

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 OR PLATING	WITH COATING OR PLATING								W HEX	T DEPTH	Y DIA			
5	5/32	.2612	.312	.1635	.1635	.1595	.004	.0410	.025	.010	1/32" x 45°	8-32UNJC-3A Modified	.0801	.100	.080	5	5,280	1,700
		.2564		.1630	.1625	.1570		.0791					.080					
6	3/16	.3016	.325	.1895	.1895	.1840	.005	.0470	.030	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806	.100	.080	.119	7,060	2,600
		.2966		.1890	.1885	.1810		.0791					.104					
8	1/4	.3948	.395	.2495	.2495	.2440	.006	.0610	.030	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967	.110	.122	.142	12,260	4,400
		.3898		.2490	.2485	.2410		.0947					.090					
10	5/16	.4739	.500	.3120	.3120	.3060	.007	.0680	.040	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295	.130	.180	.160	19,160	7,000
		.4689		.3115	.3110	.3020		.1270					.110					
12	3/8	.5604	.545	.3745	.3745	.3680	.008	.0780	.040	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617	.160	.217	.197	27,600	10,000
		.5554		.3740	.3735	.3640		.1582					.140					
14	7/16	.6680	.635	.4370	.4370	.4310	.009	.0969	.050	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930	.190	.253	.233	37,500	13,500
		.6620		.4365	.4360	.4260		.1895					.170					
16	1/2	.7540	.685	.4995	.4995	.4930	.010	.1068	.050	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242	.220	.289	.269	49,100	18,000
		.7480		.4990	.4985	.4880		.2207					.200					

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 FIM.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions to be met after finish.
 - Evidence of broken edge across point.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - Curved or flat edge manufacturer's option.
 - Use HL937 for oversize replacement.

MATERIAL: Nickel base alloy per AMS5662.

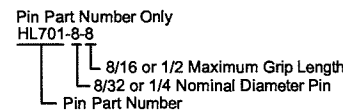
HEAT TREAT: 125,000 psi shear minimum (220,000 psi tensile minimum).

FINISH: HL701(-)(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
HL701AP(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
HL701JT(-)(-) = Passivate per Hi-Shear Spec. 258, with light blue identification on top of head, 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. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER EXAMPLE:



"Hi-Lok" and "HL" are internationally registered trademark of Hi-Shear Corporation.		
DRAWN	DATE	TITLE
D.P.S.	2-1-85	HI-LOK® PIN
APPROVED	DATE	100° FLUSH SHEAR HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16" GRIP VARIATION
JGW/lcox	2-185	
REVISION	DATE	DRAWING NUMBER
5	J.F.Obispo 4-21-2010	HL701