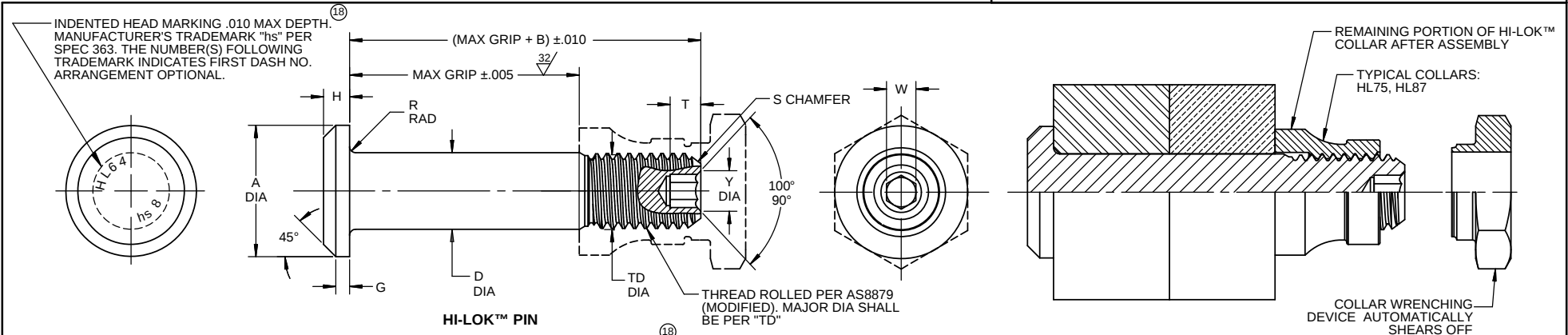




HI-LOK™ PIN

HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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

FIRST 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							NOTE: USE HL20-6-() or HL420-6-()								
6	13/64	.377 .357	.325	.2026 .2016	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	6,130	3,180
8	17/64	.440 .415	.395	.2651 .2641	.2440 .2410	.045	.090 .077	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	10,490	5,820
10	21/64	.502 .472	.500	.3276 .3266	.3060 .3020	.055	.112 .098	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	16,000	9,200
12	25/64	.565 .530	.545	.3901 .3891	.3680 .3640	.065	.140 .130	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	22,700	14,000
14	29/64	.627 .592	.635	.4526 .4516	.4310 .4260	.075	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	30,600	18,900
16	33/64	.752 .717	.685	.5151 .5141	.4930 .4880	.085	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	39,600	25,600
18	37/64	.877 .842	.770	.5771 .5761	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	49,700	32,400
20	41/64	.953 .918	.825	.6396 .6386	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	61,000	41,000
24	49/64	1.150 1.110	1.050	.7646 .7636	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	87,200	59,500

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 2. Dimensions are in inches and to be met after plating.
 3. Surface texture per ASME B46.1.
 4. Hole preparation per NAS618.
 5. Non-lubed pins must be used with sealant or lubed collars.
 6. Removed.
 7. Use HL220 for oversize replacement.

CODE: First dash number indicates nominal diameter in 1/32nds which HL64 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
HL64PB8-8
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
HL64PB86-8-8
Size and Grip Length,
See Above Example
Collar Part Number
Pin Finish
Pin Basic Part Number

MATERIAL: Alloy steel per AMS6415, AMS6349, AMS6322, AMS6327 or AMS6325.

HEAT TREAT: 160,000 - 180,000 psi tensile per AMS-H-6875.

FINISH: HL64-()-() = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL64A()-() = Cadmium plate per AMS2400-3 and cetyl alcohol lube per Hi-Shear Spec. 305.
HL64PB()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
5 HL64PN()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
HL64RB()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, color violet to purple, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LOK™ Product Specification 342.

"HI-LOK", "HL", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY BRIEJ	DATE 1964-07-29	TITLE HI-LOK™ PIN PROTRUDING TENSION HEAD ALLOY STEEL 1/16 GRIP VARIATION, 1/64 OVERSIZE	
APPROVED CESSNA	DATE 1964-07-30	DRAWING NUMBER HL64	
REVISION 18	DATE M.BEARD 2017-09-27	1 OF 1	