



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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
											W HEX	T DEPTH	Y DIA		
5	3/16			NOTE: Use HL54-6											
6	13/64	.315 .295	.325	.2026 .2016	.1840 .1810	.025	.055 .045	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	8,100	3,000
8	17/64	.412 .387	.395	.2651 .2641	.2440 .2410	.030	.069 .059	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	13,800	5,100
10	21/64	.505 .475	.500	.3276 .3266	.3060 .3020	.035	.078 .068	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	21,100	8,000
12	25/64	.600 .565	.545	.3901 .3891	.3680 .3640	.040	.088 .078	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	30,000	11,300
14	29/64	.676 .641	.635	.4526 .4516	.4310 .4260	.045	.105 .093	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	40,300	15,500
16	33/64	.770 .735	.685	.5151 .5141	.4930 .4880	.050	.115 .103	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	52,200	20,000

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

GENERAL NOTES:

1. Concentricity: "A" to "D" diameter within .010 FIR.
2. Dimensions are in inches and to be met after finish.
3. Non-lubed pins must be used with wet sealant or with lubed collars.
4. Surface texture per ASME B46.1.
5. Hole preparation per NAS618.
6. Use HL458 for oversize replacement.

CODE:

First dash number indicates nominal diameter in 1/32nds of the pin which HL52 oversize pin replace.
Second dash number indicates maximum grip in 1/16ths.
See Finish note for explanation of code letters.

HOW TO ORDER

EXAMPLE:

Pin Part Number
HL52BJ-8-8
└─ 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
HL5279-8-8
└─ Size and Grip Length, See Above Example
└─ Collar Part Number
└─ Pin Part Number

MATERIAL: (17) Type 431 stainless steel per AMS5628.

HEAT TREAT: 125,000 psi shear minimum.

- FINISH: (17) HL52-()-() = Cadmium plate per Spec. AMS-QQ-P-416, Type II, Class 2 and cetyl alcohol lube per Hi-Shear Spec. 305.
- (17) HL52BJ-()-() = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
- (17) HL52KR-()-() = Cadmium plate per Spec. AMS-QQ-P-416, Type II, Class 2 with red identification on top of head, and cetyl alcohol lube per Hi-Shear Spec. 305.
- 3 (17) HL52PN-()-() = Cadmium plate per Spec. AMS-QQ-P-416, Type II, Class 2.

SPECIFICATION: HI-LOK™ Product Specification 342.

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

DRAWN BY DMB	DATE 1962-08-02	TITLE HI-LOK™ PIN PROTRUDING SHEAR HEAD 431 STAINLESS STEEL 1/16 GRIP VARIATION, 1/64 OVERSIZE	
APPROVED CESSNA	DATE 1962-08-02	DRAWING NUMBER HL52	
REVISION (17)	DATE K. TRAN 2017-11-06	1 OF 1	