



FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	F	H	R RAD	Z	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING OR SOLID FILM LUBE	WITH COATING OR SOLID FILM LUBE								W HEX	T DEPTH	Y DIA		
5	3/16						NOTE: USE HL31-6										
6	13/64	.3016 .2966	.325	.2026 .2021	.2026 .2016	.1840 .1810	.005	.0415 .0394	.030 .020	.015 .005	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	8,100	2,600
8	17/64	.3948 .3898	.395	.2651 .2646	.2651 .2641	.2440 .2410	.006	.0544 .0523	.030 .020	.015 .005	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	13,800	4,400
10	21/64	.4739 .4689	.500	.3276 .3271	.3276 .3266	.3060 .3020	.007	.0614 .0593	.040 .030	.015 .005	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	21,100	7,000
12	25/64	.5604 .5554	.545	.3901 .3896	.3901 .3891	.3680 .3640	.008	.0714 .0694	.040 .030	.015 .005	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	30,000	10,000
14	29/64	.6680 .6620	.635	.4526 .4521	.4526 .4516	.4310 .4260	.009	.0904 .0879	.050 .040	.022 .005	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	40,300	13,500
16	33/64	.7540 .7480	.685	.5151 .5146	.5151 .5141	.4930 .4880	.010	.1002 .0977	.050 .040	.022 .005	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	52,200	18,000

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

**GENERAL NOTES:**

- Head edge out of roundness shall not exceed "F".
- Concentricity: Conical surface of head to "D" diameter within .005 FIR.
- "H" is dimensioned from maximum "D" diameter.
- Dimensions are in inches and to be met after plating.
- Surface texture per ASME B46.1.
- Hole preparation per NAS618.
- Use HL59 for oversize replacement.
- 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:** ⑨ Type 431 stainless steel per AMS5628.

**HEAT TREAT:** 125,000 psi shear minimum.

**FINISH:** HL67-( )-( ) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.

⑨ [8] HL67AP( )-( ) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.

⑨ HL67BJ( )-( ) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.

⑨ HL67D-( )-( ) = Solid film lube per Spec. AS5272, Type I.

HL67K-( )-( ) = Solid film lube per "Lubeco" 905.

**CODE:**

First dash number indicates nominal diameter in 1/32nds of the pin which HL67 oversize pin replaces.  
 Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

**HOW TO ORDER**

⑨ **EXAMPLE:**

Pin Part Number  
 HL67AP8-8  
 L 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**

HL6779-8-8  
 L 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 R.K.L.	DATE 1960-07-20	TITLE HI-LOK™ PIN 100° FLUSH SHEAR HEAD TYPE 431 STAINLESS STEEL 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED M.M.C.	DATE 1960-07-25	
REVISION 9	DATE K. TRAN 2017-11-08	DRAWING NUMBER <b>HL67</b>