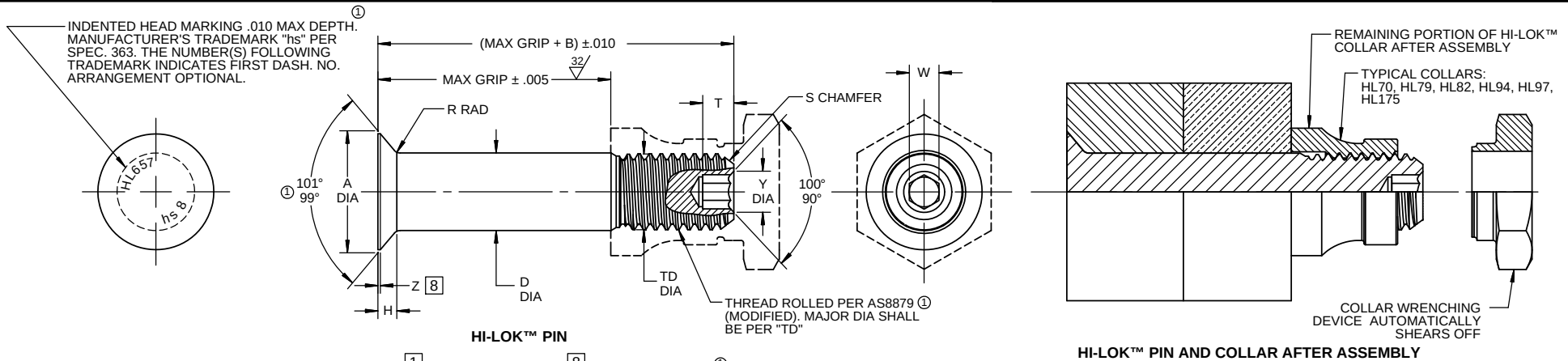


①

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FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
												W HEX	T DEPTH	Y DIA		
5	5/32	.2612 .2564	.312	.1635 .1630	.1595 .1570	.004	.0410 .0390	.025 .015	.015	1/32 x 45°	.1640-32 UNJF-3A	.0801 .0791	.100 .080	[5]	4,560	1,750
6	3/16	.3016 .2966	.325	.1895 .1890	.1840 .1810	.005	.0470 .0450	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	6,125	2,340
8	1/4	.3948 .3898	.395	.2495 .2490	.2440 .2410	.006	.0610 .0590	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	10,600	4,200
10	5/16	.4739 .4689	.500	.3120 .3115	.3060 .3020	.007	.0680 .0660	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	16,600	6,500
12	3/8	.5604 .5554	.545	.3745 .3740	.3680 .3640	.008	.0780 .0760	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	23,900	9,230
14	7/16	.6680 .6620	.635	.4370 .4365	.4310 .4260	.009	.0969 .0944	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	32,500	13,200
16	1/2	.7540 .7480	.685	.4995 .4990	.4930 .4880	.010	.1068 .1043	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	42,400	16,800

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

- GENERAL NOTES:**
- ① Head edge out of roundness shall not exceed "F".
 2. Concentricity: Conical surface of head to "D" diameter within .005 FIR.
 3. "H" dimensioned from maximum "D" diameter.
 - ④ 4. Dimensions are in inches and to be met after finish.
 - ⑤ 5. Evidence of broken edge across points.
 - ⑥ 6. Surface texture per ASME B46.1.
 7. Hole preparation per NAS618.
 - ⑧ 8. Curved or flat edge manufacturer's option.

MATERIAL: Nickel base alloy per AMS5662.

HEAT TREAT: 108,000 psi shear minimum (180,000 psi tensile minimum).

FINISH: HL657-()-() = Passivate per Hi-Shear Spec. 258, and cetyl alcohol lube per Hi-Shear Spec. 305.

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.

HOW TO ORDER

① **EXAMPLE:** Pin Part Number
HL657-8-8

HL657-8-8
8/16 or 1/2 Maximum Grip Length
8/32 or 1/4 Nominal Diameter Pin
Pin Basic Part Number

Pin and Collar Assembly Part Number Combination
HL65794-8-8

HL65794-8-8
Size and Grip Length, See Above Example
Collar Part Number
Pin Part Number

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

DRAWN BY D.P.S.	DATE 1982-03-30	TITLE HI-LOK™ PIN 100° FLUSH SHEAR HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16 GRIP VARIATION
APPROVED R.TING	DATE 1982-03-30	
REVISION ①	DATE M.BEARD 2017-12-04	DRAWING NUMBER HL657

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