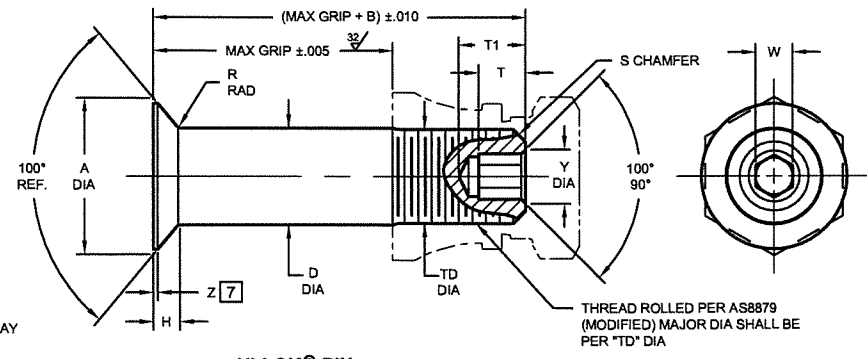
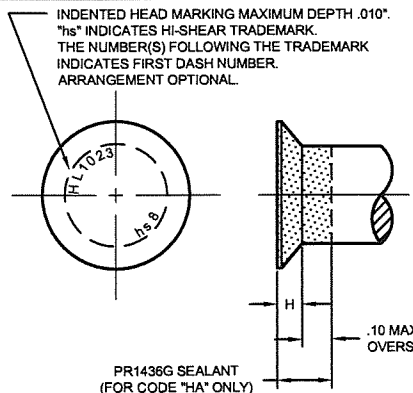
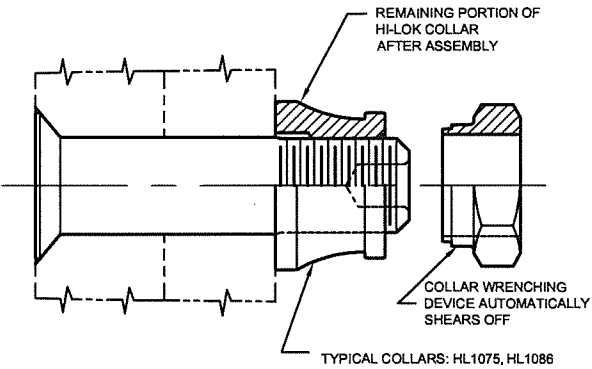


6



HI-LOK® PIN



HI-LOK® PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD	SOCKET				DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING	WITH COATING								W HEX	T DEPTH	T1 DEPTH MAX	Y DIA		
5																		
NOTE: USE HL1013-6(-)																		
6	13/64	.3813 .3765	.325	.2026 .2016	.2026 .2016	.1840 .1810	.005	.0750 .0730	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.140	.119 .104	6,130	3,180
8	17/64	.5066 .5018	.395	.2651 .2646	.2651 .2641	.2440 .2410	.006	.1013 .0993	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.160	.142 .122	10,490	5,820
10	21/64	.6335 .6287	.500	.3276 .3271	.3276 .3266	.3060 .3020	.007	.1283 .1263	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.200	.180 .160	16,000	9,200
12	25/64	.7604 .7556	.545	.3901 .3896	.3901 .3891	.3680 .3640	.008	.1553 .1533	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.235	.217 .197	22,700	14,000
14	29/64	.8884 .8812	.635	.4526 .4521	.4526 .4516	.4310 .4260	.009	.1828 .1798	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.280	.253 .233	30,600	18,900
16	33/64	1.0139 1.0068	.685	.5151 .5146	.5151 .5141	.4930 .4880	.010	.2093 .2063	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.320	.289 .269	39,600	25,600
18	37/64	1.1408 1.1337	.770	.5771 .5766	.5771 .5761	.5550 .5500	.010	.2365 .2335	.050 .040	.025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.360	.326 .306	49,700	32,400
20	41/64	1.2723 1.2651	.825	.6396 .6391	.6396 .6386	.6180 .6120	.010	.2654 .2624	.050 .040	.025	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.400	.326 .306	61,000	41,000
24	49/64	1.5308 1.5236	1.050	.7646 .7641	.7646 .7636	.7430 .7370	.012	.3214 .3184	.050 .040	.025	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.330 .300	.425	.398 .378	87,200	59,500

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

** The Double Shear values shown are based on cross sectional area for nominal diameter pin.

- GENERAL NOTES:**
- 1 Head edge out of roundness shall not exceed "F".
 - 2 Concentricity: Conical surface of head to "D" diameter within .003 FIM.
 - 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.
 - 7 Curved or flat edge manufacturer's option.
 - 8 Use HL1033 for oversize replacement.

MATERIAL: 6Al-4V titanium alloy per AMS4928 or AMS4967.

HEAT TREAT: 160,000 psi tensile minimum (95,000 psi shear minimum).

- FINISH:**
- HL1023(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL1023VF(-)(-) = Surface coating per Hi-Shear Spec. 306, Type I, color blue, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL1023AZ(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, with color black on the thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL1023HA(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, with color black on the thread end, and apply precoat No. PR1436G sealant (.002-.005 thick), and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL1023RA(-)(-) = Phosphate fluoride treat with color code red on the thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lok Product Specification 342.
CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL1023 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER EXAMPLE:

Pin Part Number Only
 HL1023AZ8-8

8/16 or 1/2 Maximum Grip Length
 Replaces 8/32 or 1/4 Nominal Diameter Pin
 Hi-Kote 1 and Cetyl Alcohol Lube Finish
 Pin Basic Part Number

DRAWN DATE		TITLE	
J.F.Obispo	3-22-95	HI-LOK® PIN	
APPROVED DATE		100° FLUSH MS24694 TENSION HEAD	
E.E.B.	3-23-95	TITANIUM, 1/64" OVERSIZE	
REVISION DATE		DRAWING NUMBER	
6	10-7-2010	HL1023	
		SHEET 1 OF 1	

HL1023