

HI-LOK® PIN

HI-LOK PIN® AND COLLAR AFTER ASSEMBLY

| FIRST DASH NO. | PIN NOM DIA | A DIA | B REF | D DIA | | TD DIA. | G REF | H | R RAD | S CHAMFER REF | THREAD | SOCKET | | | DOUBLE SHEAR POUNDS MINIMUM | TENSION POUNDS MINIMUM |
|----------------|-------------|-------|-------|----------------------------|-------------------------|---------|-------|------|-------|---------------|-------------------------|--------|---------|-------|-----------------------------|------------------------|
| | | | | WITHOUT PLATING OR COATING | WITH PLATING OR COATING | | | | | | | W HEX | T DEPTH | Y DIA | | |
| 5 | 5/32 | .262 | .312 | .1635 | .1635 | .1595 | .020 | .047 | .025 | 1/32" x 45° | 8-32UNJF-3A Modified | .0801 | .100 | 5 | 5,280 | 2,200 |
| | | .242 | | .1630 | .1625 | .1570 | | | | | | .0791 | .080 | | | |
| 6 | 3/16 | .315 | .325 | .1895 | .1895 | .1840 | .025 | .055 | .025 | 1/32" x 45° | 10-32UNJF-3A Modified | .0806 | .100 | .119 | 7,060 | 3,000 |
| | | .295 | | .1890 | .1885 | .1810 | | | | | | .0791 | .080 | | | |
| 8 | 1/4 | .412 | .395 | .2495 | .2495 | .2440 | .030 | .069 | .025 | 1/32" x 45° | 1/4-28UNJF-3A Modified | .0967 | .110 | .142 | 12,260 | 5,100 |
| | | .387 | | .2490 | .2485 | .2410 | | | | | | .0947 | .090 | | | |
| 10 | 5/16 | .505 | .500 | .3120 | .3120 | .3060 | .035 | .078 | .030 | 3/64" x 45° | 5/16-24UNJF-3A Modified | .1295 | .130 | .180 | 19,160 | 8,000 |
| | | .475 | | .3115 | .3110 | .3020 | | | | | | .1270 | .110 | | | |
| 12 | 3/8 | .600 | .545 | .3745 | .3745 | .3680 | .040 | .088 | .030 | 3/64" x 45° | 3/8-24UNJF-3A Modified | .1617 | .160 | .217 | 27,600 | 11,300 |
| | | .565 | | .3740 | .3735 | .3640 | | | | | | .1582 | .140 | | | |
| 14 | 7/16 | .676 | .635 | .4370 | .4370 | .4310 | .045 | .105 | .030 | 3/64" x 45° | 7/16-20UNJF-3A Modified | .1930 | .190 | .253 | 37,500 | 15,500 |
| | | .641 | | .4365 | .4360 | .4260 | | | | | | .1895 | .170 | | | |
| 16 | 1/2 | .770 | .685 | .4995 | .4995 | .4930 | .050 | .115 | .030 | 3/64" x 45° | 1/2-20UNJF-3A Modified | .2242 | .220 | .289 | 49,100 | 20,000 |
| | | .735 | | .4990 | .4985 | .4880 | | | | | | .2207 | .200 | | | |
| 18 | 9/16 | .864 | .770 | .5615 | .5615 | .5550 | .055 | .127 | .040 | 1/16" x 45° | 9/16-18UNJF-3A Modified | .2555 | .260 | .326 | 62,100 | 25,000 |
| | | .829 | | .5610 | .5605 | .5500 | | | | | | .2520 | .240 | | | |
| 20 | 5/8 | .953 | .825 | .6240 | .6240 | .6180 | .060 | .137 | .040 | 1/16" x 45° | 5/8-18UNJF-3A Modified | .2555 | .260 | .326 | 76,700 | 30,200 |
| | | .918 | | .6235 | .6230 | .6120 | | | | | | .2520 | .240 | | | |
| 24 | 3/4 | 1.108 | 1.050 | .7490 | .7490 | .7430 | .070 | .151 | .045 | 1/16" x 45° | 3/4-16UNJF-3A Modified | .3185 | .320 | .398 | 110,400 | 40,200 |
| | | 1.066 | | .7485 | .7480 | .7370 | | | | | | .3150 | .300 | | | |

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

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 2. Dimensions to be met after finish.
 3. Surface texture per ANSI B46.1.
 4. Hole preparation per NAS618.
 5. Evidence of broken edge across points.
 6. Use HL936 for oversize replacement.

MATERIAL: Nickel base alloy per AMS5662.

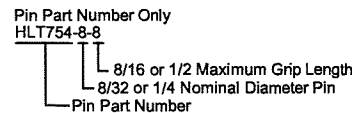
HEAT TREAT: 125,000 psi shear minimum (220,000 psi tensile minimum).

- FINISH:**
- HLT754(-)(-) = Passivate per Hi-Shear Spec. 258, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT754AP(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT754JT(-)(-) = 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:



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| "Hi-Lok", "HL", Hi-Tigue, and "HLT" are internationally registered trademark of Hi-Shear Corporation. | | |
| DRAWN | DATE | TITLE |
| D.P.S. | 3-4-83 | HI-LOK® PIN |
| APPROVED | DATE | PROTRUDING SHEAR HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16" GRIP VARIATION |
| R.Ting | 3-4-83 | |
| REVISION | DATE | DRAWING NUMBER |
| 7 | Jfobispo 4-21-10 | HL754 |