

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						NOTE: USE HLT423( )6(-)													
6	13/64	.3813 .3765	.360	.2026 .2021	.2026 .2016	.1840 .1810	.005	.0750 .0730	.016	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	8,100	4,350		
8	17/64	.5066 .5018	.435	.2651 .2646	.2651 .2641	.2440 .2410	.006	.1013 .0993	.021	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	13,800	7,750		
10	21/64	.6335 .6287	.545	.3276 .3271	.3276 .3266	.3060 .3020	.007	.1283 .1263	.026	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	21,100	12,300		
12	25/64	.7604 .7556	.590	.3901 .3896	.3901 .3891	.3680 .3640	.008	.1553 .1533	.030	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	30,000	19,100		
14	29/64	.8884 .8812	.690	.4526 .4521	.4526 .4516	.4310 .4260	.009	.1828 .1798	.035	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	40,300	25,800		
16	33/64	1.0139 1.0068	.740	.5151 .5146	.5151 .5141	.4930 .4880	.010	.2093 .2063	.039	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	52,500	34,300		
18	37/64	1.1408 1.1337	.825	.5771 .5766	.5771 .5761	.5550 .5500	.010	.2365 .2335	.039	.050 .040	.025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	65,600	43,500		
20	41/64	1.2723 1.2651	.890	.6396 .6391	.6396 .6386	.6180 .6120	.010	.2654 .2624	.044	.050 .040	.025	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	80,600	54,600		
24	49/64	1.5308 1.5236	1.115	.7646 .7641	.7646 .7636	.7430 .7370	.012	.3214 .3184	.044	.050 .040	.025	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:**

- 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.
- Dimensions to be met after finish.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- Curved or flat edge manufacturer's option.
- Use HLT717 for oversize replacement.

**MATERIAL:**

Nickel base alloy per AMS5662.

**HEAT TREAT:**

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

**FINISH:**

- HLT623(-)(-) = Passivate per Hi-Shear Spec. 258, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT623AP(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT623DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT623PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT623FB(-)(-) = Grit blast top of head, passivate per Hi-Shear Spec 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT623MA(-)(-) = Solid film lube per Kal-Gard RA.

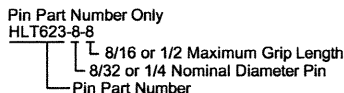
**SPECIFICATION:**

- HLT623SD(-)(-) = 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.
- HLT623SG(-)(-) = 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.
- HLT623TB(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT623GM(-)(-) = 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.

**CODE:**

Hi-Lok Hi-Tigue Product Specification 342.  
 First dash number indicates nominal diameter in 1/32nds of the pin which HLT623 oversize pin replaces.  
 Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

**HOW TO ORDER EXAMPLE:**



"Hi-Lok", "HL", Hi-Tigue, and "HLT" are internationally registered trademark of Hi-Shear Corporation.		TITLE <b>HI-LOK® HI-TIGUE® PIN</b>	
DRAWN S.Graphics	DATE 4-22-83	100° FLUSH MS24694 TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16" GRIP VARIATION, 1/64" OVERSIZE	
APPROVED R.Ting	DATE 6-6-83	DRAWING NUMBER <b>HLT623</b>	
REVISION ⑬	DATE J.F. Obispo 2-22-07		