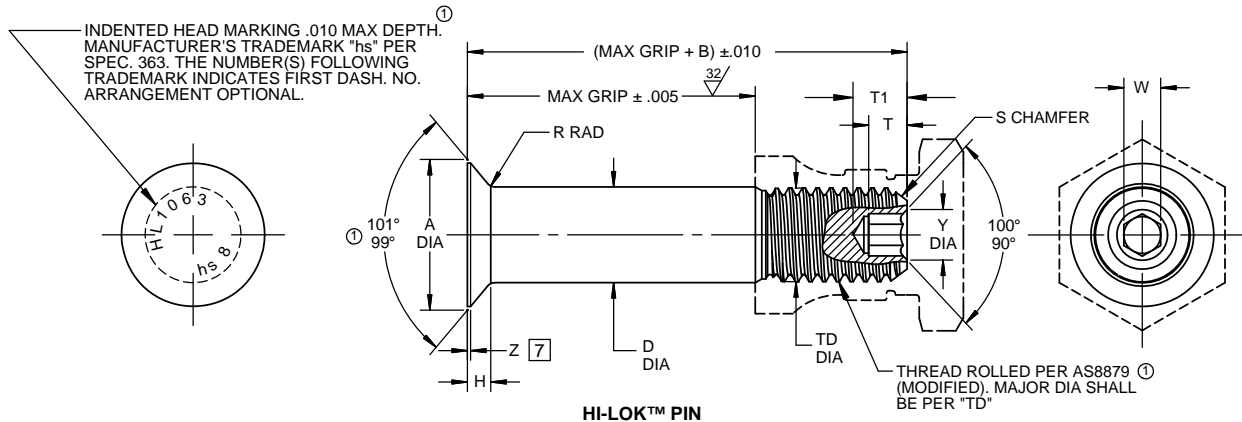
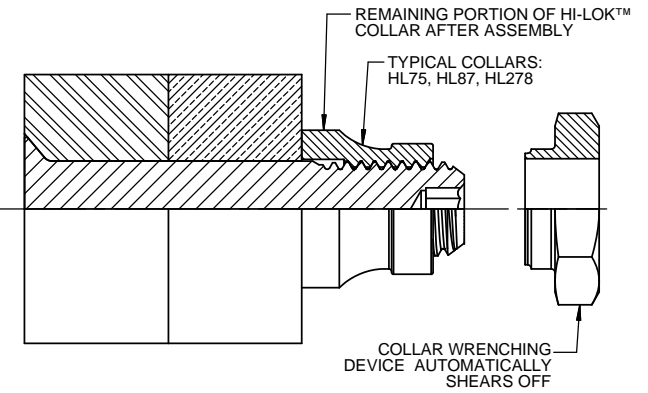


① For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at:
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HI-LOK™ PIN



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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

①																			②		③	
FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET				DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM				
				WITHOUT PLATING, COATING	WITH PLATING, COATING								W HEX	T DEPTH	T1 DEPTH MAX	Y DIA						
							NOTE: USE HL1061-6-()															
6	3/16	.3813 .3765	.325	.2026 .2021	.2026 .2016	.1840 .1810	.005	.0750 .0730	.030 .020	.015	1/32" x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.140	.119 .104	6,130	3,180				
8	1/4	.5066 .5018	.395	.2651 .2646	.2651 .2641	.2440 .2410	.006	.1013 .0993	.030 .020	.015	1/32" x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.160	.142 .122	10,490	5,820				
10	5/16	.6335 .6287	.500	.3276 .3271	.3276 .3266	.3060 .3020	.007	.1283 .1263	.040 .030	.015	3/64" x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.200	.180 .160	16,000	9,200				
12	3/8	.7604 .7556	.545	.3901 .3896	.3901 .3891	.3680 .3640	.008	.1553 .1533	.040 .030	.015	3/64" x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.235	.217 .197	22,700	14,000				
14	7/16	.8884 .8812	.635	.4526 .4521	.4526 .4516	.4310 .4260	.009	.1828 .1798	.050 .040	.022	3/64" x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.280	.253 .233	30,600	18,900				
16	1/2	1.0139 1.0068	.685	.5151 .5146	.5151 .5141	.4930 .4880	.010	.2093 .2063	.050 .040	.022	3/64" x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.320	.289 .269	39,600	25,600				

HL1063

"HI-LOK", "HL", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY J.F.OBISPO	DATE 2003-10-23	TITLE HI-LOK™ PIN	
APPROVED M.CAWLEY	DATE 2003-10-23	100° FLUSH MS24694 TENSION HEAD A-286 HIGH TEMPERATURE 1/16 GRIP VARIATION, 1/64 OVERSIZE	
REVISION ①	DATE M.BEARD 2017-09-21	DRAWING NUMBER HL1063	

- 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.
 - ① 4. Dimensions are in inches and to be met after finish.
 - ① 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 collars.
 9. Use HL1065 for oversize replacement.
 - ① 10 After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

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:**
- HL1063-()-() = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
- ① 10 HL1063AZ()-() = 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.
- HL1063CG()-() = 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.
- HL1063DU()-() = Solid film lube per AS5272, Type I.
- 8 HL1063N()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, without lubricant. (For use in LOX system).
- 8 HL1063PY()-() = Passivate per Hi-Shear Spec. 258.

SPECIFICATION: HI-LOK™ Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL1063 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

HOW TO ORDER
 ① **EXAMPLE:**

