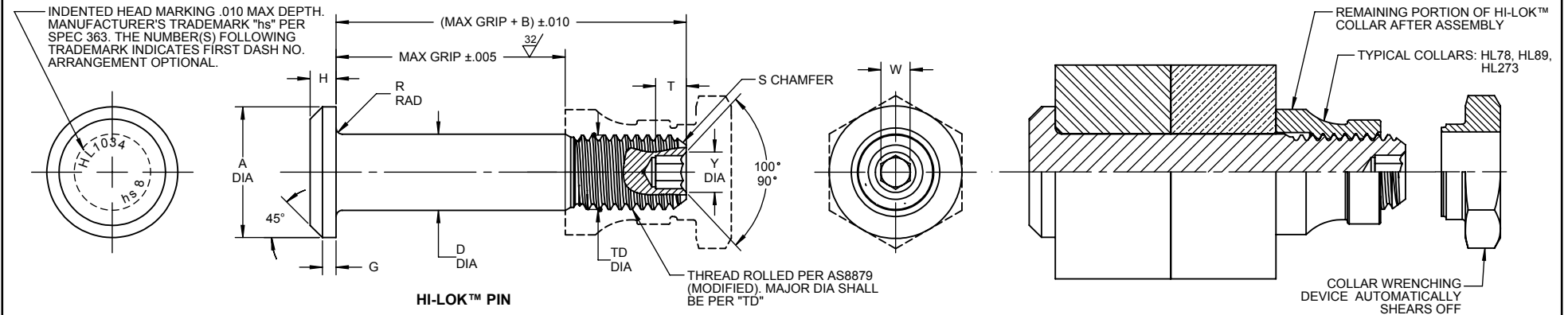




HI-LOK™ PIN

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 |
|----------------|-------------|--------------|-------|----------------|----------------|-------|--------------|--------------|---------------|---------------------|----------------|--------------|--------------|-----------------------------|------------------------|
|                |             |              |       |                |                |       |              |              |               |                     | W HEX          | T DEPTH      | Y DIA        |                             |                        |
| 6              | 3/16        | .377<br>.357 | .325  | .1895<br>.1885 | .1840<br>.1810 | .051  | .090<br>.080 | .025<br>.015 | 1/32 x 45°    | .1900-32<br>UNJF-3A | .0806<br>.0791 | .100<br>.080 | .119<br>.104 | 8,200                       | 5,620                  |
| 8              | 1/4         | .440<br>.415 | .395  | .2495<br>.2485 | .2440<br>.2410 | .075  | .120<br>.110 | .025<br>.015 | 1/32 x 45°    | .2500-28<br>UNJF-3A | .0967<br>.0947 | .110<br>.090 | .142<br>.122 | 14,200                      | 10,100                 |
| 10             | 5/16        | .505<br>.475 | .500  | .3120<br>.3110 | .3060<br>.3020 | .093  | .150<br>.140 | .030<br>.020 | 3/64 x 45°    | .3125-24<br>UNJF-3A | .1295<br>.1270 | .130<br>.110 | .180<br>.160 | 22,200                      | 16,000                 |
| 12             | 3/8         | .600<br>.530 | .545  | .3745<br>.3735 | .3680<br>.3640 | .125  | .190<br>.180 | .030<br>.020 | 3/64 x 45°    | .3750-24<br>UNJF-3A | .1617<br>.1582 | .160<br>.140 | .217<br>.197 | 32,000                      | 24,700                 |
| 14             | 7/16        | .676<br>.592 | .635  | .4370<br>.4360 | .4310<br>.4260 | .155  | .220<br>.210 | .030<br>.020 | 3/64 x 45°    | .4375-20<br>UNJF-3A | .1930<br>.1895 | .190<br>.170 | .253<br>.233 | 43,600                      | 33,500                 |
| 16             | 1/2         | .770<br>.717 | .685  | .4995<br>.4985 | .4930<br>.4880 | .162  | .255<br>.245 | .030<br>.020 | 3/64 x 45°    | .5000-20<br>UNJF-3A | .2242<br>.2207 | .220<br>.200 | .289<br>.269 | 56,900                      | 44,500                 |

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 are in inches and to be met after finish.
  3. Surface texture per ASME B46.1.
  4. Hole preparation per NAS618.

**HOW TO ORDER**

② **EXAMPLE:** Pin Part Number  
 HL1034KH8-8

8/16 or 1/2 Maximum Grip Length  
 8/32 or 1/4 Nominal Diameter Pin  
 Finish Code  
 Pin Basic Part Number

**MATERIAL:** Multiphase MP35N per AMS5844.

**HEAT TREAT:** 260,000 psi tensile minimum.

**FINISH:** HL1034-( )-( ) = Cetyl alcohol lube per Hi-Shear Spec. 305.  
 HL1034KH( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, with white identification on top of head, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HL1034KU( )-( ) = White 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.

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

|                   |  |                                  |  |                                                                                           |  |
|-------------------|--|----------------------------------|--|-------------------------------------------------------------------------------------------|--|
| DRAWN BY<br>D.P.S |  | DATE<br>1988-11-08               |  | TITLE<br>HI-LOK™ PIN<br>PROTRUDING TENSION HEAD<br>MP35 MULTIPHASE<br>1/16 GRIP VARIATION |  |
| J.F. OBISPO       |  | 2016-05-12                       |  |                                                                                           |  |
| APPROVED<br>E.E.B |  | DATE<br>1988-11-09               |  | DRAWING NUMBER<br>HL1034<br>1 OF 1                                                        |  |
| REVISION<br>②     |  | DATE<br>KEVIN TRAN<br>2017-06-22 |  |                                                                                           |  |