

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	.3304 .3256	.312	.1635 .1630	.1635 .1625	.1595 .1570	.004	.0700 .0680	.025 .015	.010	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.100 .080	[8]	5,280	2,940
6	3/16	.3813 .3765	.325	.1895 .1890	.1895 .1885	.1840 .1810	.005	.0805 .0785	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	7,060	4,350
8	1/4	.5066 .5018	.395	.2495 .2490	.2495 .2485	.2440 .2410	.006	.1080 .1060	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	12,260	7,750
10	5/16	.6335 .6287	.500	.3120 .3115	.3120 .3110	.3060 .3020	.007	.1350 .1330	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	19,160	12,300
12	3/8	.7604 .7556	.545	.3745 .3740	.3745 .3735	.3680 .3640	.008	.1620 .1600	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	27,600	19,100
14	7/16	.8884 .8812	.635	.4370 .4365	.4370 .4360	.4310 .4260	.009	.1895 .1865	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	37,500	25,800
16	1/2	1.0139 1.0068	.685	.4995 .4990	.4995 .4985	.4930 .4880	.010	.2160 .2130	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	49,100	34,300
18	9/16	1.1408 1.1337	.770	.5615 .5610	.5615 .5605	.5550 .5500	.010	.2430 .2400	.050 .040	.025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	62,100	43,500
20	5/8	1.2723 1.2651	.825	.6240 .6235	.6240 .6230	.6180 .6120	.010	.2720 .2690	.050 .040	.025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	76,700	54,600
24	3/4	1.5308 1.5236	1.050	.7490 .7485	.7490 .7480	.7430 .7370	.012	.3280 .3250	.050 .040	.025	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	110,400	79,200
28	7/8	1.7845 1.7773	1.210	.8740 .8735	.8740 .8730	.8680 .8610	.014	.3820 .3790	.050 .040	.025	5/64 x 45°	.8750-14 UNJF-3A	.3820 .3780	.400 .370	.471 .451	150,300	117,000
32	1	2.0405 2.0310	1.390	.9990 .9985	.9990 .9980	.9930 .9860	.014	.4370 .4330	.050 .040	.025	5/64 x 45°	1.0000-12 UNJF-3A	.5100 .5040	.520 .490	.618 .598	196,300	143,000

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 J.F.OBISPO		DATE 2015-04-01		TITLE HI-LOK™ PIN 100° FLUSH MS24694 TENSION HEAD PH13-8Mo STAINLESS STEEL 1/16 GRIP VARIATION	
VAN		1969-12-22			
APPROVED J.M.		DATE 1969-12-23		DRAWING NUMBER HL647 1 OF 2	
REVISION 15		DATE F.CARINGELLA 2017-05-23			

- GENERAL NOTES:**
- 1 Head edge out of roundness shall not exceed "F".
 - 2 Concentricity: Conical surface of head to "D" diameter within .005 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 Evidence of broken edge across points.
 - 9 Curved or flat edge manufacturer's option.
 - 10 Use HL753 for oversize replacement.
 - 11 After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating 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 AMS5629.

HEAT TREAT: 125,000 psi shear minimum.

FINISH:

HL647-()-()	= Solid film lube per AS5272, Type I.
11 HL647AP()-()	= HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL647LL()-()	= Passivate per Hi-Shear Spec. 262 and cetyl alcohol lube per Hi-Shear Spec. 305.
HL647PB()-()	= Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL647TB()-()	= HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL647HK()-()	= HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

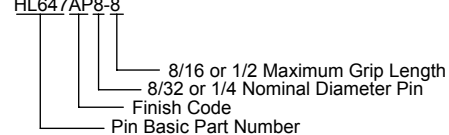
SPECIFICATION: HI-LOK™ Product Specification 342.

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
 HL647AP8-8



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

HL647

DRAWING NUMBER

HL647

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