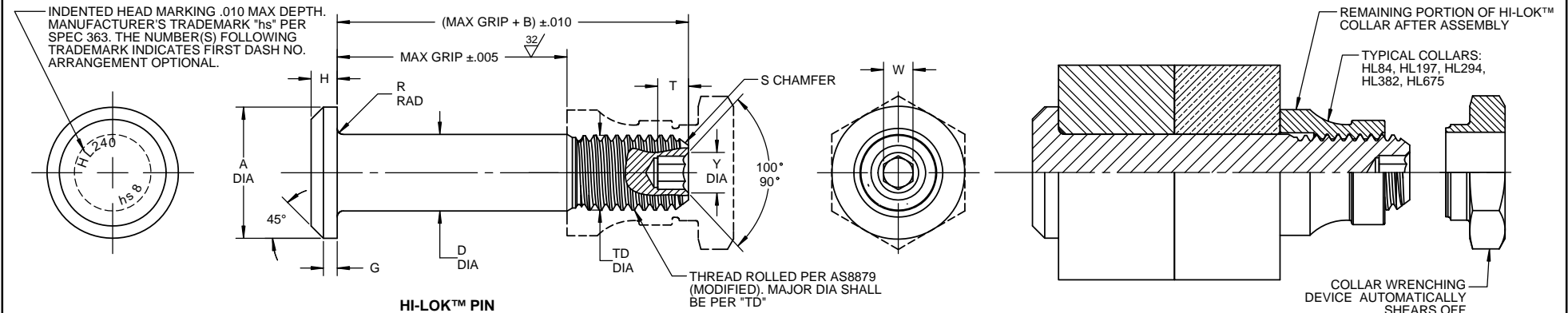


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HI-LOK™ PIN

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
				WITHOUT COATING OR SOLID FILM	AFTER COATING OR SOLID FILM							W HEX	T DEPTH	Y DIA		
5											NOTE: USE HL140-6-()					
6	7/32	.315 .295	.325	.2182 .2177	.2182 .2172	.1840 .1810	.025	.055 .045	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	7,100	2,500
8	9/32	.412 .387	.395	.2807 .2802	.2807 .2797	.2440 .2410	.030	.069 .059	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	11,800	4,300
10	11/32	.505 .475	.500	.3432 .3427	.3432 .3422	.3060 .3020	.035	.078 .068	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	17,600	6,300
12	13/32	.600 .565	.545	.4057 .4052	.4057 .4047	.3680 .3640	.040	.088 .078	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	24,600	8,700
14	15/32	.676 .641	.635	.4682 .4677	.4682 .4672	.4310 .4260	.045	.105 .093	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	32,700	12,100
16	17/32	.770 .735	.685	.5307 .5302	.5307 .5297	.4930 .4880	.050	.116 .103	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	42,000	15,300
18	19/32	.864 .829	.770	.5927 .5922	.5927 .5917	.5550 .5500	.055	.127 .112	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	52,400	19,000
20	21/32	.953 .918	.825	.6552 .6547	.6552 .6542	.6180 .6120	.060	.137 .122	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	64,100	23,000
24	25/32	1.108 1.066	1.050	.7802 .7797	.7802 .7792	.7430 .7370	.070	.151 .136	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	90,900	30,700

HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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

GENERAL NOTES: 1. Concentricity: "A" to "D" diameter within .010 FIM.

2. Dimensions are inches and to be met after finish.

3. Non-lubed pins must be used with lubed collars.

4. Surface texture per ASME B46.1.

5. Hole preparation per NAS618.

6. Oversize replacement for HL40 and HL140.

7. 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: 95,000 psi shear minimum at 70°F.

FINISH: HL240-()-() = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.

7 HL240AZ()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

HL240DU()-() = Solid film lube per AS5272, Type I.

3 HL240GU()-() = Silver plate per AMS2410.

3 HL240N()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, without lube (for use in LOX systems).

HL240PB()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, with color code green on thread end plus cetyl alcohol lube per Hi-Shear Spec. 305.

HL240V()-() = Solid film lubricant per Lubeco 2123, Type II.

SPECIFICATION: HI-LOK™ Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL240 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER

19 **EXAMPLE:** Pin Part Number HL240AZ8-8

8/16 or 1/2 Maximum Grip Length
 Replaces 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 BRIEJ	DATE 1966-03-31	TITLE HI-LOK™ PIN PROTRUDING SHEAR HEAD A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION, 1/32 OVERSIZE
APPROVED MILLER	DATE 1966-03-31	
REVISION 19	DATE M.BEARD 2017-06-26	DRAWING NUMBER HL240