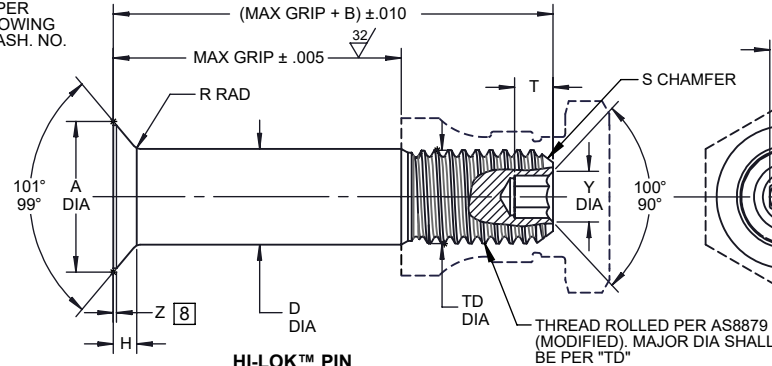
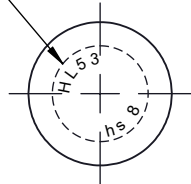


INDENTED HEAD MARKING .010 MAX DEPTH.
MANUFACTURER'S TRADEMARK PER
SPEC. 363. THE NUMBER(S) FOLLOWING
TRADEMARK INDICATES FIRST DASH. NO.
ARRANGEMENT OPTIONAL. (18)

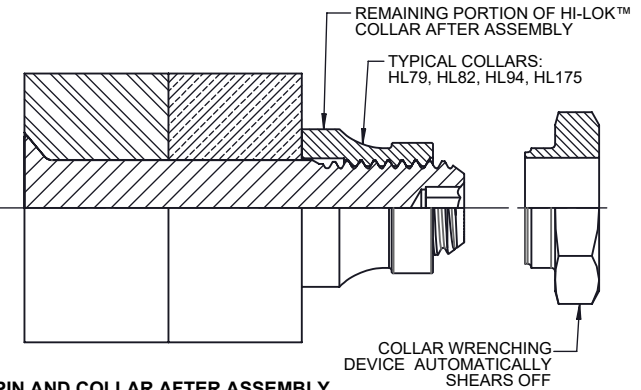


HI-LOK™ PIN

[1]

[8]

HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY



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
												W HEX	T DEPTH	Y DIA		
5	3/16					NOTE: Use HL61-6										
6	13/64	.3016 2966	.325	.2026 2016	.1840 1810	.005	.0415 .0394	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	8,100	2,600
8	17/64	.3948 3898	.395	.2651 2641	.2440 2410	.006	.0544 .0523	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	13,800	4,400
10	21/64	.4739 4689	.500	.3276 3266	.3060 3020	.007	.0614 .0593	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	21,100	7,000
12	25/64	.5604 5554	.545	.3901 3891	.3680 3640	.008	.0714 .0694	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	30,000	9,500
14	29/64	.6680 6620	.635	.4526 4516	.4310 4260	.009	.0904 .0879	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	40,300	13,500
16	33/64	.7540 7480	.685	.5151 5141	.4930 4880	.010	.1002 .0977	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	52,200	18,000

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

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .005 FIM.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions are in inches and to be met after finish.
 - Non-lubed pin must be used with wet sealant or with lubed collars.
 - Surface texture per ASME B46.1.
 - Hole preparation per NAS618.
 - Curved or flat edge manufacturer's option.
 - Use HL459 for oversize replacement.

MATERIAL: (18) Type 431 stainless steel per AMS5628.

HEAT TREAT: 125,000 psi shear minimum.

- FINISH:**
- HL53(-)(-) = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL53BJ(-)(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL53KR(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and with red identification on top of head, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - (5) HL53PN(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.

SPECIFICATION: HI-LOK™ Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL53 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
HL53BJ8-8
└─ 8/16 or 1/2 Maximum Grip Length
└─ Replaces 8/32 or 1/4 Nominal Diameter Pin
└─ Finish Code
└─ Pin Basic Part Number

Pin and Collar Assembly Part Number Combination
HL5379-8-8
└─ Size and Grip Length, See Above Example
└─ Collar Part Number
└─ Pin Part Number

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

DRAWN BY DMB	DATE 1962-08-02	(18)	TITLE HI-LOK™ PIN 100° FLUSH SHEAR HEAD TYPE 431 STAINLESS 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED CESSNA	DATE 1962-08-02		
REVISION (18)	DATE B.CHAN 2021-07-01	DRAWING NUMBER HL53 1 OF 1	