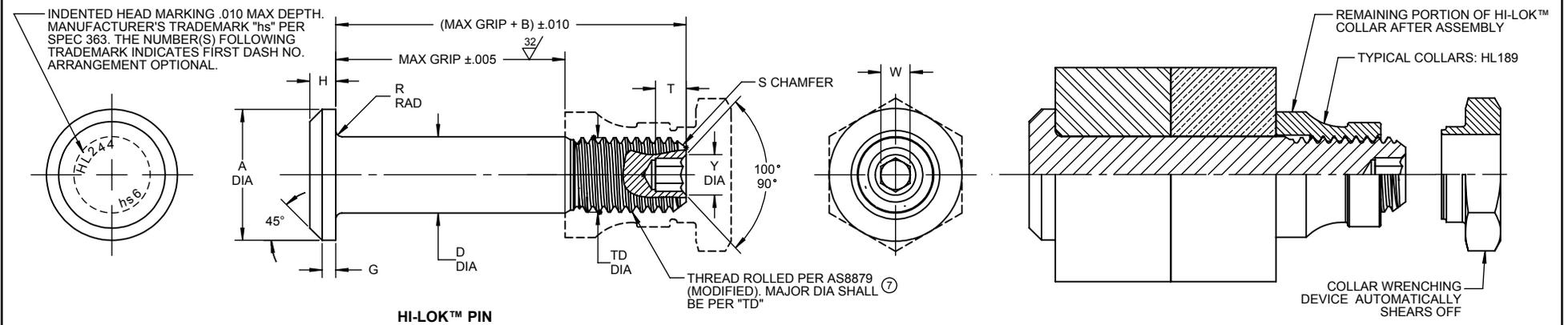


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HI-LOK™ PIN

HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING	WITH COATING							W HEX	T DEPTH	Y DIA		
4	1/8	.290 .275	.294	.1375 .1370	.1375 .1365	.1335 .1310	.025	.055 .045	.020 .010	1/32 x 45°	.1380-32 UNJC-3A	.0645 .0635	.100 .085	5	2,840	1,450
5	5/32	.322 .306	.312	.1635 .1630	.1635 .1625	.1595 .1570	.030	.065 .055	.025 .015	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.100 .080	5	4,010	2,180
6	3/16	.377 .357	.325	.1895 .1890	.1895 .1885	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.110 .080	.119 .104	5,380	3,180
8	1/4	.440 .415	.395	.2495 .2490	.2495 .2480	.2440 .2410	.045	.090 .077	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	9,300	5,820

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 in inches and to be met after finish.
  3. Surface texture per ASME B46.1.
  4. Hole preparation per NAS618.
- [5] Evidence of broken edge across points.

**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  
**HL244TB6-8**  
 | 8/16 or 1/2 Maximum Grip Length  
 | 6/32 or 3/16 Nominal Diameter Pin  
 | Finish Code  
 | Pin Basic Part Number

Pin and Collar Assembly Part Number Combination

**HL244189-6-8**  
 | Size and Grip Length, See Above Example  
 | Collar Part Number  
 | Pin Part Number

**MATERIAL:** Waspaloy high temperature alloy per AMS5708.

**HEAT TREAT:** 160,000 psi tensile minimum at 70°F.

**FINISH:** HL244-( )-( ) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol tube per Hi-Shear Spec. 305.  
 HL244TB-( )-( ) = Passivate per Hi-Shear Spec. 258, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol tube per Hi-Shear Spec. 305.

⑦ **SPECIFICATION:** HI-LOK™ Product Specification 342.

"HI-LOK", "HL", AND "HI-KOTE" ARE TRADEMARKS OF HI-SHEAR CORPORATION		
DRAWN BY VAN	DATE 1969-01-03	TITLE HI-LOK™ PIN PROTRUDING TENSION HEAD WASPALOY HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION
APPROVED J.M	DATE 1969-01-07	DRAWING NUMBER <b>HL244</b>
REVISION ⑦	DATE KEVIN TRAN 2017-06-22	1 OF 1