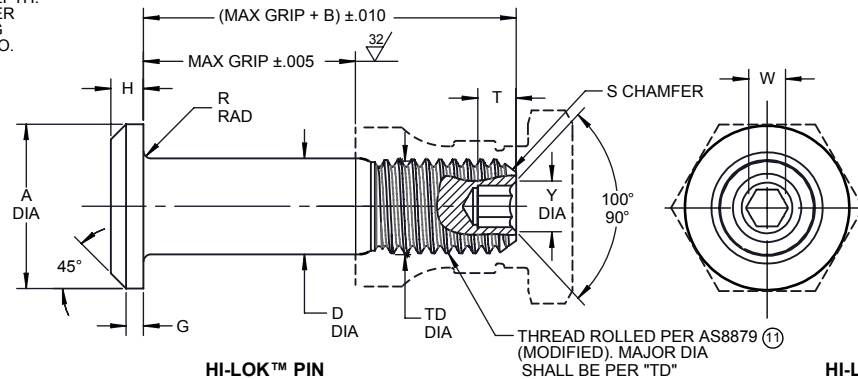
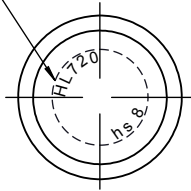
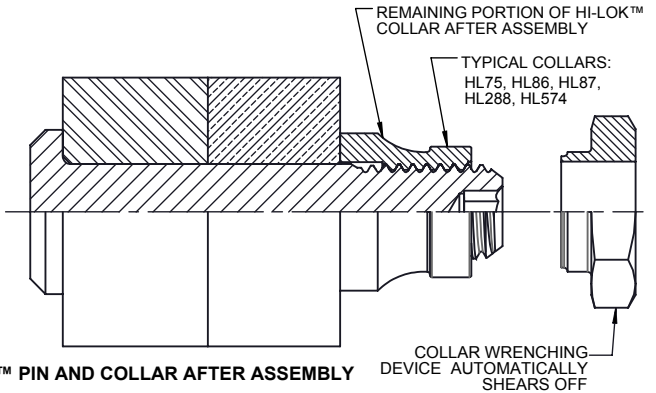


INDENTED HEAD MARKING .010 MAX DEPTH.
MANUFACTURER'S TRADEMARK "hs" PER
SPEC 363. THE NUMBER(S) FOLLOWING
TRADEMARK INDICATES FIRST DASH NO.
ARRANGEMENT OPTIONAL. (11)



HI-LOK™ PIN



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

COLLAR WRENCHING-
DEVICE AUTOMATICALLY
SHEARS OFF

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	5/32	.322 .306	.312	.1635 .1625	.1595 .1570	.030	.060 .055	.025 .015	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.135 .115	(6)	4,560	2,450
6	3/16	.377 .357	.325	.1895 .1885	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	6,125	3,850
8	1/4	.440 .415	.395	.2495 .2485	.2440 .2410	.045	.090 .077	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	10,600	6,550
10	5/16	.505 .475	.500	.3120 .3110	.3060 .3020	.055	.112 .098	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	16,600	10,350
12	3/8	.600 .530	.545	.3745 .3735	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	23,900	15,750
14	7/16	.676 .592	.635	.4370 .4360	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	32,500	21,200
16	1/2	.770 .717	.685	.4995 .4985	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	42,400	28,800
18	9/16	.877 .842	.770	.5615 .5605	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 45°	.5625-1 UNJF-3A	.2555 .2520	.290 .270	.326 .306	53,700	36,400
20	5/8	.953 .905	.825	.6240 .6230	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	66,300	46,100
24	3/4	1.150 1.110	1.050	.7490 .7480	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	95,400	66,900

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

GENERAL NOTES:

- Concentricity: "A" to "D" diameter within .010 FIR.
- Dimensions are in inches and to be met after finish.
- Non-lubed pins must be used with wet sealant or with lubed collars.
- Surface texture per ASME B46.1.
- Hole preparation per NAS618.
- Evidence of broken edge across points.
- Use HL764 for oversize replacement.
- Maximum "D" diameter may be increased by .0002 to allow for plating or coating application.

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

(11) EXAMPLE:

Pin Part Number
HL720BJ-8-8
└─ 8/16 or 1/2 Maximum Grip Length
└─ 8/32 or 1/4 Nominal Diameter Pin
└─ Finish Code
└─ Pin Basic Part Number

Pin and Collar Assembly Part Number Combination
HL72086-8-8

└─ 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 BRLEJ	DATE 1965-02-17	TITLE HI-LOK™ PIN PROTRUDING TENSION HEAD ALLOY STEEL 1/16 GRIP VARIATION	
APPROVED CESSNA	DATE 1965-02-17		
REVISION (11)	DATE K. TRAN 2017-11-15	DRAWING NUMBER HL720	