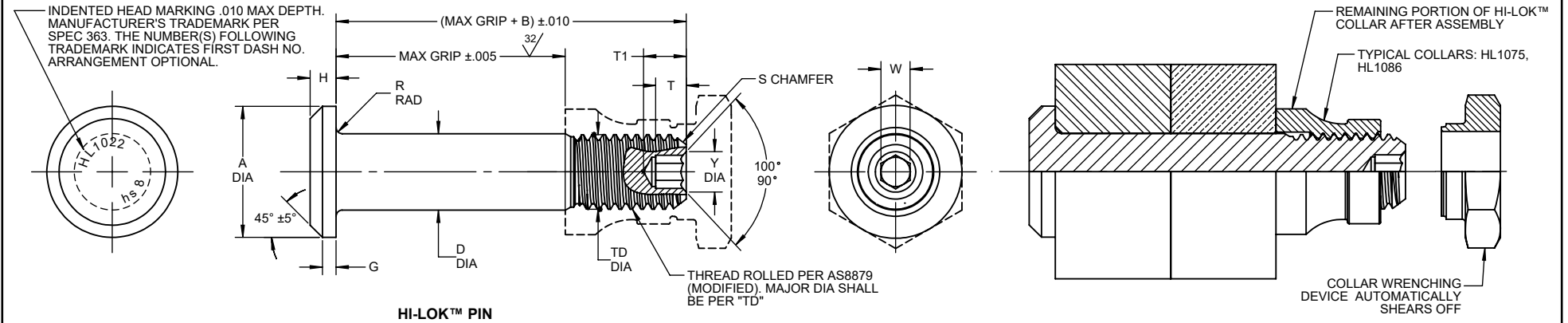


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HI-LOK™ PIN

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 MODIFIED	SOCKET				DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING OR SOLID FILM	AFTER COATING OR SOLID FILM							W HEX	T DEPTH	T1 DEPTH MAX	Y DIA		
5						NOTE: USE HL1012( )6(- )											
6	3/16	.377 .357	.325	.2026 .2021	.2026 .2016	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.140	.119 .104	6,130	3,180
7	7/32	.410 .390	.355	.2338 .2333	.2338 .2328	.2100 .2070	.040	.081 .071	.025 .015	1/32 x 37°	.2160-28 UNJF-3A	.0806 .0791	.100 .080	.140	.119 .104	8,160	4,280
8	1/4	.440 .415	.395	.2651 .2646	.2651 .2641	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.160	.142 .122	10,490	5,820
10	5/16	.505 .485	.500	.3276 .3271	.3276 .3266	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.200	.180 .160	16,000	9,200
12	3/8	.600 .580	.545	.3901 .3896	.3901 .3891	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.235	.217 .197	22,700	14,000
14	7/16	.676 .651	.635	.4526 .4521	.4526 .4516	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.280	.253 .233	30,600	18,900
16	1/2	.770 .745	.685	.5151 .5146	.5151 .5141	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.320	.289 .269	39,600	25,600
18	9/16	.877 .842	.770	.5771 .5766	.5771 .5761	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.360	.326 .306	49,700	32,400
20	5/8	.953 .905	.825	.6396 .6391	.6396 .6386	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.400	.326 .306	61,000	41,000
24	3/4	1.150 1.110	1.050	.7646 .7641	.7646 .7636	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.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

"HI-LOK", "HL", AND "HI-KOTE",  
ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY J.F. OBISPO	DATE 1995-03-22	TITLE HI-LOK™ PIN PROTRUDING TENSION HEAD TITANIUM 1/16 GRIP VARIATION, 1/64 OVERSIZE (SPECIAL SOCKET APPLICATION)
APPROVED E.E.B	DATE 1995-03-23	
REVISION 9	DATE C. ARTOS 2024-4-18	DRAWING NUMBER HL1022

- ⑨GENERAL NOTES:
1. Concentricity: "A" to "D" diameter within .010 FIM.

2. Dimensions are in inches and to be met after finish.

3. Surface texture per ASME B46.1.

4. Hole preparation per NAS618.

5. Use HL1032 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:
- HL1022-( )-( ) = Cetyl alcohol lube per Hi-Shear Spec. 305.

HL1022AZ( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

HL1022DK( )-( ) = Solid film lube per KalGard FA.

HL1022GL( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only (no overspray is allowed on the shank) with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec 305.

HL1022RA( )-( ) = Phosphate fluoride treat with color red on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.

HL1022VF( )-( ) = Anodize per Hi-Shear Spec 306, Type I, color blue and cetyl alcohol lube per hi-Shear Spec. 305.

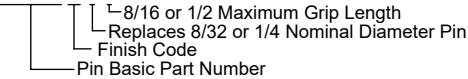
HL1022SY( )-( ) = Phosphate fluoride treat, solid film lube per AS5272, Type I, and color red on thread end.

SPECIFICATION: HI-LOK™ Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL1022 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  
HL1022VF8-8



Pin and Collar Assembly Part Number Combination  
HL1022VF1086-8-8



HL1022