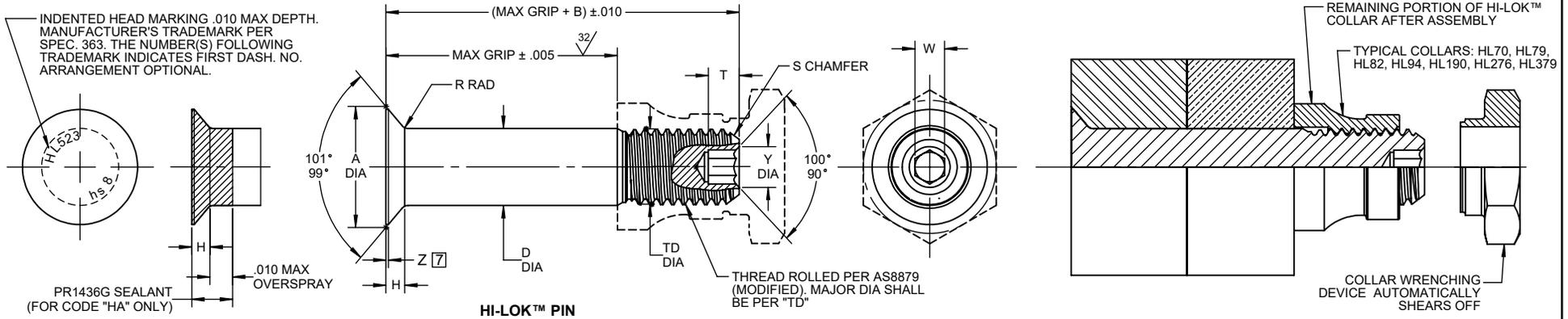


For the current list of licensed manufacturers, please visit the
 LISI AEROSPACE website at:

[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 REF	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING OR SOLID FILM	AFTER COATING OR SOLID FILM								W HEX	T DEPTH	Y DIA		
5	5/32	.2922 .2874	.312	.1635 .1630	.1635 .1625	.1595 .1570	.004	.0540 .0520	.025 .015	.010	1/32 x 37°	.1640-32 UNJC-3A	.0645 .0635	.135 .115	.090 .075	4,010	1,730
6	3/16	.3536 .3486	.325	.1895 .1890	.1895 .1885	.1840 .1810	.005	.0688 .0667	.030 .020	.015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	5,380	2,590
7	7/32	.4452 .4378	.355	.2182 .2177	.2182 .2172	.2100 .2070	.005	.0940 .0920	.030 .020	.015	1/32 x 37°	.2160-28 UNJF-3A	.0806 .0791	.135 .115	.119 .104	8,160	3,580
8	1/4	.4732 .4682	.395	.2495 .2490	.2495 .2485	.2440 .2410	.006	.0939 .0918	.030 .020	.015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	9,300	4,760
10	5/16	.5619 .5569	.500	.3120 .3115	.3120 .3110	.3060 .3020	.007	.1048 .1027	.040 .030	.015	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	14,600	7,100
12	3/8	.6912 .6862	.545	.3745 .3740	.3745 .3735	.3680 .3640	.008	.1329 .1308	.040 .030	.015	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	21,000	10,600
14	7/16	.8041 .7969	.635	.4370 .4365	.4370 .4360	.4310 .4260	.009	.1540 .1510	.050 .040	.022	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	28,600	14,450
16	1/2	.9166 .9095	.685	.4995 .4990	.4995 .4985	.4930 .4880	.010	.1750 .1720	.050 .040	.022	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	37,300	19,550
18	9/16	1.0337 1.0286	.770	.5615 .5610	.5615 .5605	.5550 .5500	.010	.1981 .1951	.050 .040	.025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	47,200	24,700
20	5/8	1.1230 1.1158	.825	.6240 .6235	.6240 .6230	.6180 .6120	.010	.2094 .2064	.050 .040	.025	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	58,300	29,600
24	3/4	1.3500 1.3428	1.050	.7490 .7485	.7490 .7480	.7430 .7370	.012	.2521 .2491	.050 .040	.025	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	83,900	42,900

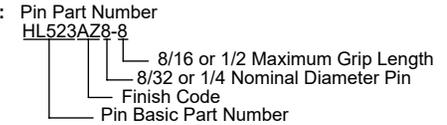
"HI-LOK", "HL", AND "HI-KOTE" ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY DATE		TITLE	
J. F. OBISPO	2015-01-06	HI-LOK™ PIN	
SHRODE 1967-05-17		100° FLUSH MS20426 HEAD	
APPROVED DATE		TITANIUM	
J. MILLER	1967-05-17	1/16 GRIP VARIATION	
REVISION DATE		DRAWING NUMBER	
16	C. ARTOS 2024-4-10	HL523	

- ⑩ **GENERAL NOTES:**
- 1 Head edge out of roundness shall not exceed "F".
 2. Concentricity: Conical surface of head to "D" diameter within .003 FIM.
 3. Dimensions are in inches and to be met after finish.
 4. Surface texture per ASME B46.1.
 5. Hole preparation per NAS618.
 6. "H" is dimensioned from maximum "D" diameter.
 - 7 Curved or flat edge manufacturer's option.
 - 8 Maximum "D" diameter may be increased by .0002 to allow for aluminum coating or solid film application.
 9. Use HL537 for oversize replacement.

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:



MATERIAL: 6AL-4V titanium alloy per AMS4928 or AMS4967.

HEAT TREAT: 95,000 psi shear minimum.

- FINISH:**
- HL523(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
 - 10 HL523AD(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305. Top of head shall be painted in accordance with BAC5684, Type I. No overspray is allowed except in the "Z" land area.
 - 10 HL523AP(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 10 HL523AZ(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 10 HL523EF(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on top of head only (.005 max overspray on the head bearing surface permissible) with color blue on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 10 HL523GM(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads (no overspray on the shank allowed) and top of head only (.005 max overspray on the head bearing surface permissible) with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 10 HL523HA(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color black on thread end, and apply Precoat No. PR1436G sealant (.002-.005 thick), and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL523RA(-)(-) = Phosphate fluoride treat with color red on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL523SY(-)(-) = Phosphate fluoride treat, solid film lube per AS5272, Type I, and color red on the thread end.
 - HL523NKJ(-)(-) = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color silver on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL523NKK(-)(-) = Sulfuric acid anodizing per ISO8080 and HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only, with color silver on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL523NKL(-)(-) = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only, with color silver on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LOK™ Product Specification 342.

HL523

DRAWING NUMBER

HL523

2 OF 2