



HI-LOK™ STUD PIN

HI-LOK™ STUD PIN AND COLLAR AFTER ASSEMBLY

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

FIRST DASH NO.	NOM DIA	A DIA	B REF	D DIA	TD DIA	F	H REF	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
												W HEX	T DEPTH	Y DIA		
[7] 5	5/32	.285 .255	.312	.1635 .1625	.1595 .1570	.010	.045	.025 .015	.010	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.135 .115	[8]	4,010	1,290
6	3/16	.322 .292	.325	.1895 .1885	.1840 .1810	.010	.050	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	5,380	2,000
8	1/4	.416 .384	.395	.2495 .2485	.2440 .2410	.012	.063	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	9,300	3,700
10	5/16	.501 .468	.500	.3120 .3110	.3060 .3020	.014	.072	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .160	.180 .160	14,600	5,000
12	3/8	.587 .554	.545	.3745 .3735	.3680 .3640	.016	.082	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	21,000	7,200

- GENERAL NOTES:**
1. Head edge out of roundness shall not exceed "F".
 2. Concentricity: Conical surface of head to "D" diameter within .005 FIR.
 3. "H (REF)" dimensioned from maximum "D" diameter.
 4. Dimensions are in inches and to be met after plating.
 5. Surface texture per ASME B46.1.
 6. Hole preparation per NAS618.
 - [7] Recommended for light structure only.
 - [8] Evidence of broken edge cross points.
 - [9] Curved or flat edge manufacturer's option.

MATERIAL: Alloy steel per Spec. AMS6382, AMS6322, AMS6415.

[20] **HEAT TREAT:** 95,000 psi shear minimum (160,000-180,000 psi tensile per Spec. AMS-H-6875)

FINISH: HL35-()-() = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL35PB-()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

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. Third dash number indicates stud length in 1/16ths. See "Finish" note for explanation of code letters.

HOW TO ORDER EXAMPLE:

Stud Pin Part Number
 HL35PB-8-8-8
 ————— 8/16 or 1/2 Maximum Stud Length
 ————— 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 Combination
 HL3570-8-8-8
 ————— Size and grip length, see above example
 ————— Collar Part Number
 ————— Pin Basic Part Number

"HI-LOK", "HL", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION		
DRAWN BY SCHAD	DATE 1957-07-22	TITLE HI-LOK™ STUD PIN 100° FLUSH SHEAR HEAD ALLOY STEEL 1/16 GRIP VARIATION
APPROVED CESSNA	DATE 1957-07-29	
REVISION [20]	DATE J. LO 2020-07-23	DRAWING NUMBER HL35