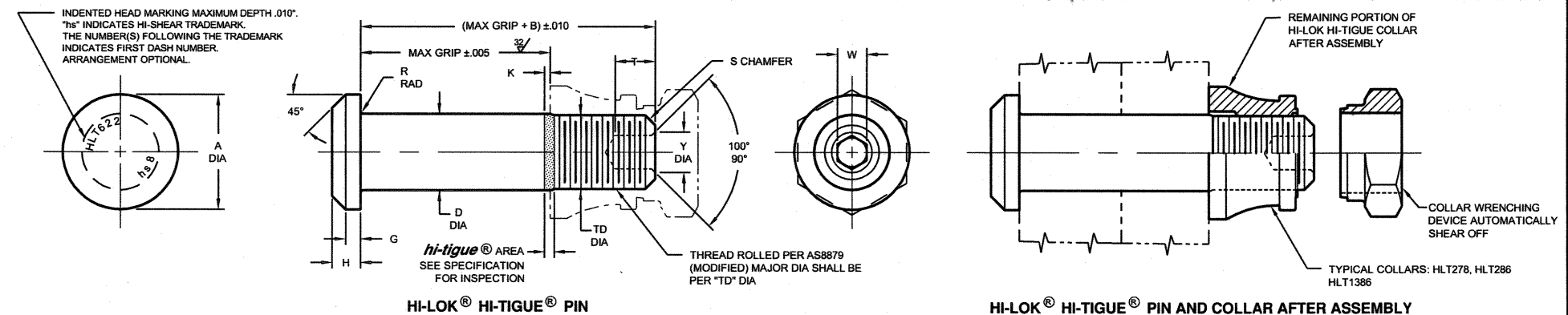


# STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197 a LISI AEROSPACE Company	BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE No. CLB88 a LISI AEROSPACE Company
AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A & Canada) CAGE No. 06725	HUCK S.A. France (Licensee - ECC Countries)
HUCK INTERNATIONAL, INC., U.S.A. (Licensee) CAGE No. 97928	BLANC AERO S.A. France (Licensee - ECC Countries)
SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878	a LISI AEROSPACE Company
FAIRCHILD Aerospace Fastener Division (Licensee) CAGE No. 92215	TOKYO SCREW COMPANY, Japan (Licensee - Japan)
WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516 (Pins & Steel Collars)	



FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	G REF	H	K REF	R RAD	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																	
NOTE: USE HLT422-6(-)																	
6	13/64		.360	.2026 .2021	.2026 .2016	.1840 .1810	.035	.074 .064	.016	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	8,100	4,350
8	17/64		.435	.2651 .2646	.2651 .2641	.2440 .2410	.045	.090 .080	.021	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	13,800	7,750
10	21/64		.545	.3276 .3271	.3276 .3266	.3060 .3020	.055	.112 .102	.026	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	21,100	12,300
12	25/64		.590	.3901 .3896	.3901 .3891	.3680 .3640	.075	.140 .130	.030	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	30,000	19,100
14	29/64		.690	.4526 .4521	.4526 .4516	.4310 .4260	.095	.160 .150	.035	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	40,300	25,800
16	33/64		.740	.5151 .5146	.5151 .5141	.4930 .4880	.095	.188 .178	.039	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	52,500	34,300
18	37/64		.825	.5771 .5766	.5771 .5761	.5550 .5500	.125	.210 .200	.039	.040 .025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	65,600	43,500
20	41/64		.890	.6396 .6391	.6396 .6386	.6180 .6120	.175	.265 .255	.044	.040 .025	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	80,600	54,600
24	49/64		1.115	.7646 .7641	.7646 .7636	.7430 .7370	.200	.335 .320	.044	.045 .030	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.330 .300	.398 .378	115,000	79,200

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

**GENERAL NOTES:**

1. Concentricity: "A" to "D" diameter within .010 FIM.
2. Dimensions to be met after finish.
3. Surface texture per ANSI B46.1.
4. Hole preparation per NAS618.
5. Use HLT716 for oversize replacement.

**MATERIAL:**

Nickel base alloy per AMS5662.

**HEAT TREAT:**

125,000 psi shear minimum (210,000 psi tensile minimum).

**FINISH:**

- HLT622-(-) = Passivate per Hi-Shear Spec. 258, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT622AP(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT622DL(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT622PB(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT622SC(-) = 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.
- HLT622FB(-) = Grit blast top of head, passivate per Hi-Shear Spec. 258, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT622SE(-) = 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.

**SPECIFICATION:**

- ⑬ HLT622SD(-) = Grit blast top of head, passivate per Hi-Shear Spec 258, with color yellow on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- ⑬ HLT622SG(-) = 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.
- HLT622TB(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT622MA(-) = Solid film lube per Kal-Gard RA.
- HLT622GL(-) = Passivate per Hi-Shear Spec. 258. Hi-Kote 1 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.

**HOW TO ORDER EXAMPLE:**

Pin Part Number Only  
 HLT622-8-8  
 | L 8/16 or 1/2 Maximum Grip Length  
 | Replaces 8/32 or 1/4 Nominal Diameter Pin  
 | Pin Part Number

"Hi-Lok" and "HL" are internationally registered trademark of Hi-Shear Corporation.		TITLE <b>HI-LOK® HI-TIGUE® PIN</b>	
DRAWN D.P.S.	DATE 6-2-83	PROTRUDING TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16" GRIP VARIATION, 1/64" OVERSIZE	
APPROVED R.Ting	DATE 6-6-83	DRAWING NUMBER <b>HLT622</b>	
REVISION ⑬	DATE JO 4-17-07		

HLT622