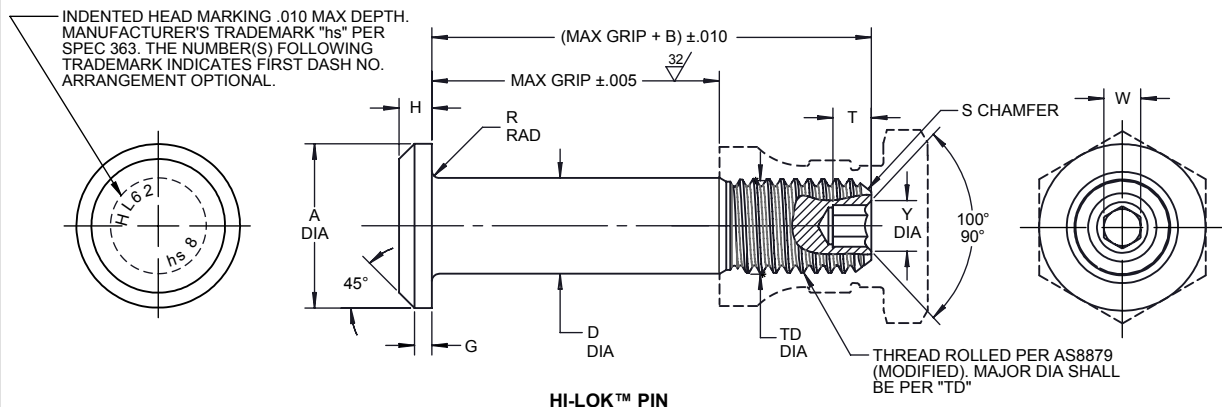
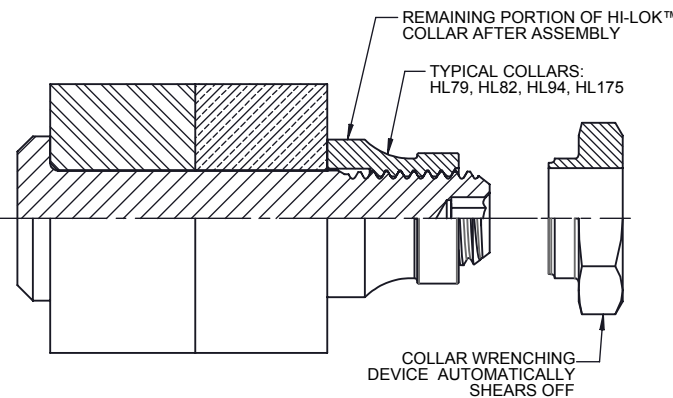




HI-LOK™ PIN



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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

| FIRST<br>DASH<br>NO. | PIN<br>NOM<br>DIA | A<br>DIA       | B<br>REF | D<br>DIA         | TD<br>DIA                             | G<br>REF | H            | R<br>RAD     | S<br>CHAMFER<br>REF | THREAD<br>MODIFIED   | SOCKET         |              |              | DOUBLE<br>SHEAR<br>POUNDS<br>MINIMUM | TENSION<br>POUNDS<br>MINIMUM |
|----------------------|-------------------|----------------|----------|------------------|---------------------------------------|----------|--------------|--------------|---------------------|----------------------|----------------|--------------|--------------|--------------------------------------|------------------------------|
|                      |                   |                |          |                  |                                       |          |              |              |                     |                      | W<br>HEX       | T<br>DEPTH   | Y<br>DIA     |                                      |                              |
| 5                    |                   |                |          |                  | NOTE: USE HL18-6- ( ) or HL418-6- ( ) |          |              |              |                     |                      |                |              |              |                                      |                              |
| 6                    | 13/64             | .315<br>295    | .325     | .2026<br>2016    | .1840<br>1810                         | .025     | .055<br>.045 | .025<br>.015 | 1/32 x 45°          | .1900-32<br>UNJF-3A  | .0806<br>0791  | .135<br>.115 | .119<br>.104 | 6,130                                | 2,500                        |
| 8                    | 17/64             | .412<br>387    | .395     | .2651<br>2641    | .2440<br>2410                         | .030     | .069<br>.059 | .025<br>.015 | 1/32 x 45°          | .2500-28<br>UNJF-3A  | .0967<br>0947  | .150<br>.130 | .142<br>.122 | 10,490                               | 4,300                        |
| 10                   | 21/64             | .505<br>475    | .500     | .3276<br>3266    | .3060<br>3020                         | .035     | .078<br>.068 | .030<br>.020 | 3/64 x 45°          | .3125-24<br>UNJF-3A  | .1295<br>.1270 | .170<br>.150 | .180<br>.160 | 16,000                               | 6,300                        |
| 12                   | 25/64             | .600<br>565    | .545     | .3901<br>3891    | .3680<br>3640                         | .040     | .088<br>.078 | .030<br>.020 | 3/64 x 45°          | .3750-24<br>UNJF-3A  | .1617<br>.1582 | .200<br>.180 | .217<br>.197 | 22,700                               | 8,700                        |
| 14                   | 29/64             | .676<br>641    | .635     | .4526<br>4516    | .4310<br>4260                         | .045     | .105<br>.093 | .030<br>.020 | 3/64 x 45°          | .4375-20<br>UNJF-3A  | .1930<br>.1895 | .230<br>.210 | .253<br>.233 | 30,600                               | 12,100                       |
| 16                   | 33/64             | .770<br>735    | .685     | .5151<br>5141    | .4930<br>4880                         | .050     | .115<br>.103 | .030<br>.020 | 3/64 x 45°          | .5000-20<br>UNJF-3A  | .2242<br>2207  | .260<br>.240 | .289<br>269  | 39,600                               | 15,300                       |
| 18                   | 37/64             | .864<br>829    | .770     | .5771<br>5761    | .5550<br>5500                         | .055     | .127<br>.112 | .040<br>.025 | 1/16 x 45°          | .5625-18<br>UNJF-3A  | .2555<br>2520  | .290<br>.270 | .326<br>.306 | 49,700                               | 19,000                       |
| 20                   | 41/64             | .953<br>918    | .825     | .6396<br>6386    | .6180<br>6120                         | .060     | .137<br>.122 | .040<br>.025 | 1/16 x 45°          | .6250-18<br>UNJF-3A  | .2555<br>2520  | .330<br>.305 | .326<br>.306 | 61,000                               | 23,000                       |
| 24                   | 49/64             | 1.108<br>1.066 | 1.050    | .7646<br>7636    | .7430<br>7370                         | .070     | .151<br>.136 | .045<br>.030 | 1/16 x 45°          | .7500-16<br>UNJF-3A  | .3185<br>.3150 | .395<br>.365 | .398<br>.378 | 87,200                               | 30,700                       |
| 28                   | 57/64             | 1.285<br>1.241 | 1.210    | .8896<br>8886    | .8680<br>8610                         | .090     | .187<br>.172 | .050<br>.035 | 5/64 x 45°          | .8750-14<br>UNJF-3A  | .3820<br>3780  | .455<br>.425 | .471<br>.451 | 118,000                              | 45,000                       |
| 32                   | 1-1/64            | 1.468<br>1.424 | 1.390    | 1.0146<br>1.0136 | .9930<br>9860                         | .110     | .218<br>203  | .060<br>.045 | 5/64 x 45°          | 1.0000-12<br>UNJF-3A | .5100<br>5040  | .580<br>.550 | .618<br>.598 | 154,000                              | 60,900                       |

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

|                    |                                     |                                                                                                    |
|--------------------|-------------------------------------|----------------------------------------------------------------------------------------------------|
| DRAWN BY<br>BRIEJ  | DATE<br>1963-05-02                  | TITLE<br>HI-LOK™ PIN<br>PROTRUDING SHEAR HEAD<br>ALLOY STEEL<br>1/16 GRIP VARIATION, 1/64 OVERSIZE |
| APPROVED<br>CESSNA | DATE<br>1963-11-01                  |                                                                                                    |
| REVISION<br>(21)   | DATE<br>F. CARINGELLA<br>2018-10-30 | DRAWING NUMBER<br><b>HL62</b>                                                                      |

**GENERAL NOTES:**

1. Concentricity: "A" to "D" diameter within .010 FIM.
2. Dimensions are in inches and to be met after finish.
3. Surface texture per ASME B46.1.
4. Hole preparation per NAS618.
5. Use HL218 for oversize replacement.

**MATERIAL:** Alloy steel per AMS6415, AMS6349 or AMS6382, AMS6322.

**HEAT TREAT:** 95,000 psi shear (160,000 - 180,000 psi tensile per AMS-H-6875).

**② FINISH:**

- HL62-( )-( ) = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL62A( )-( ) = Cadmium plate per AMS2400-3, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL62PB( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL62TF( )-( ) = Cadmium plate per AMS-QQ-P-416, Type III, Class 2, and HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.

**SPECIFICATION:** HI-LOK™ Product Specification 342.

**CODE:** First dash number indicates nominal diameter in 1/32nds which HL62 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  
 HL62PB8-8

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

HL62

DRAWING NUMBER

**HL62**

2 OF 2