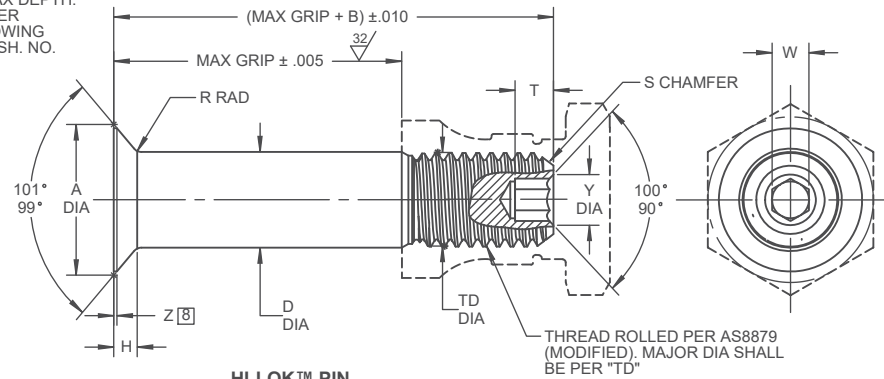
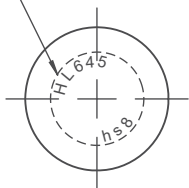
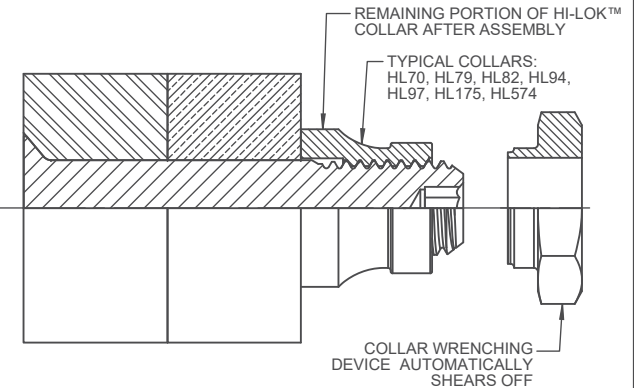


INDENTED HEAD MARKING .010 MAX DEPTH.
 MANUFACTURER'S TRADEMARK PER
 SPEC. 363. THE NUMBER(S) FOLLOWING
 TRADEMARK INDICATES FIRST DASH. NO.
 ARRANGEMENT OPTIONAL. (16)



HI-LOK™ PIN



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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	.2612 .2564	.312	.1635 .1630	.1635 .1625	.1595 .1570	.004	.0410 .0390	.025 .015	.010	1/32 x 45°	.1640-32 UNJC-3A	.0645 .0635	.135 .115	.090 .075	5,280	1,700
6	3/16	.3016 .2966	.325	.1895 .1890	.1895 .1885	.1840 .1810	.005	.0470 .0450	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	7,060	2,600
8	1/4	.3948 .3898	.395	.2495 .2490	.2495 .2485	.2440 .2410	.006	.0610 .0590	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	12,260	4,400
10	5/16	.4739 .4689	.500	.3120 .3115	.3120 .3110	.3060 .3020	.007	.0680 .0660	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	19,160	7,000
12	3/8	.5604 .5554	.545	.3745 .3740	.3745 .3735	.3680 .3640	.008	.0780 .0760	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	27,600	10,000
14	7/16	.6680 .6620	.635	.4370 .4365	.4370 .4360	.4310 .4260	.009	.0969 .0944	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	37,500	12,500
16	1/2	.7540 .7480	.685	.4995 .4990	.4995 .4985	.4930 .4880	.010	.1068 .1043	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	49,100	18,000
18	9/16	.8380 .8310	.770	.5615 .5610	.5615 .5605	.5550 .5500	.010	.1160 .1131	.050 .040	.022	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	62,100	22,500
20	5/8	.9250 .9180	.825	.6240 .6235	.6240 .6230	.6180 .6120	.010	.1260 .1230	.050 .040	.022	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	76,700	28,000
24	3/4	1.0970 1.0850	1.050	.7490 .7485	.7490 .7480	.7430 .7370	.012	.1460 .1410	.050 .040	.022	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	110,400	40,200
28	7/8	1.3197 1.3030	1.210	.8740 .8735	.8740 .8730	.8680 .8610	.014	.1870 .1800	.050 .040	.022	5/64 x 45°	.8750-14 UNJF-3A	.3820 .3780	.400 .370	.471 .451	150,300	54,000
32	1	1.5186 1.4995	1.390	.9990 .9985	.9990 .9980	.9930 .9860	.014	.2180 .2100	.050 .040	.022	5/64 x 45°	1.0000-12 UNJF-3A	.5100 .5040	.520 .490	.618 .598	196,300	72,000

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

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

DRAWN BY VAN	DATE 1969-12-20	TITLE HI-LOK™ PIN 100° FLUSH SHEAR HEAD PH13-8Mo STAINLESS STEEL 1/16 GRIP VARIATION
APPROVED J.M.	DATE 1969-12-23	
REVISION (16)	DATE K. MURKER 2020-02-18	DRAWING NUMBER HL645

- 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 Maximum "D" diameter may be increased by .0002 to allow for solid film or aluminum coating application.
 - 8 Curved or flat edge manufacturer's option.
 - 9. Use HL751 for oversize replacement.
 - 10 After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

MATERIAL: PH13-8Mo stainless steel per Spec. AMS5629.

HEAT TREAT: 125,000 psi shear minimum.

- FINISH:**
- HL645-()-() = Solid film lube per AS5272, Type I.
 - 10 HL645AP()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL645LL()-() = Passivate per Hi-Shear Spec. 262 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL645TB()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL645YE()-() = Passivate per Hi-Shear Spec. 262, white paint on head, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL645HK()-() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

SPECIFICATION: HI-LOK™ Product Specification 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
 HL645AP8-8

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

HL645

DRAWING NUMBER

HL645

2 OF 2