

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	F REF	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET		DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING, SOLID FILM	AFTER COATING, SOLID FILM								W HEX	T DEPTH		
5	5/32	.2612 .2564	.312	.1635 .1630	.1635 .1625	.1595 .1570	.004	.0410 .0390	.025 .015	.010 .005	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.135 .115	5,280	1,700
6	3/16	.3016 .2966	.325	.1895 .1890	.1895 .1885	.1840 .1810	.005	.0470 .0450	.030 .020	.015 .005	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	7,060	2,500
8	1/4	.3948 .3898	.395	.2495 .2490	.2495 .2485	.2440 .2410	.006	.0610 .0590	.030 .020	.015 .005	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	12,260	4,300
10	5/16	.4739 .4689	.500	.3120 .3115	.3120 .3110	.3060 .3020	.007	.0680 .0660	.040 .030	.015 .005	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	19,160	6,300
12	3/8	.5604 .5554	.545	.3745 .3740	.3745 .3735	.3680 .3640	.008	.0780 .0760	.040 .030	.015 .005	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	27,600	8,700
14	7/16	.6680 .6620	.635	.4370 .4365	.4370 .4360	.4310 .4260	.009	.0970 .0940	.050 .040	.022 .005	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	37,500	12,100
16	1/2	.7540 .7480	.685	.4995 .4990	.4995 .4985	.4930 .4880	.010	.1070 .1040	.050 .040	.022 .005	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	49,100	13,300

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

DRAWN BY BRIEJ	DATE 1965-03-08	TITLE HI-LOK™ PIN 100° FLUSH SHEAR HEAD PH15-7Mo STAINLESS STEEL 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED MILLER	DATE 1965-03-08	
REVISION 2	DATE B.CHAN 2021-04-29	DRAWING NUMBER HL151

GENERAL NOTES:

1. Head edge out of roundness shall not exceed "F".

2. Concentricity: Conical surface of head to "D" diameter within .005 TIR.

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

② 4. Surface texture per ASME B46.1.

5. Hole preparation per NAS618.

6. "H" is dimensioned from maximum "D" diameter.

MATERIAL:

PH15-7Mo per AMS5657 or AMS5657.

HEAT TREAT:

125,000 PSI shear minimum.

② FINISH:

HL151-()-() = Passivate per AMS2700, Method 1, Type 8, Class 1

SPECIFICATION:

HI-LOK™ Product Specification 342.

CODE:

First dash number indicates nominal diameter in 1/32nds

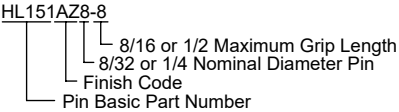
Second dash number indicates maximum grip in 1/16ths.

See Finish note for explanation of code letters.

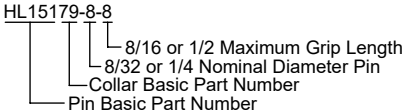
HOW TO ORDER

② EXAMPLE:

Pin Part Number



Pin and Collar Assembly Part Number



HL151