lisi AEROSPACE
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR Corporation, USA
a LISI AEROSPACE Company

Design Holder

CAGE No. 73197

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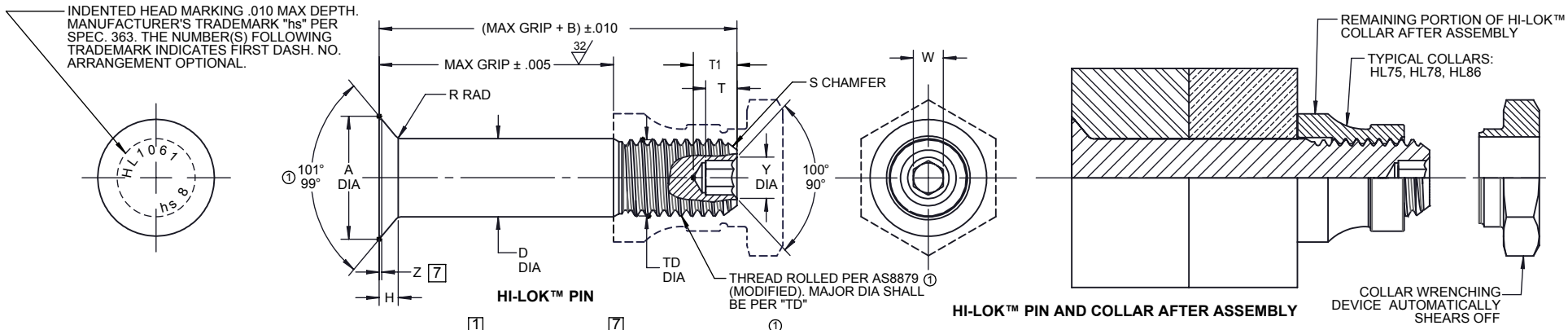

HI-LOK™ PIN

HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA WITHOUT PLATING, COATING, OR S.F.L.	D DIA WITH PLATING, COATING, OR S.F.L.	TD DIA	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET W HEX	SOCKET T DEPTH	SOCKET T1 DEPTH MAX	SOCKET Y DIA	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
5	5/32	.3304 .3256	.312	.1635 .1630	.1635 .1625	.1595 .1570	.004	.0700 .0680	.025 .015	.010	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.100 .080	.140	9	4,010	2,180
6	3/16	.3813 .3765	.325	.1895 .1890	.1895 .1885	.1840 .1810	.005	.0805 .0785	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.140	.119 .104	5,380	3,180
8	1/4	.5066 .5018	.395	.2495 .2490	.2495 .2485	.2440 .2410	.006	.1080 .1060	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.160	.142 .122	9,300	5,820
10	5/16	.6335 .6287	.500	.3120 .3115	.3120 .3110	.3060 .3020	.007	.1350 .1330	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.200	.180 .160	14,600	9,200
12	3/8	.7604 .7556	.545	.3745 .3740	.3745 .3735	.3680 .3640	.008	.1620 .1600	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.235	.217 .197	21,000	14,000
14	7/16	.8884 .8812	.635	.4370 .4365	.4370 .4360	.4310 .4260	.009	.1895 .1865	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.280	.253 .233	28,600	18,900
16	1/2	1.0139 1.0068	.685	.4995 .4990	.4995 .4985	.4930 .4880	.010	.2160 .2130	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.320	.289 .269	37,300	25,600

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

GENERAL NOTES:
1. Head edge out of roundness shall not exceed "F".
2. Concentricity: Conical surface of head to "D" diameter within .003 FIM.
3. "H" is dimensioned from maximum "D" diameter.
4. Dimensions are in inches and to be met after finish.
5. Surface texture per ASME B46.1.
6. Hole preparation per NAS618.
7. Curved or flat edge manufacturer's option.
8. Non-lubed pins must be used with lubed collar.
9. Evidence of broken edge across points.
10. Use HL1063 for oversize replacement.
11. After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union

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
HL1061AZ8-8
- 8/16 or 1/2 Maximum Grip Length
- 8/32 or 1/4 Nominal Diameter Pin
- Finish Code
- Pin Basic Part Number

~~Pin and Collar Assembly Part Number Combination~~
~~HL1061AZ86-8-8~~
- ~~Size and Grip Length, See Above Example~~
- ~~Collar Part Number~~
- ~~Pin Finish~~
- ~~Pin Basic Part Number~~

MATERIAL: A-286 high temperature alloy per AMS5737 or AMS5731.

HEAT TREAT: 160,000 psi tensile minimum (95,000 psi shear minimum) at 70°F.

FINISH:
- HL1061-( )-( ) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
- 11 HL1061AZ( )-( ) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, with color black on the thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL1061CG( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, with color green on the thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL1061DU( )-( ) = Solid film lube per AS5272, Type I.
- 8 HL1061N( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, without lubricant. (For use in LOX system).
- 8 HL1061PY( )-( ) = Passivate per Hi-Shear Spec. 258.

SPECIFICATION: HI-LOK™ Product Specification 342.

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

DRAWN BY	DATE
J.F. OBISPO	2003-10-23
APPROVED	DATE
M. CAWLEY	2003-10-23
REVISION	DATE
1	KEVIN TRAN 2017-09-21

TITLE
HI-LOK™ PIN
100° FLUSH MS24694 TENSION HEAD
A-286 HIGH TEMPERATURE ALLOY
1/16 GRIP VARIATION

DRAWING NUMBER
HL1061

1 OF 1

HL1061