



HI-LOK™ PIN

HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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

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							NOTE: USE HL645()6-()										
6	13/64	.3016 .2966	.325	.2026 .2021	.2026 .2016	.1840 .1810	.005	.0415 .0394	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	8,100	2,600
8	17/64	.3948 .3898	.395	.2651 .2646	.2651 .2641	.2440 .2410	.006	.0544 .0523	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	13,800	4,400
10	21/64	.4739 .4689	.500	.3276 .3271	.3276 .3266	.3060 .3020	.007	.0614 .0593	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	21,000	7,000
12	25/64	.5604 .5554	.545	.3901 .3896	.3901 .3891	.3680 .3640	.008	.0714 .0693	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	30,000	10,000
14	29/64	.6680 .6620	.635	.4526 .4521	.4526 .4516	.4310 .4260	.009	.0904 .0879	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	40,300	13,500
16	33/64	.7540 .7480	.685	.5151 .5146	.5151 .5141	.4930 .4880	.010	.1002 .0977	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	52,500	18,000
18	37/64	.8380 .8310	.770	.5771 .5766	.5771 .5761	.5550 .5500	.010	.1094 .1065	.050 .040	.022	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	65,600	22,500
20	41/64	.9250 .9180	.825	.6396 .6391	.6396 .6386	.6180 .6120	.010	.1197 .1168	.050 .040	.022	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	80,600	28,000
24	49/64	1.0970 1.0850	1.050	.7646 .7641	.7646 .7636	.7430 .7370	.012	.1394 .1344	.050 .040	.022	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	115,000	40,200
28	57/64	1.3197 1.3030	1.210	.8896 .8891	.8896 .8886	.8680 .8610	.014	.1804 .1734	.050 .040	.022	5/64 x 45°	.8750-14 UNJF-3A	.3820 .3780	.400 .370	.471 .451	156,000	54,000
32	1-1/64	1.5186 1.4995	1.390	1.0146 1.0141	1.0146 1.0136	.9930 .9860	.014	.2114 .2034	.050 .040	.022	5/64 x 45°	1.0000-12 UNJF-3A	.5100 .5040	.520 .490	.618 .598	202,000	72,000

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

DRAWN BY VAN	DATE 1970-11-18	TITLE HI-LOK™ PIN 100° FLUSH SHEAR HEAD PH 13-8Mo STAINLESS STEEL 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED R. TING	DATE 1971-11-19	
REVISION 4	DATE KEVIN TRAN 2017-06-21	DRAWING NUMBER HL751

- 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 "H" is dimensioned from maximum "D" diameter.
 - 4 Dimensions are in inches and to be met after finish.
 - 5 Surface texture per ASME B46.1.
 - 6 Hole preparation per NAS618.
 - 7 Maximum "D" diameter may be increased by .0002 to allow for solid film or application.
 - 8 Use HL851 for oversize replacement.
 - 9 Curved or flat edge manufacturer's option.

MATERIAL: PH13-8Mo stainless steel per AMS5629.

HEAT TREAT: 125,000 psi tensile minimum.

FINISH:

- HL751-()-() = Solid film lube per AS5272, Type I.
- HL751LL()-() = Passivate per Hi-Shear Spec. 262, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL751TB()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- 4 HL751HK()-() = 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 of the pin which HL751 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

HOW TO ORDER

4 **EXAMPLE:**

Pin Part Number
 HL751TB8-8

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