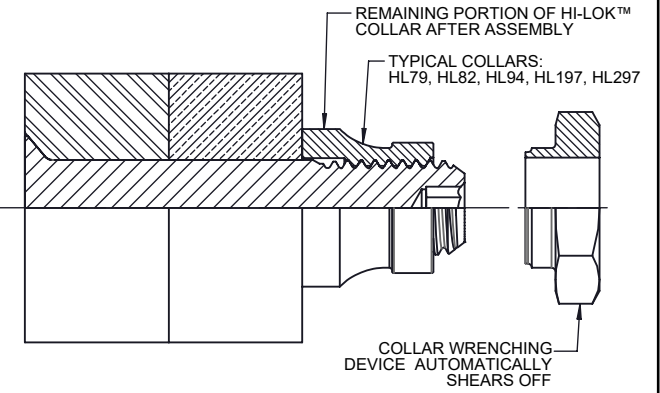
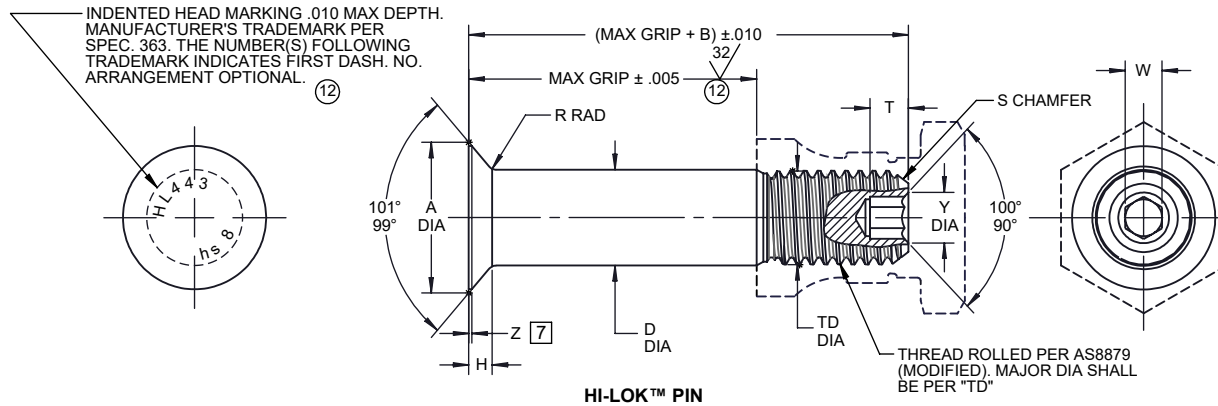




HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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

1																	7																
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 COATING S.F.L. OR PLATING	WITH COATING S.F.L. OR PLATING								W HEX	T DEPTH	Y DIA																		
5	3/16			NOTE: USE HL441-6-()																													
6	13/64	.3016 .2966	.325	.2026 .2021	.2026 .2016	.1840 .1810	.005	.0415 .0394	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	6,130	2,000																
8	17/64	.3948 .3898	.395	.2651 .2646	.2651 .2641	.2440 .2410	.006	.0544 .0523	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	10,490	3,700																
10	21/64	.4739 .4689	.500	.3276 .3271	.3276 .3266	.3060 .3020	.007	.0614 .0593	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	16,000	5,000																
12	25/64	.5604 .5554	.545	.3901 .3896	.3901 .3891	.3680 .3640	.008	.0714 .0693	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	22,700	7,200																
14	29/64	.6680 .6620	.635	.4526 .4521	.4526 .4516	.4310 .4260	.009	.0904 .0879	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	30,600	10,000																
16	33/64	.7540 .7480	.685	.5151 .5146	.5151 .5141	.4930 .4880	.010	.1002 .0977	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	39,600	13,500																
18	37/64	.8380 .8310	.770	.5771 .5766	.5771 .5761	.5550 .5500	.010	.1094 .1065	.050 .040	.022	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	49,700	17,000																
20	41/64	.9250 .9180	.825	.6396 .6391	.6396 .6386	.6180 .6120	.010	.1197 .1168	.050 .040	.022	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	61,000	21,000																
24	49/64	1.0970 1.0850	1.050	.7646 .7641	.7646 .7636	.7430 .7370	.012	.1394 .1344	.050 .040	.022	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	87,200	30,700																

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

DRAWN BY D.M.B.	DATE 1962-12-6	TITLE HI-LOK™ PIN 100° FLUSH SHEAR HEAD A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED CESSNA	DATE 1962-12-6	
REVISION (12)	DATE C. ARTOS 2023-12-7	DRAWING NUMBER HL443

- ⑫ **GENERAL NOTES:**
- ① Head edge out of roundness shall not exceed "F".
 2. Concentricity: Conical surface of head to "D" diameter within .005 FIM.
 3. "H" is dimensioned from maximum "D" diameter.
 4. Dimensions are in inches and to be met after finish.
 5. Surface texture per ASME B46.1.
 6. Hole preparation per NAS618.
 - ⑦ Curved or flat edge manufacturer's option.
 - ⑧ Non-lubed pin must be used with wet sealant or with lubed collars.
 9. Use HL241 for oversize replacement.

MATERIAL: A-286 high temperature alloy per AMS5737 or AMS5731.

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

- FINISH:**
- HL443(-)() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, with color blue on top of head and cetyl alcohol lube per Hi-Shear Spec. 305.
- ⑫ HL443AP()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
- ⑫ HL443AZ()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294, with color black on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL443EL()-() = Solid film lube per "Electrofilm" 4396.
- HL443N()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2., without lubricant. (For use in LOX systems.)
- HL443UC()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2., with color green on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
- ⑫ ⑧ HL443PY()-() = Passivate per AMS2700, Method 1, Type 8, Class 1
- ⑫ HL443PZ()-() = Passivate per AMS2700, Method 1, Type 8, Class 1 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 of the pin which HL443 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER

EXAMPLE: Pin Part Number
HL443AP8-8

8/16 or 1/2 Maximum Grip Length
8/32 or 1/4 Nominal Diameter Pin
Finish Code
Pin Basic Part Number