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

2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

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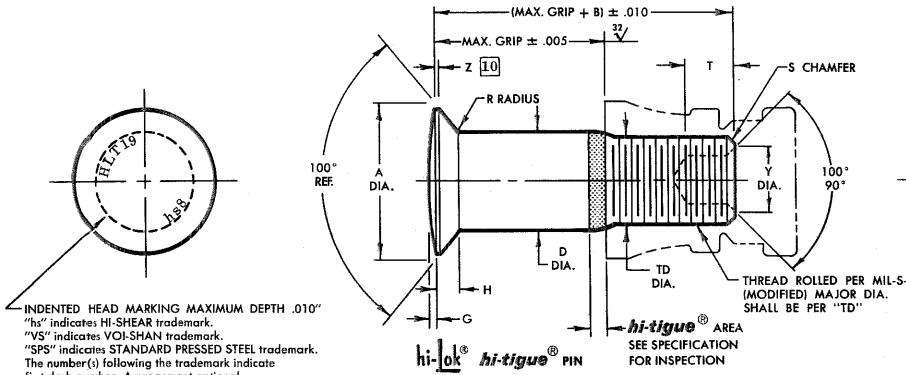
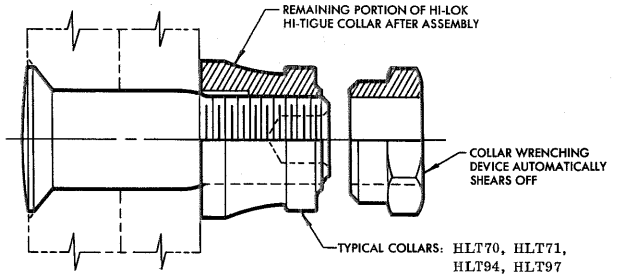


hi-lok® hi-tigue® PIN



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

[1] [10] [9]

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.	TD DIA.	F	G	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET W HEX.	SOCKET T DEPTH	SOCKET Y DIA.	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	MIN. GRIP LENGTH
–5	5/32	.2612 .2564	.312	.1695 .1685	.1595 .1570	.004	.0070 .0040	.0385 .0365	.025 .015	.010	1/32" x 45°	8-32UNJC-3A Modified	.0801 .0791	.100 .080	.104 .094	4,210	1,290	-2
–6	3/16	.3016 .2966	.325	.1955 .1945	.1840 .1810	.005	.0080 .0050	.0445 .0424	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	5,550	2,000	-3
–8	1/4	.3948 .3898	.395	.2555 .2545	.2440 .2410	.006	.0100 .0070	.0586 .0563	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	9,620	3,700	-3
–10	5/16	.4739 .4689	.500	.3180 .3170	.3060 .3020	.007	.0110 .0080	.0654 .0633	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .130	.180 .160	14,890	5,000	-3
–12	3/8	.5604 .5554	.545	.3805 .3795	.3680 .3640	.008	.0125 .0095	.0755 .0734	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	21,430	7,200	-4
–14	7/16	.6680 .6620	.635	.4430 .4420	.4310 .4260	.009	.0150 .0120	.0944 .0919	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	29,000	10,000	-5
–16	1/2	.7540 .7480	.685	.5055 .5045	.4930 .4880	.010	.0165 .0135	.1042 .1017	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	37,900	13,500	-5

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

⑤ **GENERAL NOTES:**
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 finish.
5. Surface texture per ANSI B46.1.
6. Hole preparation per NAS618 (Column "B") for interference application.
7. Use HLT119 for oversize replacement.
8. Install per Hi-Shear Specification 299.
9. Minimum required for head and Hi-Tigue feature.
10. Curved or flat edge manufacturer's option.

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

HEAT TREAT: 95,000 psi shear minimum (160,000 - 180,000 psi tensile per Spec. MIL-H-6875).

⑤ **FINISH:**
HLT19-( )-( ) = Cadmium plate per Spec. QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT19BJ-( )-( ) = I.V.D. aluminum coating per MIL-C-83488, Type II, Class 3, 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.

HOW TO ORDER EXAMPLES:

Pin Part Number Only
HLT19-8-8
- 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
HLT1970-8-8
- Size and Grip Length, See Above Example
- Collar Part Number
- Pin Part Number

"HL", "Hi-Lok", "HLT" and "Hi-Tigue" are internationally registered trademarks of Hi-Shear Corporation

DRAWN	DATE	hi-lok® hi-tigue® PIN
VAN	10-4-68	100° FLUSH CROWN SHEAR HEAD ALLOY STEEL 1/16" GRIP VARIATION
APPROVED	DATE	
POLIVKA	10-8-68	
REVISION 5	DATE T.Craine 3-18-93	DRAWING NUMBER HLT19

HLT19

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