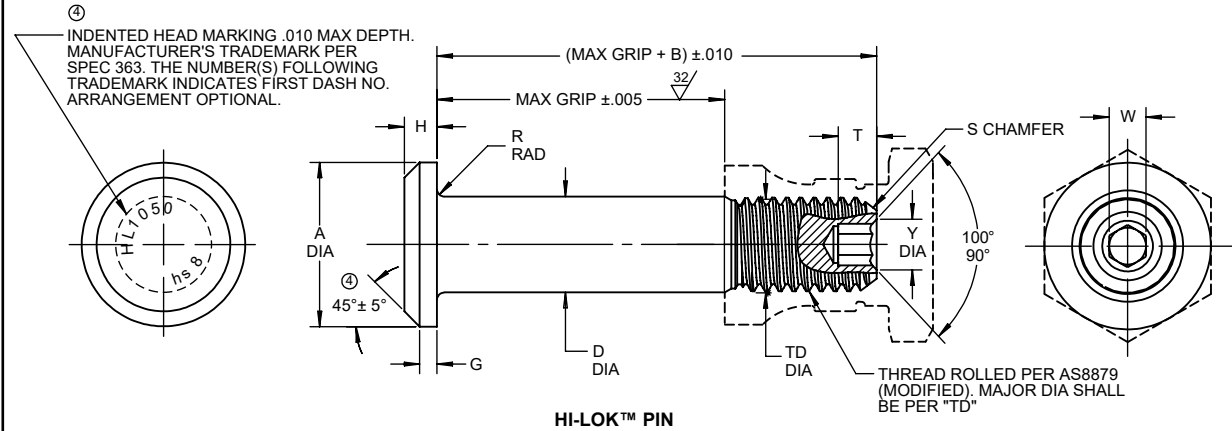
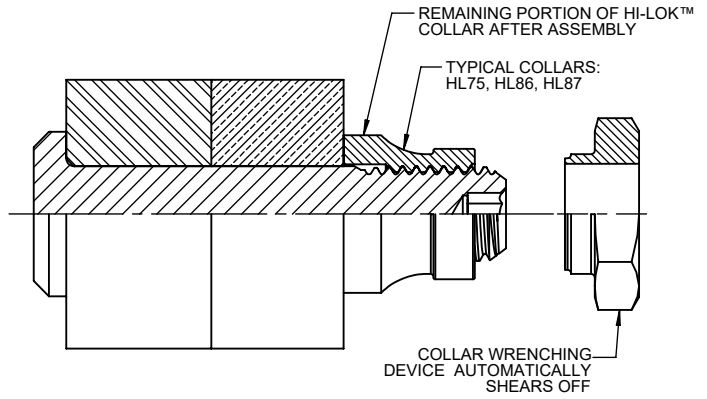




HI-LOK™ PIN



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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

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		
5	5/32	.322 .306	.312	.1635 .1625	.1595 .1570	.030	.060 .055	.025 .015	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.135 .115	6	4,010	2,180
6	3/16	.377 .357	.325	.1895 .1885	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	5,380	3,180
8	1/4	.440 .415	.395	.2495 .2485	.2440 .2410	.045	.090 .077	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	9,300	5,820
10	5/16	.505 .485	.500	.3120 .3110	.3060 .3020	.055	.112 .098	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	14,600	9,200
12	3/8	.600 .580	.545	.3745 .3735	.3680 .3640	.065	.140 .130	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	21,000	14,000
14	7/16	.676 .651	.635	.4370 .4360	.4310 .4260	.075	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	28,600	18,900
16	1/2	.770 .745	.685	.4995 .4985	.4930 .4880	.085	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	37,300	25,600
18	9/16	.877 .842	.770	.5615 .5605	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 45°	.5325-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	47,200	32,400
20	5/8	.953 .905	.825	.6240 .6230	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	58,300	41,000
24	3/4	1.150 1.110	1.050	.7490 .7480	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	83,900	59,500

- GENERAL NOTES:**
- Concentricity: "A" to "D" diameter within .010 FIM.
 - Dimensions are in inches and to be met after finish.
 - Surface texture per ASME B46.1.
 - Hole preparation per NAS618.
 - Evidence of broken edge across points.
 - Use HL1052 for oversize replacement.

MATERIAL: Alloy steel 4340 per AMS6415, 4140, per AMS6382 or AMS6349, 8740 per AMS6322 or AMS6325 or AMS6327.

④ **HEAT TREAT:** 95,000 psi shear (160,000 - 180,000 psi tensile per AMS2759).

FINISH: HL1050PB() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 ④ HL1050RL() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, color black, and cetyl alcohol lube per Hi-Shear Spec.305.
 HL1050ZN() = Zinc nickel plate per AMS2417, Type II, Grade B, 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:**

Pin Part Number
 HL1050PB8-8
 8/16 or 1/2 Maximum Grip Length
 8/32 or 1/4 Nominal Diameter Pin
 Finish Code
 Pin Basic Part Number

"HI-LOK", "HL", AND "HI-KOTE" ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY J.F.OBISPO	DATE 1996-01-03	TITLE HI-LOK™ PIN PROTRUDING TENSION HEAD ALLOY STEEL 1/16 GRIP VARIATION	
APPROVED MC	DATE 1996-01-03	DRAWING NUMBER HL1050	
REVISION 4	DATE A.CHAE 2021-01-11	1 OF 1	