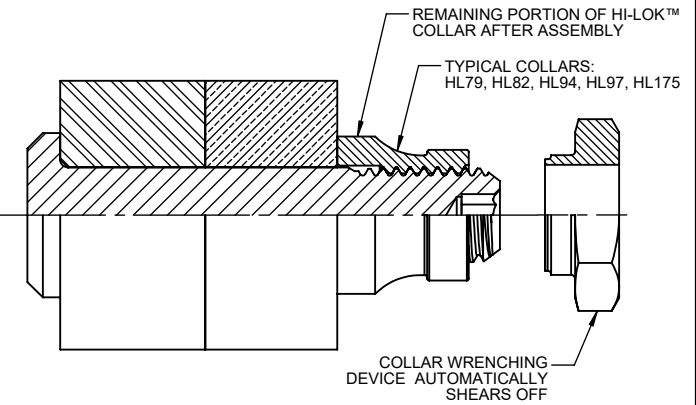


HI-LOK™ PIN



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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	5/32	.262 .242	.312	.1635 .1625	.1595 .1570	.020	.047 .037	.025 .015	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.135 .115	[7]	5,280	2,200
6	3/16	.315 .295	.325	.1895 .1885	.1840 .1810	.025	.055 .045	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	7,060	3,000
8	1/4	.412 .387	.395	.2495 .2485	.2440 .2410	.030	.069 .059	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	12,260	5,100
10	5/16	.505 .475	.500	.3120 .3110	.3060 .3020	.035	.078 .068	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	19,160	8,000
12	3/8	.600 .565	.545	.3745 .3735	.3680 .3640	.040	.088 .078	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	27,600	11,300
14	7/16	.676 .641	.635	.4370 .4360	.4310 .4260	.045	.105 .093	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	37,500	15,500
16	1/2	.770 .735	.685	.4995 .4985	.4930 .4880	.050	.115 .103	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	49,100	20,000
18	9/16	.864 .829	.770	.5615 .5605	.5550 .5500	.055	.127 .112	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	62,100	25,000
20	5/8	.953 .918	.825	.6240 .6230	.6180 .6120	.060	.137 .122	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	76,700	30,200

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIR.
 2. Dimensions are in inches and to be met after plating.
 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 HL52 for oversize replacement.
- [7] Evidence of broken edge across points.

MATERIAL: Type 431 stainless steel per AMS5628.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: HL54-()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

[23] HL54KR()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, red identification on top of head, and cetyl alcohol lube per Hi-Shear Spec. 305.

[23] HL54PN()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2. (See note 3.)

SPECIFICATION: HI-LOK™ Product Spec. 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.

**HOW TO ORDER
 EXAMPLE:**

Pin Part Number
 HL54PN-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
 HL6479-8-8

Size and Grip Length, See Above Example
 Collar Part Number
 Pin Part Number

* * The Double Shear Values shown are based on cross sectional area for nominal diameter pin.

"HI-LOK", "HL", AND "HI-KOTE" ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY R.K.L.	DATE 1961-06-30	TITLE HI-LOK™ PIN PROTRUDING SHEAR HEAD TYPE 431 STAINLESS STEEL 1/16 GRIP VARIATION CADMIUM PLATED	
APPROVED M.E.C.	DATE 1961-06-30		
REVISION [23]	DATE A.CHAE 2020-09-15	DRAWING NUMBER HL54	