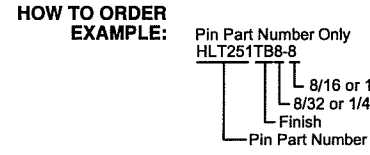


FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	F	G	H	K REF	R RAD	Z MAX	S CHAMFER REF	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
														W HEX	T DEPTH	Y DIA		
5	13/64					NOTE: USE HLT151-6-()												
6	7/32	.3304 .3253	.360	.2182 .2177	.1840 .1810	.005	.015 .010	.0470 .0449	.016	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	9,400	2,600
8	9/32	.4260 .4210	.435	.2807 .2802	.2440 .2410	.006	.015 .010	.0610 .0589	.021	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	15,500	4,400
10	11/32	.5051 .5001	.545	.3432 .3427	.3060 .3020	.007	.015 .010	.0679 .0658	.026	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	23,200	7,000
12	13/32	.5916 .5866	.590	.4057 .4052	.3680 .3640	.008	.015 .010	.0780 .0759	.030	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	32,400	10,000
14	15/32	.6992 .6932	.690	.4682 .4677	.4310 .4260	.009	.015 .010	.0969 .0944	.035	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	43,100	12,500
16	17/32	.7852 .7792	.740	.5307 .5302	.4930 .4880	.010	.015 .010	.1068 .1043	.039	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	55,400	18,000

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.
 - Surface texture per ANSI B46.1.
 - Dimensions to be met before finish, except threads. ③
 - Hole preparation per NAS618.
 - ⑦ Curved or flat edge manufacturer's option.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HLT251 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.



MATERIAL: PH13-8Mo stainless steel per AMS5629.
HEAT TREAT: 125,000 psi shear minimum.
FINISH: HLT251-()-() = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT251DL-()-() = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT251TB-()-() = 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.

"Hi-Lok", "HL", Hi-Tigue, and "HLT" are internationally registered trademark of Hi-Shear Corporation.		
DRAWN	DATE	TITLE
D.P.S.	6-8-77	HI-LOK® HI-TIGUE® PIN
APPROVED	DATE	100° FLUSH CROWN SHEAR HEAD PH13-8Mo STAINLESS STEEL 1/16" GRIP VARIATION, 1/32" OVERSIZE
R.Ting	6-8-77	
REVISION	DATE	DRAWING NUMBER
④	JO 1-7-13	HLT251

HLT251