

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 HL1023-6(-)																		
6	7/32	.3813 .3765	.325	.2182 .2177	.2182 .2172	.1840 .1810	.005	.0684 .0664	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.140	.119 .104	7,100	3,180
8	9/32	.5066 .5018	.395	.2807 .2802	.2807 .2797	.2440 .2410	.006	.0948 .0928	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.160	.142 .122	11,800	5,820
10	11/32	.6335 .6287	.500	.3432 .3427	.3432 .3422	.3060 .3020	.007	.1218 .1198	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.200	.180 .160	17,600	9,200
12	13/32	.7604 .7556	.545	.4057 .4052	.4057 .4047	.3680 .3640	.008	.1488 .1468	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.235	.217 .197	24,600	14,000
14	15/32	.8884 .8812	.635	.4682 .4677	.4682 .4672	.4310 .4260	.009	.1763 .1733	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.280	.253 .233	32,700	18,900
16	17/32	1.0139 1.0068	.685	.5307 .5302	.5307 .5297	.4930 .4880	.010	.2027 .1997	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.320	.289 .269	42,000	25,600
18	19/32	1.1408 1.1337	.770	.5927 .5922	.5927 .5917	.5550 .5500	.010	.2300 .2270	.050 .040	.025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.360	.326 .306	52,400	32,400
20	21/32	1.2723 1.2651	.825	.6552 .6547	.6552 .6542	.6180 .6120	.010	.2589 .2559	.050 .040	.025	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.400	.326 .306	64,100	41,000
24	25/32	1.5308 1.5236	1.050	.7802 .7797	.7802 .7792	.7430 .7370	.012	.3149 .3119	.050 .040	.025	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.330 .300	.425	.398 .378	90,900	59,500

HI-LOK® PIN AND COLLAR AFTER ASSEMBLY

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:

- Head edge out of roundness shall not exceed "F".
- Concentricity: Conical surface of head to "D" diameter within .003 FIM.
- "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.
- Oversize replacement for HL1013 and HL1023.

MATERIAL:

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

HEAT TREAT:

160,000 psi tensile minimum (95,000 psi shear minimum).

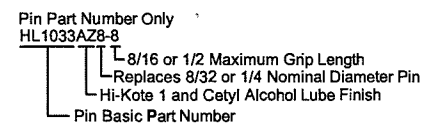
FINISH:

- HL1033(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
- HL1033VF(-)(-) = Surface coating per Hi-Shear Spec. 306, Type I, color blue, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL1033AZ(-)(-) = 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.
- HL1033HA(-)(-) = 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.
- HL1033RA(-)(-) = Phosphate fluoride treat with color code red on the thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION:
CODE:

Hi-Lok Product Specification 342.
 First dash number indicates nominal diameter in 1/32nds of the pin which HL1033 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

HOW TO ORDER EXAMPLE:



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, 1/32" OVERSIZE	
REVISION DATE		DRAWING NUMBER	
6	10-7-2010	HL1033	
		SHEET 1 OF 1	

HL1033