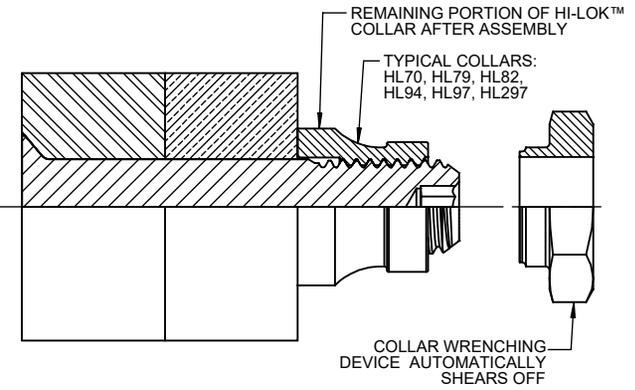
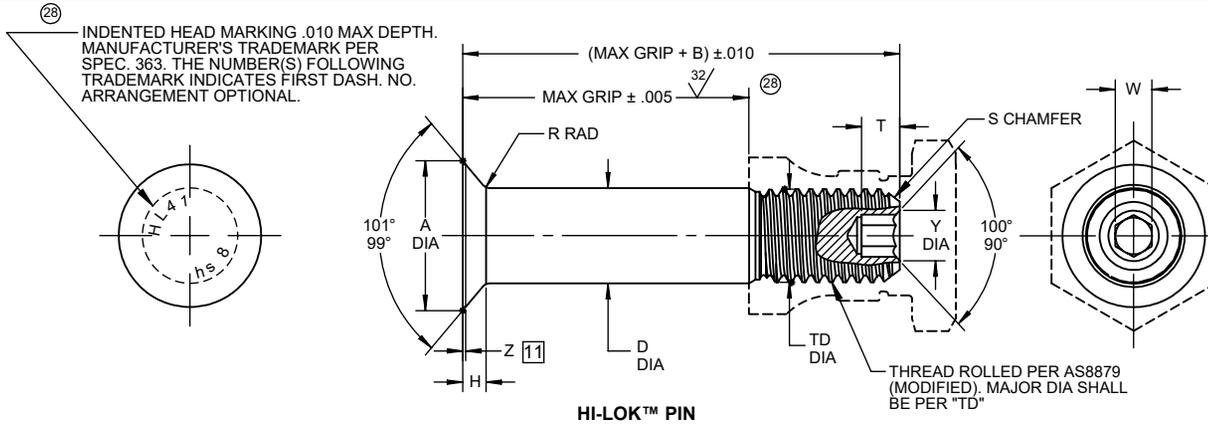


For the current list of licensed manufacturers, please visit the
 LISI AEROSPACE website at:
[HTTP://WWW.LISI-AEROSPACE.COM/LICENSES](http://www.lisi-aerospace.com/licenses)



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	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT SOLID FILM LUBE	WITH SOLID FILM LUBE								W HEX	T DEPTH	Y DIA		
4	1/8	.2219 .2171	.294	.1375 .1370	.1375 .1365	.1335 .1310	.003	.0354 .0334	.020 .010	.010	1/32 x 45°	.1380-32 UNJC-3A	.0645 .0635	.100 .085	10	2,840	950
5	5/32	.2612 .2564	.312	.1635 .1630	.1635 .1625	.1595 .1570	.004	.0410 .0390	.025 .015	.010	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.135 .115	10	4,010	1,750
6	3/16	.3016 .2966	.325	.1895 .1890	.1895 .1885	.1840 .1810	.005	.0470 .0449	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	5,380	2,000
8	1/4	.3948 .3898	.395	.2495 .2490	.2495 .2485	.2440 .2410	.006	.0610 .0589	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	9,300	3,700
10	5/16	.4739 .4689	.500	.3120 .3115	.3120 .3110	.3060 .3020	.007	.0679 .0658	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	14,600	5,500
12	3/8	.5604 .5554	.545	.3745 .3740	.3745 .3735	.3680 .3640	.008	.0780 .0759	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	21,000	7,200
14	7/16	.6680 .6620	.635	.4370 .4365	.4370 .4360	.4310 .4260	.009	.0969 .0944	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	28,600	10,000
16	1/2	.7540 .7480	.685	.4995 .4990	.4995 .4985	.4930 .4880	.010	.1068 .1043	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	37,300	13,500
18	9/16	.8380 .8310	.770	.5615 .5610	.5615 .5605	.5550 .5500	.010	.1160 .1131	.050 .040	.025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	47,200	17,000
20	5/8	.9250 .9180	.825	.6240 .6235	.6240 .6230	.6180 .6120	.010	.1260 .1230	.050 .040	.025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	58,300	21,000
24	3/4	1.0970 1.0850	1.050	.7490 .7485	.7490 .7480	.7430 .7370	.012	.1460 .1410	.050 .040	.025	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	83,900	30,700

"HI-LOK", "HL", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION		
DRAWN BY C.E.K.	DATE 1962-10-17	TITLE HI-LOK™ PIN 100° FLUSH SHEAR HEAD A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION
APPROVED M.E.C.	DATE 1962-10-17	
REVISION (28)	DATE A.CHAE 2022-06-16	DRAWING NUMBER HL41

- 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" is dimensioned from maximum "D" diameter.
 4. Dimensions are in inches and to be met after finish.
 - 5 Non-lubed pins must be used with lubed collars.
 6. Surface texture per ASME B46.1.
 7. Hole preparation per NAS618.
 - 8 Maximum "D" diameter may be increased by .0002 to allow for solid film application.
 9. Use HL141 for oversize replacement.
 - 10 Evidence of broken edge across points.
 - 11 Curved or flat edge manufacturer's option.
 - 12 Broach petals removed.

MATERIAL: A-286 high temperature alloy per AMS5737 or AMS5731.
HEAT TREAT: 95,000 psi shear minimum at 70°F.

- FINISH:**
- 28 HL41(-)(-) = Passivate per AMS2700, Method 1, Type 8, Class 1, and cetyl alcohol lube per Hi-Shear Spec. 305
 - HL41DL(-)(-) = Kalgard FA or EM620C solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL41DU(-)(-) = Solid film lube per AS5272, Type I.
 - 5 HL41GU(-)(-) = Silver plate per AMS2410.
 - 12 HL41K(-)(-) = Solid film lube per Lubeco 905.
 - 28 5 HL41PY(-)(-) = Passivate per AMS2700, Method 1, Type 8, Class 1.
 - HL41TF(-)(-) = HI-KOTE™ 2 solid film per Hi-Shear Spec. 292.
 - HL41V(-)(-) = Solid film lubricant per "Lubeco" 2123, Type II.
 - HL41HK(-)(-) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

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.

28 **HOW TO ORDER EXAMPLE:**

