



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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

②

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		HL75 HL86 HL87	HL73 HL273 HL89
5	5/32	.3304 .3256	.312	.1635 .1630	.1635 .1625	.1595 .1570	.004	.0700 .0680	.025 .015	.010 .005	1/32 x 45°	.1640-32 UNJC-3A	.0645 .0635	.135 .115	5,280	2,300	2,940
6	3/16	.3813 .3765	.325	.1895 .1890	.1895 .1885	.1840 .1810	.005	.0805 .0785	.030 .020	.015 .005	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	7,060	2,750	4,000
8	1/4	.5066 .5018	.395	.2495 .2490	.2495 .2485	.2440 .2410	.006	.1080 .1060	.030 .020	.015 .005	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	12,260	5,000	7,500
10	5/16	.6335 .6287	.500	.3120 .3115	.3120 .3110	.3060 .3020	.007	.1350 .1330	.040 .030	.015 .005	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	19,160	8,300	11,750
12	3/8	.7604 .7556	.545	.3745 .3740	.3745 .3735	.3680 .3640	.008	.1620 .1600	.040 .030	.015 .005	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	27,600	12,700	18,000
14	7/16	.8884 .8812	.635	.4370 .4365	.4370 .4360	.4310 .4260	.009	.1895 .1865	.050 .040	.022 .005	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	37,500	19,000	23,750
16	1/2	1.0139 1.0068	.685	.4995 .4990	.4995 .4985	.4930 .4880	.010	.2160 .2130	.050 .040	.022 .005	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	49,100	25,500	32,000

⑥

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

DRAWN BY B. CHAN	DATE 1965-03-08	TITLE HI-LOK™ PIN 100° FLUSH SHEAR HEAD PH15-7Mo STAINLESS STEEL 1/16 GRIP VARIATION
APPROVED J. LO	DATE 1965-03-08	
REVISION ②	DATE 2021-08-05	DRAWING NUMBER <b>HL153</b>

- 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. "H" is dimensioned from maximum "D" diameter.
  - ② 4. Surface texture per ASME B46.1.
  5. Hole preparation per NAS618.
  - ② ⑥ -5 size must be installed using a torque controlled hex key
  - ② ⑦ See reference collar standards page for detail dimensions

**MATERIAL:** PH15-7Mo per AMS5657

**HEAT TREAT:** 125,000 PSI shear minimum.

② **FINISH:** HL153-( )-( ) = 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  
**HL153 - 8-8**  
 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

**HL15386-8-8**  
 8/16 or 1/2 Maximum Grip Length  
 8/32 or 1/4 Nominal Diameter Pin  
 Collar Basic Part Number  
 Pin Basic Part Number

HL153

DRAWING NUMBER

**HL153**

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